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**Tiller Corporation**  
*and its operating divisions*

Barton Sand & Gravel Co.  
Commercial Asphalt Co.  
Barton Enterprises, Inc.

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April 4, 2017

Planning Commission Members  
City of Blaine  
10801 Town Square Drive NE  
Blaine, MN 55449

Dear Planning Commission Members:

Tiller Corporation's operating division, Commercial Asphalt Co., is scheduled to have a request on the agenda for your April 11, 2017 meeting. Our Blaine facility has been operating as an established member of your business community for some time and we thought it may be helpful to hear about our recent activities and the features of the facility. As our application information explains, the Federal Highway Administration (FHWA) goals and the US Department of Transportation (USDOT) plans, both support and promote the use of recycled highway materials in road construction. Tiller and its operating divisions have embraced these goals and plans and the resulting technologies at all of our facilities including Blaine and all nine of our other asphalt facilities located throughout the metropolitan area.

In 2016 our company utilized recycled asphalt products (RAP) at a rate of just over 22% as a total of all of the mixes we produced. This is slightly above the national average which has been reported to be 20%. In addition to utilizing RAP, we also produce aggregate base materials from recycled concrete and asphalt. In 2016 the total of all recycled materials utilized in Blaine accounted for approximately 160,000 tons of aggregate materials and 3500 tons of asphalt cement that went to projects served by this facility. If the recycling were not taking place, virgin aggregates and asphalt cement would have been produced and trucked in from other areas to fill the void caused by not recycling at our Blaine facility.

The Blaine facility is also home to our mix design laboratory which designs and tests various asphalt mixes. The lab has been host to numerous tours by local, state, national and international groups. These groups range from students to industry experts and officials.

Staff at Tiller's mix design lab in Blaine has strived to increase the amount of RAP being incorporated in all of our mixes at all of our facilities. In fact, due to the mix design staff's hard work, Commercial Asphalt Co. received the Governor's Award for Pollution Prevention in 2009.

Besides the Governor's Award, other awards our company has received for this Facility include the MPCA's Green Star Award, NAPA's Ecological Award in 2001 after the Facility was first



constructed and a second Ecological Award in 2015 after a new plant and energy saving equipment were installed. The facility was featured in an industry publication describing this latest award which is enclosed.

Of course, it goes without saying that, Tiller and its employees are very proud of our Blaine Facility and all of its accomplishments.

We look forward to seeing you on April 11<sup>th</sup>. If you have any questions please do not hesitate to call. We may be reached at (763) 425-4191.

Sincerely,

**Tiller Corporation**

A handwritten signature in black ink, appearing to read "Michael Caron".

Michael Caron  
Director of Land Use Affairs

A handwritten signature in blue ink, appearing to read "Christina Morrison".

Christina Morrison  
Land Use and Permitting Coordinator

c: Bryan Schafer, Blaine Planning & Community Development Director

enc:



# Thinking Ecologically Means

By Mary Ann Melody

Putting a “green” facelift on today’s asphalt plant means more than just a stamp of approval from the federal and state environmental regulatory agencies overseeing asphalt pavement facilities. It involves taking great strides to reduce a plant’s environmental footprint.

In recent years, these advances have helped keep asphalt companies financially viable by diminishing the amount of energy needed to produce asphalt and increasing the amount of recycled materials used in asphalt mixes. In addition, many asphalt producers have multiple emission control systems in place to control dust, stormwater run-off, and equipment wash water.

NAPA’s Ecological Awards recognize asphalt production facilities that best demonstrate safe and responsible environmental practices. Facilities are judged on their design layout, clean operation, maintenance performance practices, and community activities. Winners must first earn a Diamond Achievement Commendation by establishing adherence to best practices for asphalt plant operations, including outstanding appearance, environmental practices, safety, permitting and regulatory compliance, and community relations.

This year’s two winners exemplify their commitment to the environment, company mission statements, and community by excelling in these best practice standards.

## WINNER — NEW PLANT

### Commercial Asphalt Co.

#### Blaine, Minnesota

When Commercial Asphalt Company upgraded its Blaine, Minn., facility last year from a 500 ton per hour (TPH) to a 600 TPH hot-mix asphalt plant, the upgrades provided an opportunity to highlight the ecological and economic achievements at the facility.

In addition to the obvious increased output, Commercial Asphalt added a new 600 TPH counterflow drum, a new 600 TPH slat with fume capturing, a sixth silo, four additional virgin bins, two new recycle bins, one shingle bin, a fourth asphalt cement tank, and a warm-mix foaming system.

“Running an energy efficient plant makes us more competitive,” said Todd Laubis, Vice President of Asphalt Operations for Commercial Asphalt. “We run energy efficient motors, and we run a natural gas burner that is tuned on-site to get the best efficiency.”

**Commercial Asphalt Co.’s upgraded Blaine, Minn., plant is now more energy-efficient — something very appealing to the company’s customers.**



# Thinking Economically

Frequency drivers on the exhaust fan, drum, and slat conveyor have helped reduce the plant's electrical usage by 11 percent, even with the plant upgrade. To further reduce electrical usage, a "smart" capacitor bank was added to help keep their power factor above 90 percent.

Natural resources are also preserved through recycling asphalt, and concrete materials and shingles. The lower temperature in the warm-mix foaming system contributes to reduction in the company's fuel consumption and a drive-over truck unloading system

is used to stockpile the company's most frequently used products, decreasing loader use and increasing production efficiency.

Christina Morrison, Land Use and Permitting Coordinator for Commercial Asphalt, added that performing best management practices is a key component to the success of an operation.

"What we've found is customers increasingly want to align themselves with companies that demonstrate a heightened awareness for the environment and perform sustainable practices,

which we strive for here," Morrison said.

Fugitive dust is controlled through a baghouse, daily sweeping of the paved traffic and parking areas, and by implementing a facility speed limit. Unpaved portions of the stockpiling area are watered and receive dust control applications, as necessary.

The Commercial Asphalt facility practices best management by containing its storm water internally on-site into the designated stormwater ponds. The

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## Ecological Awards



**Live Bottom Trailers**



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facility was designed to promote this practice and includes inspections as part of its Storm Water Pollution Prevention Plan (SWPPP).

The company is recognized annually as being a good neighbor, noting its well-maintained landscaping, and the variety of trees, shrubs, and flowers planted near the entrance and company logo. "We strive to set a great example at the gate," Laubis said.

"Within the facility, noise reduction technology such as broadband backup alarms on company equipment, and maintaining a clean and tidy appearance go to great lengths as far as being a good neighbor," added Morrison.


Being a good neighbor does not end at the fence line. As a leader in the industry, Commercial Asphalt has participated in a program sponsored by the U.S. Department of Commerce for a number of years which promoted partnership between the U.S. and Eurasia and provided an opportunity for transportation officials from former Soviet republics to visit the facility and gain exposure to asphalt production methods in the U.S.

The facility also features a design and quality assurance laboratory contained within a building that is often showcased to state, county, and local officials. Community involvement is part of their protocol especially when it comes to engagement with local universities, technical colleges, and high schools to promote awareness of the industry and career opportunities.

Both Laubis and Morrison agree that Commercial Asphalt sets the bar high, which encourages its employees to achieve well maintained and pleasing aesthetics, exceptional environmental compliance, energy efficiency, and most importantly, high quality mixes. These achievements are appreciated by their customers and

neighbors alike and the benefits extend well beyond the plant itself.

### **WINNER — EXISTING PLANT**

**Duval Asphalt Products Inc.**   
**Jacksonville, Florida**

Duval Asphalt Products' Plant 2 is prominently located and visible to the public on Philips Highway in Jacksonville.

Such direct exposure means the facility must consistently be neat, clean, and aesthetically pleasing — a goal Duval Asphalt maintains by going above and beyond the baseline ecological requirements set by the federal and local regulatory agencies.

"Our clean and vibrant facility is pleasing to the residents of Duval County, our neighbors, and our regulatory agencies," said Jennifer Ragsdale, Director of Business Development and Marketing for Duval Asphalt.

The company's top-notch standards often send new customers and new ventures its way, Ragsdale said. One of those standards is a daily inspection of the plant to ensure ecological compliance.

"Our customers are more inclined to choose us because of our cleanliness and professionalism," Ragsdale said. "The agencies are more open to work with us on new pursuits and expansion, because we have an established reputation for doing the right thing."

Indeed, Duval Asphalt maintains its delicate balancing act of keeping an aesthetically pleasing plant while simultaneously being as ecologically sensitive as possible. The company conducts regular testing of its baghouse emissions, daily cleaning of all paved surfaces, regular cleaning of its equipment and structures, and the use of burner sound suppression to control noise.

The plant uses a warm-mix foaming system and variable frequency drives to help reduce electrical energy. All asphalt cement,