



STATE OF ALABAMA
DEPARTMENT OF AGRICULTURE AND INDUSTRIES
1445 Federal Drive • Montgomery, Alabama 36107-1123

John McMillan
Commissioner

Ready Mix plant Inspection

Pretest:

1. Device Registration must be current
2. Weigh Master certificate must be current
3. Devices in good repair with no obvious binds or other characteristics that will affect performance.
4. Adequate known test weights needed and support mechanisms such as chains and single trees.
5. Equipment connected to scales and NTEP approved elements.

Test Load:

Determine what test load (amount of known test weights) will be used to test scale. This can be found in NIST HB-44 (table 4 page 2-33) under minimum test load. Other things to consider are how weights are to be supported. The use of chains, lifting hoists, and single trees is commonly how test weights are applied. Keep test load as close to the center of hopper to prevent false readings due to side loading. Safety should be considered when making decisions to apply weights as well. If a scale has not been adequately tested before, corrections should be made to ensure adequate test loads can be applied. Any modifications to catwalks, hooks added, or changes needed should be discussed and coordinated with plant management.

Applying Test Load:

1. Set scale to zero.
2. Apply known test load.
3. Remove known test weights and ensure scale returns to zero.
4. Add material to scale less than or equal to known test weights that were applied.
5. Apply known test weights to scale along with material.
6. Continue to build scale up with material and known test weights until user capacity is reached.
7. Ensure scale returns to zero when all material and known test weights are removed.



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Recording:

The readings of "as found" and "as left" are to be recorded on the test report. The actual readings and errors are to be recorded accurately. If the scale is found to be out of tolerance according to NIST HB-44 when tested, adjustments or corrections should be made. to reduce errors to as close to zero as possible. The test report should show the errors before and after adjustments are made. The report should also contain an explanation of corrections made in the remarks section. If adjustments are made the device must be retested. Reports must be uploaded to Veriform within one week of inspection by a Registered Serviceman.

General considerations:

Inspections may be scheduled with plant management to eliminate unnecessary down time and to provide adequate time for inspections to be done correctly. The assistance of plant personnel may be required to position test weights and supports. Inspections are to be performed a minimum of once annually by a Registered Serviceman. Only a Registered Serviceman with a current registration is allowed to make adjustments to a device that affect calibration or performance. Agriculture and Industries inspectors may perform random inspections or witness tests performed by registered servicemen to ensure correct test procedures are being followed and ensure that equipment is kept in good repair. It is the responsibility of the device owner to keep weighing devices in good working condition. The inspection of all scales (aggregate, cement, water) should follow the guideline above.

It may be necessary to test the cement scale solely with known test weights. This is to eliminate leaving material in the hopper or tank if it cannot be removed immediately after inspection. For cement scales tested with known test weights only it is required that a device start and return to zero and test weights are added to perform an increasing load test. Applying a single weight is not an adequate test. This should be determined before testing begins.

Weights and Measures:

www.agi.alabama.gov is the website for a list of Serviceman, Device Registration and Weighmaster's applications. All can be found on the Weights and Measures page. We may also be reached by phone at: 334-240-7133.