



Standard Practice for Classifying Hot-Mix Recycling Agents¹

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1. Scope

1.1 This practice covers a standardized method whereby petroleum product additives to be used in hot recycling of asphalt concrete can be identified. The products are classified by viscosity in mm²/s measured at 60°C [140°F]. This practice does not apply to emulsified materials.

1.2 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

1.3 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:²

- D70 Test Method for Density of Semi-Solid Bituminous Materials (Pycnometer Method)
- D92 Test Method for Flash and Fire Points by Cleveland Open Cup Tester
- D140 Practice for Sampling Bituminous Materials
- D946 Specification for Penetration-Graded Asphalt Cement for Use in Pavement Construction
- D1298 Test Method for Density, Relative Density (Specific

Gravity), or API Gravity of Crude Petroleum and Liquid Petroleum Products by Hydrometer Method

D1754 Test Method for Effects of Heat and Air on Asphaltic Materials (Thin-Film Oven Test)

D2007 Test Method for Characteristic Groups in Rubber Extender and Processing Oils and Other Petroleum-Derived Oils by the Clay-Gel Absorption Chromatographic Method

D2170 Test Method for Kinematic Viscosity of Asphalts (Bitumens)

D2171 Test Method for Viscosity of Asphalts by Vacuum Capillary Viscometer

D2872 Test Method for Effect of Heat and Air on a Moving Film of Asphalt (Rolling Thin-Film Oven Test)

D3381 Specification for Viscosity-Graded Asphalt Cement for Use in Pavement Construction

3. Significance and Use

3.1 Recycling of deteriorated asphalt pavements is being used with increasing frequency for its economy and benefit of conserving raw materials. The objective of recycling is to reuse the two ingredients of asphalt concrete—aggregate and asphalt and to restore the desired properties to the mixture. Recycling is carried out hot or cold, depending on the condition of the deteriorated pavement, construction procedure, availability of equipment, and cost. This practice is for classifying recycling agents to be used in hot recycling.

4. Classification

4.1 This practice describes recycling agents (RA) as belonging to one of the following six groups: RA 1, RA 5, RA 25, RA 75, RA 250, or RA 500, as shown in Table 1. The viscosity ranges are designed to avoid overlap and to provide sufficient flexibility to satisfy a wide range of mix proportions. Other properties specified include flash point (handling), weight percent of saturates (compatibility), selected properties of the RTF or TF oven residue (durability), and specific gravity.

¹ This practice is under the jurisdiction of ASTM Committee D04 on Road and Paving Materials and is the direct responsibility of Subcommittee D04.40 on Asphalt Specifications.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.



TABLE 1 Physical Properties of Hot-Mix Recycling Agents

NOTE—Compliance requires the asphalt be extracted from the pavement to be recycled and combined with the recycling agent being tested. This combination should be in accordance with ratio of recycling agent to recovered asphalt used in the mix. The resulting mixture must meet all specifications for the appropriate grade within Specification D946 or Table 1, 2 or 3 of Specification D3381.

Test	ASTM Test Method	RA 1		RA 5		RA 25		RA 75		RA 250		RA 500	
		Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
Viscosity • 60°C [140°F], mm ² /s	D2170 or D2171	50	175	176	900	901	4500	4501	12500	12501	37500	37501	60000
Flash Point, COC, °C [°F]	D92	219 [425]	...	219 [425]	...	219 [425]	...	219 [425]	...	219 [425]	...	219 [425]	...
Saturates, wt, %	D2007	...	30	...	30	...	30	...	30	...	30	...	30
Tests on Residue from RTFO or TFO oven 163°C [325°F]	D2872 or D1754												
Viscosity Ratio ^A	"	...	3	...	3	...	3	...	3	...	3	...	3
Wt Change, ±, %	"	...	4	...	4	...	3	...	3	...	3	...	3
Specific Gravity	D70 or D1298	Report		Report		Report		Report		Report		Report	

$$^A \text{Viscosity Ratio} = \frac{\text{Viscosity of Residue from RTFO or TFO Oven Test} \cdot 60^\circ\text{C} [140^\circ\text{F}], \text{cSt}}{\text{Original Viscosity} \cdot 60^\circ\text{C} [140^\circ\text{F}], \text{cSt}}$$

4.2 The choice of RA grade will depend on the amount and hardness of the asphalt in the aged pavement. In general, the lower viscosity RA types can be used to restore aged asphalts of high viscosity and vice versa. Additionally, grades RA 1, RA 5, RA 25, and RA 75 will generally be most appropriate for hot-mix recycling of salvaged asphalt concrete when no more than 30 % virgin aggregate is added, while grades RA 250 and RA 500 will generally be most appropriate when more than 30 % virgin aggregate is incorporated into the mix.

5. Physical Properties

5.1 All recycling agents must be homogeneous, free-flowing at pumping temperature, and must conform to the requirements shown in Table 1.

5.2 The final acceptance of recycling agents meeting the requirements shown in Table 1 is subject to the compliance of the reconstituted asphalt blends with current asphalt specifications.

6. Sampling

6.1 All sampling shall be carried out in accordance with Practice D140.

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