



Standard Specification for Mineral Aggregate Used on Built-Up Roofs¹

This standard is issued under the fixed designation D 1863; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last approval. A superscript epsilon (ε) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope

1.1 This specification covers the quality and grading of crushed stone, crushed slag, and water-worn gravel suitable for use as coarse mineral aggregate on built-up roofs.

1.2 The values stated in SI units are to be regarded as the standard. The values given in parentheses are for information only.

2. Referenced Documents

2.1 ASTM Standards:²

- C 29/C 29M Test Method for Bulk Density (Unit Weight) and Voids in Aggregate
- C 33 Specification for Concrete Aggregates
- C 117 Test Method for Materials Finer Than 75-μm (No. 200) Sieve in Mineral Aggregates by Washing
- C 136 Test Method for Sieve Analysis of Fine and Coarse Aggregates
- D 75 Practice for Sampling Aggregates
- D 448 Classification for Sizes of Aggregate for Road and Bridge Construction
- D 1864 Test Method for Moisture in Mineral Aggregate Used on Built-Up Roofs
- D 1865 Test Method for Hardness of Mineral Aggregate Used on Built-Up Roofs
- E 11 Specification for Wire Cloth and Sieves for Testing Purposes

3. Materials and Manufacture

3.1 *Crushed Stone and Gravel*—The crushed stone and gravel at the time of application shall be hard, durable, opaque, and free of clay, loam, sand, or other foreign substances.

¹ This specification is under the jurisdiction of ASTM Committee D08 on Roofing and Waterproofing and is the direct responsibility of Subcommittee D08.03 on Surfacing and Bituminous Materials for Membrane Waterproofing and Built-up Roofing.

Current edition approved Dec. 1, 2003. Published January 2004. Originally published in 1961. Last previous edition approved in 2003 as D 1863 – 93 (2003).

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.

3.2 *Crushed Slag*—Crushed slag shall be hard, air-cooled, blast-furnace slag, or electric furnace phosphate slag that is free of sand, clay, or other foreign substances at the time of application.

4. Requirements

4.1 The aggregate shall conform to the gradation requirements specified in Table 1.

TABLE 1 Gradation Requirements

Sieve (Specification E 11)	Amounts Finer than Sieve Specified, mass %		
	Size 6 ^A 19.0 to 9.5 mm (¾ in. to ⅜ in.)	Size No. 67 ^A 19.0 to 4.75 mm (¾ in. to No. 4)	Size No. 7 ^A 12.5 to 4.75 mm (½ in. to No. 4)
25 mm (1 in.)	100	100	...
19 mm (¾ in.)	90 to 100	90 to 100	100
12.5 mm (½ in.)	20 to 55	...	90 to 100
9.5 mm (⅜ in.)	0 to 15	20 to 55	40 to 70
4.75 mm (No. 4)	0 to 5	0 to 10	0 to 15
2.36 mm (No. 8)	...	0 to 5	0 to 5

^A Size number and requirements data are from Specification C 33 and Classification D 448.

4.2 The aggregate shall conform to the physical properties specified in Table 2.

TABLE 2 Physical Properties

Moisture, max, %:	
Crushed stone and gravel	2.0
Crushed roofing slag	5.0 ^A
Unit mass (loose), min, kg/m ³ (lb/ft ³)	960 (59.9)
Dust, max, %	2.0
Hardness, max, percentage passing a 3.35-mm (No. 6) sieve	20

^A A higher moisture content is permitted for slag because of moisture entrapment in the internal pores of the pieces of slag.

4.3 Suggested Field Checks:

4.3.1 Aggregate shall be free of ice and snow.

4.3.2 A handful of aggregate shall not drip water.

4.3.3 The aggregate shall be dry and clean enough to adhere to the hot bitumen flood coat when installed.

5. Sampling

5.1 Sample aggregates received in bulk in accordance with Practice D 75.

5.2 For aggregates received in bags or small containers, select a number of bags or small containers at random equivalent to the cube root of the total number in the shipment.

6. Test Methods

6.1 *Gradation*—Test Method C 136.

6.2 *Moisture*—Test Method D 1864.

6.3 *Unit Mass (Loose)*—Test Method C 29/C 29M, utilizing the shoveling procedure.

6.4 *Dust*—Test Method C 117.

6.5 *Hardness*—Test Method D 1865.

7. Inspection

7.1 Inspection of the material shall be as agreed upon between the purchaser and the supplier.

8. Rejection and Rehearing

8.1 Failure to conform to any of the requirements prescribed in this specification shall constitute grounds for rejection. In case of rejection, the seller shall have the right to re-inspect the rejected material and resubmit the lot after removal of those items not conforming to the requirements.

9. Certification

9.1 Certification of material shall be as agreed upon between the purchaser and the supplier.

10. Keywords

10.1 built-up roofs; crushed slag; crushed stone; gravel; mineral aggregate

ASTM International takes no position respecting the validity of any patent rights asserted in connection with any item mentioned in this standard. Users of this standard are expressly advised that determination of the validity of any such patent rights, and the risk of infringement of such rights, are entirely their own responsibility.

This standard is subject to revision at any time by the responsible technical committee and must be reviewed every five years and if not revised, either reapproved or withdrawn. Your comments are invited either for revision of this standard or for additional standards and should be addressed to ASTM International Headquarters. Your comments will receive careful consideration at a meeting of the responsible technical committee, which you may attend. If you feel that your comments have not received a fair hearing you should make your views known to the ASTM Committee on Standards, at the address shown below.

This standard is copyrighted by ASTM International, 100 Barr Harbor Drive, PO Box C700, West Conshohocken, PA 19428-2959, United States. Individual reprints (single or multiple copies) of this standard may be obtained by contacting ASTM at the above address or at 610-832-9585 (phone), 610-832-9555 (fax), or service@astm.org (e-mail); or through the ASTM website (www.astm.org).