

**PROJECT SPECIAL PROVISIONS**

**ROADWAY**

**SHOULDER CONSTRUCTION:**

(12-21-99) (Rev.7-18-06)

R1 R04 Rev.

**Description**

**The work covered by this provision consists of performing shoulder construction in accordance with Section 560 of the 2006 Standard Specifications and the details of this provision. Construction of a new shoulder is required due to widening of the existing paved shoulder and resurfacing on the existing roadway. Place earth material along the completed edge of pavement and construct shoulders as shown on the sketch map and/or as directed by the Engineer. Backfill and compact the area to the satisfaction of the Engineer. Perform this work immediately after the resurfacing operations are completed as directed by the Engineer.**

**Materials**

**Use all suitable material generated from the widening operation to construct the shoulders. Furnish any other earth material necessary for the construction of the shoulders. Provide earth material meeting the approval of the Engineer. No testing will be necessary.**

**Measurement and Payment**

*Shoulder Construction* will be measured and paid for as the actual number of shoulder miles that have been constructed. Measurement will be made along the surface of each shoulder and to the nearest 0.01 of a mile. Such price and payment will be full compensation for furnishing earth material, hauling, placing, compaction, and all incidentals necessary to complete construction of the shoulders. **Seeding and mulching will be paid for as provided elsewhere in this contract.**

Payment will be made under:

<b>Pay Item</b>	<b>Pay Unit</b>
Shoulder Construction	Shoulder Mile

**ASPHALT PAVEMENTS - SUPERPAVE:**

(7-18-06)(Rev 10-20-09)

RR6R01

Revise the *2006 Standard Specifications* as follows:

**Page 6-2, Article 600-9 Measurement and Payment, delete the second paragraph.**

**Page 6-12, Subarticle 609-5(C)2, Required Sampling and Testing Frequencies, first partial paragraph at the top of the page, delete last sentence and add the following:**

If the Engineer allows the mix to remain in place, payment will be made in accordance with Article 105-3.

**Page 6-12, Subarticle 609-5(C)2, QUALITY CONTROL MINIMUM SAMPLING AND TESTING SCHEDULE**

**First paragraph, delete and replace with the following.**

Sample and test the completed mixture from each mix design per plant per year at the following minimum frequency during mix production:

**Second paragraph, delete the fourth sentence, and replace with the following**

When daily production of each mix design exceeds 100 tons and a regularly scheduled full test series random sample location for that mix design does not occur during that day's production, perform at least one partial test series consisting of Items A and B in the schedule below.

**Page 6-12, Subarticle 609-5(C)2(c) Maximum Specific Gravity, add after (AASHTO T 209):**

*or ASTM D 2041*

**Page 6-13, last line and on page and Page 6-14, Subarticle 609-5(C)(2)(e) Tensile Strength Ratio (TSR), add a heading before the first paragraph as follows:**

(i) Option 1

**Insert the following immediately after the first paragraph:**

(ii) Option 2

Mix sampled from truck at plant with one set of specimens prepared by the Contractor and then tested jointly by QA and QC at a mutually agreed upon lab site within the first 7 calendar days after beginning production of each new mix design.

**Second paragraph, delete and replace with the following:**

Test all TSR specimens required by either option noted above on either a recording test press or a test press that maintains the peak load reading after the specimen has broken.

**Subarticle 609-5(C)(3) Control Charts, delete the second sentence of the first paragraph and replace with the following:**

For mix incorporated into the project, record full test series data from all regularly scheduled random samples or directed samples that replace regularly scheduled random samples, on control charts the same day the test results are obtained.

**Page 6-15, Subarticle 609-5(C)(3) Control Charts, first paragraph on this page, delete the last sentence and substitute the following:**

Denote the moving average control limits with a dash green line and the individual test limits with a dash red line.

**Subarticle 609-5(C)(3)(a), (b) and (c), replace (a) (b) and (c) with the following:**

- (a) A change in the binder percentage, aggregate blend, or  $G_{mm}$  is made on the JMF, or,
- (b) When the Contractor elects to stop or is required to stop production after one or two moving average values, respectively, fall outside the moving average limits as outlined in subarticle 609-5(C)6 or,
- (c) If failure to stop production after two consecutive moving averages exceed the moving average limits occurs, but production does stop at a subsequent time, re-establish a new moving average beginning at the actual production stop point.

**Subarticle 609-5(C)(4) Control Limits, replace the first paragraph and the CONTROL LIMITS Table on page 6-16 with the following.**

The following are established as control limits for mix production. Apply the individual limits to the individual test results. Control limits for the moving average limits are based on a moving average of the last 4 data points. Apply all control limits to the applicable target source.

**CONTROL LIMITS**

Mix Control Criteria	Target Source	Moving Average Limit	Individual Limit
2.36 mm Sieve	JMF	±4.0 %	±8.0 %
0.075mm Sieve	JMF	±1.5 %	±2.5 %
Binder Content	JMF	±0.3 %	±0.7 %
VTM @ $N_{des}$	JMF	±1.0 %	±2.0 %
VMA @ $N_{des}$	Min. Spec. Limit	Min Spec. Limit	-1.0%
$P_{0.075} / P_{bc}$ Ratio	1.0	±0.4	±0.8
% $G_{mm}$ @ $N_{ini}$	Max. Spec. Limit	N/A	+2.0%
TSR	Min. Spec. Limit	N/A	- 15%

**Page 6-16, Subarticle 609-5(C)(5) Warning Bands, delete this subarticle in its entirety.**

**Pages 6-16 through 6-19, Subarticle 609-5(C)(6), delete the word "warning" and substitute the words "moving average".**

**Page 6-16, Subarticle 609-5(C)(6) Corrective Actions, first paragraph, first sentence, delete and replace with the following:**

Immediately notify the Engineer when moving averages exceed the moving average limits.

**Page 6-17, third full paragraph, delete and replace with the following:**

Failure to stop production when required due to an individual mix test not meeting the specified requirements will subject all mix from the stop point tonnage to the point when the next individual test is back on or within the moving average limits, or to the tonnage point when production is actually stopped, whichever occurs first, to being considered unacceptable.

**Sixth full paragraph, delete the first, second, and third sentence and replace with the following:**

Immediately notify the Engineer when any moving average value exceeds the moving average limit. If two consecutive moving average values for any one of the mix control criteria fall outside the moving average limits, cease production of that mix, immediately notify the Engineer of the stoppage, and make adjustments. The Contractor may elect to stop production after only one moving average value falls outside the moving average limits.

**Page 6-18, Subarticle 609-5(C)(6) Corrective Actions second full paragraph, delete and replace with the following:**

If the process adjustment improves the property in question such that the moving average after four additional tests is on or within the moving average limits, the Contractor may continue production with no reduction in payment

**Page 6-18, delete the third and fourth full paragraphs, including the Table for Payment for Mix Produced in the Warning Bands and substitute the following:**

If the adjustment does not improve the property in question such that the moving average after four additional individual tests is outside the moving average limits, the mix will be evaluated for acceptance in accordance with Article 105-3. Reduced payment for or removal of the mix in question will be applied starting from the plant sample tonnage at the stop point to the sample tonnage when the moving average is on or within the moving average limits. In addition, any mix that is obviously unacceptable will be rejected for use in the work.

**Page 6-19, First paragraph, delete and replace with the following:**

Failure to stop production and make adjustments when required due to two consecutive moving average values falling outside the moving average limits will subject all mix

produced from the stop point tonnage to the tonnage point when the moving average is back on or within the moving average limits or to the tonnage point when production is actually stopped, whichever occurs first, to being considered unacceptable. Remove this material and replaced with materials that comply with the Specifications at no additional costs to the Department, unless otherwise approved. Payment will be made for the actual quantities of materials required to replace the removed quantities, not to exceed the original amounts.

**Page 6-20, Subarticle 609-5(D)(1) General, delete the third full paragraph, and replace with the following:**

Perform the sampling and testing at the minimum test frequencies as specified above. Should the density testing frequency fail to meet the minimum frequency as specified above, all mix without the required density test representation will be considered unsatisfactory. If the Engineer allows the mix to remain in place, payment will be made in accordance with Article 105-3.

**Page 6-22, Subarticle 609-5(D)(4) Nuclear Gauge Density Procedures, third paragraph, insert the following as the second sentence:**

Determine the Daily Standard Count in the presence of the QA Roadway Technician or QA Nuclear Gauge Technician on days when a control strip is being placed.

**Page 6-23, Subarticle 609-5(D)(5) Limited Production Procedure, delete the first paragraph including (a), (b), (c) and substitute the following:**

Proceed on limited production when, for the same mix type and on the same contract, one of the following conditions occur (except as noted in the first paragraph below).

- (a) Two consecutive failing lots, except on resurfacing\*
- (b) Three consecutive failing lots on resurfacing\*
- (c) Two consecutive failing nuclear control strips.

\* Resurfacing is defined as the first new uniform layer placed on an existing pavement.

**Page 6-25, Article 609-6 Quality Assurance, Density Quality Assurance, insert the following items after item (E):**

- (F) By retesting Quality Control core samples from control strips (either core or nuclear) at a frequency of 100% of the frequency required of the Contractor;
- (G) By observing the Contractor perform all standard counts of the Quality Control nuclear gauge prior to usage each nuclear density testing day; or
- (H) By any combination of the above

**Page 6-28, Subarticle 610-3(A) Mix Design-General, delete the fourth and fifth paragraphs and replace with the following:**

Reclaimed Asphalt Pavement (RAP) or Reclaimed Asphalt Shingles (RAS) may be incorporated into asphalt plant mixes in accordance with Article 1012-1 and the following applicable requirements.

Reclaimed asphalt pavement (RAP) may constitute up to 50% of the total material used in recycled mixtures, except for mix Type S 12.5D, Type S 9.5D, and mixtures containing reclaimed asphalt shingle material (RAS). Reclaimed asphalt shingle (RAS) material may constitute up to 6% by weight of total mixture for any mix. When both RAP and RAS are used, do not use a combined percentage of RAS and RAP greater than 20% by weight of total mixture, unless otherwise approved. When the percent of binder contributed from RAS or a combination of RAS and RAP exceeds 20% but not more than 30% of the total binder in the completed mix, the virgin binder PG grade shall be one grade below (both high and low temperature grade) the binder grade specified in Table 610-2 for the mix type, unless otherwise approved. When the percent of binder contributed from RAS or a combination of RAS and RAP exceeds 30% of the total binder in the completed mix, the Engineer will establish and approve the virgin binder PG grade. Use approved methods to determine if any binder grade adjustments are necessary to achieve the performance grade for the specified mix type.

For Type S 12.5D and Type S 9.5D mixes, the maximum percentage of reclaimed asphalt material is limited to 20% and shall be produced using virgin asphalt binder grade PG 76-22. For all other recycled mix types, the virgin binder PG grade shall be as specified in Table 610-2A for the specified mix type.

When the percentage of RAP is greater than 20% but not more than 30% of the total mixture, use RAP meeting the requirements for processed or fractionated RAP in accordance with the requirements of Section 1012-1.

When the percentage of RAP is greater than 30% of the total mixture, use an approved stockpile of RAP in accordance with Section 1012-1(C). Use approved test methods to determine if any binder grade adjustments are necessary to achieve the performance grade for the specified mix type. The Engineer will establish and approve the virgin asphalt binder grade to be used.

## Page 6-34, Subarticle 610-3(C),

Delete Table 610-2 and associated notes. Substitute the following:

**TABLE 610-2**  
**SUPERPAVE MIX DESIGN CRITERIA**

Mix Type	Design ESALs Millions (a)	Binder PG Grade (b)	Compaction Levels No. Gyration @		Max. Rut Depth (mm)	Volumetric Properties (c)			
			N <sub>ini</sub>	N <sub>des</sub>		VMA % Min.	VTM %	VFA Min. - Max.	%G <sub>mm</sub> @ N <sub>ini</sub>
S-4.75A(e)	< 0.3	64 -22	6	50	-----	20.0	7.0 - 15.0	-----	-----
SF-9.5A	< 0.3	64 -22	6	50	11.5	16.0	3.0 - 5.0	70 - 80	≤ 91.5
S-9.5B	0.3 - 3	64 -22	7	65	9.5	15.5	3.0 - 5.0	65 - 80	≤ 90.5
S-9.5C	3 - 30	70 -22	7	75	6.5	15.5	3.0 - 5.0	65 - 78	≤ 90.5
S-9.5D	> 30	76 -22	8	100	4.5	15.5	3.0 - 5.0	65 - 78	≤ 90.0
S-12.5C	3 - 30	70 -22	7	75	6.5	14.5	3.0 - 5.0	65 - 78	≤ 90.5
S-12.5D	> 30	76 -22	8	100	4.5	14.5	3.0 - 5.0	65 - 78	≤ 90.0
I-19.0B	< 3	64 -22	7	65	-----	13.5	3.0 - 5.0	65 - 78	≤ 90.5
I-19.0C	3 - 30	64 -22	7	75	-----	13.5	3.0 - 5.0	65 - 78	≤ 90.0
I-19.0D	> 30	70 -22	8	100	-----	13.5	3.0 - 5.0	65 - 78	≤ 90.0
B-25.0B	< 3	64 -22	7	65	-----	12.5	3.0 - 5.0	65 - 78	≤ 90.5
B-25.0C	> 3	64 -22	7	75	-----	12.5	3.0 - 5.0	65 - 78	≤ 90.0
All Mix Types	<b>Design Parameter</b> 1. Dust to Binder Ratio (P <sub>0.075</sub> / P <sub>be</sub> ) 2. Retained Tensile Strength (TSR) (AASHTO T283 Modified)					<b>Design Criteria</b> 0.6 – 1.4 85% Min. (d)			

- Notes:
- (a) Based on 20 year design traffic.
  - (b) When Recycled Mixes are used, select the binder grade to be added in accordance with Subarticle 610-3(A).
  - (c) Volumetric Properties based on specimens compacted to N<sub>des</sub> as modified by the Department.
  - (d) AASHTO T 283 Modified (No Freeze-Thaw cycle required). TSR for Type S 4.75A, Type B 25.0B, and Type B 25.0C mixes is 80% minimum.
  - (e) Mix Design Criteria for Type S 4.75A may be modified subject to the approval of the Engineer.

**Page 6-34, Insert the following immediately after Table 610-2:**

**TABLE 610-2A  
SUPERPAVE MIX DESIGN CRITERIA**

Mix Type	Percentage of RAP in Mix		
	Category 1 % RAP ≤20%	Category 2 20.1% ≤ %RAP ≤ 30.0%	Category 3 %RAP > 30.0%
All A and B Level Mixes, I19.0C, B25.0C	PG 64 -22	PG 64 -22	TBD
S9.5C, S12.5C, I19.0D	PG 70 -22	PG 64-22	TBD
S 9.5D and S12.5D	PG 76-22	N/A	N/A

- Note: (1) Category 1 RAP has been processed to a maximum size of 2 inches.  
 (2) Category 2 RAP has been processed to a maximum size of 1 inch by either crushing and or screening to reduce variability in the gradations.  
 (3) Category 3 RAP has been processed to a maximum size of 1 inch, fractionating the RAP into 2 or more sized stockpiles

**Page 6-35, Table 610-3 delete and replace with the following:**

**TABLE 610-3  
ASPHALT PLACEMENT- MINIMUM TEMPERATURE REQUIREMENTS**

Asphalt Concrete Mix Type	Minimum Air Temperature	Minimum Surface Temperature
ACBC, Type B 25.0B, C, B 37.5C	35°F	35°F
ACIC, Type I 19.0B, C, D	35°F	35°F
ACSC, Type S 4.75A, SF 9.5A, S 9.5B	40°F	50°F*
ACSC, Type S 9.5C, S 12.5C	45°F	50°F
ACSC, Type S 9.5D, S 12.5D	50°F	50°F

\* 35°F if surface is soil or aggregate base for secondary road construction.

**Page 6-44, Article 610-8 Spreading and Finishing, third full paragraph, replace the first sentence with the following:**

Use the 30 foot minimum length mobile grade reference system or the non-contacting laser or sonar type ski *with at least four referencing stations mounted on the paver at a minimum length of 24 feet* to control the longitudinal profile when placing the initial lanes and all adjacent lanes of all layers, including resurfacing and asphalt in-lays, unless otherwise specified or approved.



**Page 6-50, Article 610-13 Density Acceptance, delete the second paragraph and replace with the following:**

As an exception, when the first layer of mix is a surface course and is being placed directly on an unprimed aggregate or soil base, the layer will be included in the "Other" construction category.

**Page 6-50, Article 610-13 Density Acceptance, delete the formula and description in the middle of the page and replace with the following:**

where:

PF	=	$100 - 10(D)^{1.465}$
PF	=	Pay Factor (computed to 0.1%)
D	=	the deficiency of the lot average density, not to exceed 2.0%

**Page 6-53, Article 620-4 Measurement and Payment:**

**Sixth paragraph, delete the last sentence.**

**Seventh paragraph, delete the paragraph and replace with the following:**

The adjusted contract unit price will then be applied to the theoretical quantity of asphalt binder authorized for use in the plant mix placed during the partial payment period involved, except that where recycled plant mix is used, the adjusted unit price will be applied only to the theoretical number of tons of additional asphalt binder materials required by the job mix formula.

**Page 6-54, Article 620-4 Measurement and Payment, add the following pay item:**

<b>Pay Item</b>	<b>Pay Unit</b>
Asphalt Binder for Plant Mix, Grade PG 70-28	Ton

**Page 6-69, Table 660-1 Material Application Rates and Temperatures, add the following:**

Type of Coat	Grade of Asphalt	Asphalt Rate gal/yd <sup>2</sup>	Application Temperature °F	Aggregate Size	Aggregate Rate lb./sq. yd. Total
Sand Seal	CRS-2 or CRS-2P	0.22-0.30	150-175	Blotting Sand	12-15

**Page 6-75, Subarticle 660-9(B), add the following as sub-item (5)**

(5) Sand Seal

Place the fully required amount of asphalt material in one application and immediately cover with the seal coat aggregate. Uniformly spread the fully required

amount of aggregate in one application and correct all non-uniform areas prior to rolling.

Immediately after the aggregate has been uniformly spread, perform rolling.

When directed, broom excess aggregate material from the surface of the seal coat.

When the sand seal is to be constructed for temporary sealing purposes only and will not be used by traffic, other grades of asphalt material meeting the requirements of Articles 1020-6 and 1020-7 may be used in lieu of the grade of asphalt required by Table 660-1 when approved.

**Page 6-76, Article 661-1 Description, add the following as the 2nd paragraph:**

Provide and conduct the quality control and required testing for acceptance of the UBWC in accordance with "Quality Management System for Asphalt Pavements (OGAFC, PADL, and Ultra-Thin HMA Version)", included in the contract.

**Page 6-80, Subarticle 661-3(A) Equipment, add the following as the first paragraph:**

Use asphalt mixing plants in accordance with Article 610-5.

**Page 10-41, Table 1012-1, delete the last row of entries for OGAFC and add the following:**

Mix Type	Coarse Aggregate Angularity <sup>(b)</sup> ASTM D5821	Fine Aggregate Angularity % Minimum AASHTO T304 Method A	Sand Equivalent % Minimum AASHTO T176	Flat & Elongated 5:1 Ratio % Maximum ASTM D4791 Section 8.4
S 9.5 D	100/100	45	50	10
OGAFC	100/100	N/A	N/A	10
UBWC	100/85	40	45	10

**Delete Note (c) under the Table 1012-1 and replace with the following:**

(c) Does not apply to Mix Types SF 9.5A and S 9.5B.

**Page 10-43, Subarticle 1012-1(F): Reclaimed Asphalt Shingle Material (RAS), insert the following immediately following the first paragraph:**

(1) Mix Design RAS

Incorporate RAS from stockpiles that have been tested for uniformity of gradation and binder content prior to use in an asphalt mix design.

## (2) Mix Production RAS

New Source RAS is defined as acceptable material which was not included in the stockpile when samples were taken for mix design purposes. Process new source RAS so that all materials will pass a 1/2" sieve prior to introduction into the plant mixer unit.

After a stockpile of processed RAS has been sampled and mix designs made from these samples, do not add new source RAS to the original stockpile without prior field testing to insure gradation and binder uniformity. Sample and test new source RAS before blending with the existing stockpile.

Store new source RAS in a separate stockpile until the material can be sampled and tested for comparison with the original recycled mix design data. New source RAS may also be placed against the existing stockpile in a linear manner provided it is sampled for mix design conformity prior to its use in the recycled mix.

RAS contamination including but not limited to excessive dirt, debris, clean stone, concrete will not be allowed.

Field approval of new source RAS will be based on the table below and volumetric mix properties on the mix with the new source RAS included. Provided these tolerances are met, volumetric properties of the new mix will then be performed. If all volumetric mix properties meet the mix design criteria for that mix type, the new source RAS may continue to be used.

If the gradation, binder content, or any of the volumetric mix properties are not within the allowable tolerances of the table below, do not use the new source RAS unless approved by the Engineer. The Contractor may elect to either not use the stockpile, to request an adjustment to the JMF, or to redesign the mix.

**NEW SOURCE RAS GRADATION and BINDER TOLERANCES**  
(Apply Tolerances to Mix Design Data)

0-6% RAS	
P <sub>b</sub> %	±1.6%
Sieve Size (mm)	Tolerance
9.5	±1
4.75	±5
2.36	±4
1.18	±4
0.300	±4
0.150	±4
0.075	±2.0

**Page 10-43 through 10-45, Subarticle 1012-1(G), delete this in its entirety and replace with the following:**

**(G) Reclaimed Asphalt Pavement (RAP)**

**(1) Mix Design RAP**

Incorporate RAP from stockpiles or other sources that have been tested for uniformity of gradation and binder content prior to use in an asphalt mix design. Use reclaimed asphalt pavement that meets all requirements specified for *one* of the following *two* classifications.

**(a) Millings**

Existing reclaimed asphalt pavement (RAP) that is removed from its original location by a milling process as specified in Section 607. Millings should be such that it has a uniform gradation and binder content and all materials will pass a 2" sieve prior to introduction into the plant mixer unit.

**(b) Processed RAP**

RAP that is processed in some manner (possibly by crushing and/or use of a blending method) to produce a uniform gradation and binder content in the RAP prior to use in a recycled mix. Process RAP so that all materials have a uniform gradation and binder content and will pass a 1" sieve prior to introduction into the plant mixer unit.

**(c) Fractionated RAP**

Fractionated RAP is defined as having two or more RAP stockpiles, where the RAP is divided into coarse and fine fractions. Grade RAP so that all materials will pass a 1" sieve. The coarse RAP stockpile shall only contain material retained on a 3/8" screen, unless otherwise approved. The fine RAP stockpile shall only contain material passing the 3/8" screen, unless otherwise approved. The Engineer may allow the Contractor to use an alternate to the 3/8" screen to fractionate the RAP. The maximum percentages of fractionated RAP may be comprised of coarse, fine, or the combination of both. Utilize a separate cold feed bin for each stockpile of fractionated RAP used.

**(d) Approved Stockpiled RAP**

Approved Stockpiled RAP is defined as fractionated RAP which has been isolated and tested for asphalt content, gradation, and asphalt binder characteristics with the intent to be used in mix designs with

greater than 30% RAP materials. Fractionate the RAP in accordance with Section 1012-1(G)(c). Utilize a separate cold feed bin for each approved stockpile of RAP used.

Perform extraction tests at a rate of 1 per 1000 tons of RAP, with a minimum of 5 tests per stockpile to determine the asphalt content and gradation. Separate stockpiles of RAP material by fine and coarse fractions. Erect and maintain a sign satisfactory to the Engineer on each stockpile to identify the material. Assure that no deleterious material is allowed in any stockpile. The Engineer may reject by visual inspection any stockpiles that are not kept clean, separated, and free of foreign materials.

Submit requests for RAP stockpile approval to the Engineer with the following information at the time of the request:

- (1) Approximate tons of materials in stockpile
- (2) Name or Identification number for the stockpile
- (3) Asphalt binder content and gradation test results
- (4) Asphalt characteristics of the Stockpile.

For the Stockpiled RAP to be considered for approval, the gradation and asphalt content shall be uniform. Individual test results, when compared to the target, will be accepted if within the tolerances listed below:

**APPROVED STOCKPILED RAP GRADATION and BINDER TOLERANCES**  
(Apply Tolerances to Mix Design Data)

P <sub>b</sub> %	±0.3%
Sieve Size (mm)	Percent Passing
25.0	±5%
19.0	±5%
12.5	±5%
9.5	±5%
4.75	±5%
2.36	±4%
1.18	±4%
0.300	±4%
0.150	±4%
0.075	±1.5%

Note: If more than 20% of the individual sieves are out of the gradation tolerances, or if more than 20% of the asphalt binder content test results fall outside the appropriate tolerances, the RAP shall not be used in HMA unless the RAP representing the failing tests is removed from the stockpile.

Do not add additional material to any approved RAP stockpile, unless otherwise approved by the Engineer.

Maintain at the plant site a record system for all approved RAP stockpiles. Include at a minimum the following: Stockpile identification and a sketch of all stockpile areas at the plant site; all RAP test results (including asphalt content, gradation, and asphalt binder characteristics).

**(2) Mix Production RAP**

During mix production, use RAP that meets the criteria for one of the following categories:

**(a) Mix Design RAP**

RAP contained in the mix design stockpiles as described above may be used in all applicable JMFs. These stockpiles have been pretested; however, they are subject to required QC/QA testing in accordance with Subarticle 609-5(C)(2).

**(b) New Source RAP**

New Source RAP is defined as any acceptable material that was not included in the stockpile or other source when samples were taken for mix design purposes. Process new source RAP so that all materials have a uniform gradation and binder content and will pass a 2" sieve prior to introduction into the plant mixer unit.

After a stockpile of millings, processed RAP, or fractionated RAP has been sampled and mix designs made from these samples, do not add new source RAP to the original stockpile without prior field testing to insure gradation and binder uniformity. Sample and test new source RAP before blending with the existing stockpile.

Store new source RAP in a separate stockpile until the material can be sampled and tested for comparison with the original recycled mix design data. New source RAP may also be placed against the existing stockpile in a linear manner provided it is sampled for mix design conformity prior to its use in the recycled mix.

Unprocessed RAP is asphalt material that was not milled and/or has not been processed to obtain a uniform gradation and binder content and is not representative of the RAP used during the applicable mix design. Unprocessed RAP shall not be incorporated into any JMFs

prior to processing. Different sources of unprocessed RAP may be stockpiled together provided it is generally free of contamination and will be processed prior to use in a recycled mix. RAP contamination in the form of excessive dirt, debris, clean stone, concrete, etc. will not be allowed. Incidental amounts of dirt, concrete, and clean stone may be acceptable. Unprocessed RAP may be processed and then classified as a new source RAP as described above.

Field approval of new source RAP will be based on Table 1012-2 below and volumetric mix properties on the mix with the new source RAP included. Provided the Table 1012-2 tolerances are met, volumetric properties of the new mix will then be performed. If all volumetric mix properties meet the mix design criteria for that mix type, the new source RAP may continue to be used.

If the gradation, binder content, or any of the volumetric mix properties are not within the allowable tolerances of Table 1012-2, do not use the new source RAP unless approved by the Engineer. The Contractor may elect to either not use the stockpile, to request an adjustment to the JMF, or to redesign the mix.

**TABLE 1012-2**  
**NEW SOURCE RAP GRADATION and BINDER TOLERANCES**  
 (Apply Tolerances to Mix Design Data)

Mix Type	0-20% RAP			20 <sup>+</sup> -30 % RAP			30 <sup>+</sup> % RAP		
	Base	Inter.	Surf.	Base	Inter.	Surf.	Base	Inter.	Surf.
P <sub>b</sub> %	± 0.7%			± 0.4%			± 0.3%		
25.0	±10	-	-	±7	-	-	±5	-	-
19.0	±10	±10	-	±7	±7	-	±5	±5	-
12.5	-	±10	±10	-	±7	±7	-	±5	±5
9.5	-	-	±10	-	-	±7	-	-	±5
4.75	±10	-	±10	±7	-	±7	±5	-	±5
2.36	±8	±8	±8	±5	±5	±5	±4	±4	±4
1.18	±8	±8	±8	±5	±5	±5	±4	±4	±4
0.300	±8	±8	±8	±5	±5	±5	±4	±4	±4
0.150	-	-	±8	-	-	±5	-	-	±4
0.075	±4	±4	±4	±2	±2	±2	±1.5	±1.5	±1.5

**ASPHALT BINDER CONTENT OF ASPHALT PLANT MIXES:**

(1-1-02)

R6 R15

The approximate asphalt binder content of the asphalt concrete plant mixtures used on this project will be as follows:

Asphalt Concrete Base Course	Type B 25.0	4.3 %
Asphalt Concrete Intermediate Course	Type I 19.0	4.7 %
Asphalt Concrete Surface Course	Type S 4.75A	7.0 %
Asphalt Concrete Surface Course	Type SF 9.5A	6.5 %
Asphalt Concrete Surface Course	Type S 9.5	6.0 %
Asphalt Concrete Surface Course	Type S 12.5	5.5 %

The actual asphalt binder content will be established during construction by the Engineer within the limits established in the *2006 Standard Specifications*.

**QUALITY MANAGEMENT SYSTEM FOR ASPHALT PAVEMENTS:**

**(OGAFC, PADC, and ULTRATHIN HMA Version)**

(3-22-07)

SPI 6-1

**Description**

Produce and construct Open Graded Asphalt Friction Course, Permeable Asphalt Drainage Course, and Ultrathin Hot Mix Asphalt Concrete Wearing Surface asphalt mixtures and pavements. All materials and work shall conform to Division 6 of the *2006 Standard Specifications* except as modified herein. Perform all applicable quality control activities in accordance with the Department’s *Hot Mix Asphalt Quality Management System (HMA/QMS) Manual* unless otherwise approved.

**Description of Responsibilities**

(A) Quality Control (QC)

Provide and conduct a quality control program. A quality control program is defined as all activities, including mix design, process control inspection, plant and equipment calibration, sampling and testing, and necessary adjustments in the process that are related to production of a pavement which meets all requirements of the Specifications.

(B) Quality Assurance (QA)

The Department will conduct a quality assurance programs. A quality assurance program is defined as all activities, including inspection, sampling, and testing related to determining that the quality of the completed pavement conforms to specification requirements.

**Mix Design/Job Mix Formula Requirements**

All mix design and job mix formula requirements of Article 661-2 of the *2006 Standard Specifications* and the contract documents shall apply. In addition, submit Superpave gyratory compactor printouts for all specimens required to be compacted during the mix design process.



**Field Verification Of Mixture And Job Mix Formula Adjustments**

Conduct field verification of the mix at each plant within 30 calendar days prior to initial production of each mix design, when required by the Allowable Mix Adjustment Policy, and when directed as deemed necessary.

Field verification testing consists of performing a minimum of 1 test series on mix sampled and tested in accordance *Required Sampling and Testing Frequencies*. Obtain the mix verification sample and split in accordance with the Department's *HMA/QMS Manual*. Do not begin normal plant production until all field verification test results have been completed and the mix has been satisfactorily verified by the Contractor's Level II Technician. Verification is considered satisfactory when the mix meets all applicable individual test control limits as specified elsewhere in these provisions, except that the drain down test will meet the requirements as specified in Section 661 of the *2006 Standard Specifications* for the applicable mix type.

In addition to the required sampling and testing for field verification, perform all preliminary inspections and plant calibrations as shown in the *HMA/QMS Manual*.

Retain records of these calibrations and mix verification tests, including Superpave Gyratory Compactor (SGC) printouts, at the QC laboratory. In addition, furnish copies, including SGC printouts, to the Engineer for review and approval within 1 working day after beginning production of the mix.

Conduct the initial mix verification of all new mix designs with the plant set up to produce the aggregate blend and binder content in accordance with the initially approved job mix formula (JMF). If the Contractor and/or the Engineer determine from results of quality control tests conducted during mix verification that adjustments to the job mix formula are necessary to achieve specified mix properties, adjustments to the JMF may be made within tolerances permitted by specifications for the mix type being produced, subject to approval. All JMF adjustments will be approved and documented in writing by the Engineer.

Failure by the Contractor to fully comply with the above mix verification requirements will result in immediate production stoppage by the Engineer. Do not resume normal production until all mix verification sampling, testing, calibrations, and plant inspections have been performed and approved. Any mix produced that is not verified may be assessed a price reduction at the Engineer's discretion in addition to any reduction in pay due to mix and/or surface deficiencies.

**Contractor's Quality Control System****(A) Personnel Requirements**

Obtain all certifications in accordance with the Department's QMS Asphalt Technician Certification Program as shown in the *HMA/QMS Manual*. Perform all sampling, testing, data analysis and data posting by or under the direct supervision of a certified QMS Asphalt Plant Technician.

Provide a certified Asphalt Plant Technician Level I to perform quality control operations and activities at each plant site at all times during production of material for the project. A plant operator who is a certified Asphalt Plant Technician Level I may be utilized to meet this requirement when daily production for each mix design is less than 100 tons

provided the randomly scheduled increment sample is not within that tonnage. When performing in this capacity, the plant operator will be responsible for all quality control activities that are necessary and required. Absences of the Level I Technician, other than those for normal breaks and emergencies, shall be pre-approved by the appropriate QA Supervisor or his designated representative. Any extended absence of the Technician that has not been approved will result in immediate suspension of production by the Engineer. All mix produced during this absence will be accepted in accordance with Article 105-3 of the *2006 Standard Specifications*.

Provide and have readily available a certified Asphalt Plant Technician Level II to supervise, coordinate, and make any necessary adjustments in the mix quality control process in a timely manner. The Level II Technician may serve in a dual capacity and fulfill the Level I Technician requirements specified.

Provide a certified QMS Roadway Technician with each paving operation at all times during placement of asphalt. This person is responsible for monitoring all roadway paving operations and all quality control processes and activities, to include stopping production or implementing corrective measures when warranted.

Post in the quality control laboratory an organizational chart, including names, telephone numbers and current certification numbers of all personnel responsible for the quality control program while asphalt paving work is in progress.

(B) Field Laboratory Requirements

Furnish and maintain a Department certified laboratory at the plant site. A minimum of 320 square feet of floor space (exclusive of toilet facilities), equipment, and supplies necessary for performing Contractor quality control testing is required. Provide convenient telephone and fax machine access for QMS personnel at the plant site.

Provide testing equipment meeting the requirements of the test methods herein identified. Provide equipment that is properly calibrated and maintained. Allow all measuring and testing devices to be inspected to confirm both calibration and condition. If at any time the Engineer determines that the equipment is not operating properly or is not within the limits of dimensions or calibration described in the applicable test method, the Engineer may stop production until corrective action is taken. Maintain and have available a record of all calibration results at the laboratory.

(C) Plant Mix Quality Control

(1) General

Include in the quality control process the preliminary inspections, plant calibrations and field verification of the mix and JMF. In addition, conduct at a minimum but not limited to, the sampling, testing, and determination of all parameters outlined in these provisions using test methods and minimum frequencies as specified herein. Perform additional sampling and testing when conditions dictate. Obtain, split, and retain all scheduled samples at randomly selected locations in accordance with the Department's *HMA/QMS Manual*, except as modified below. Log all samples taken on forms provided by the Department. Provide documentation. Identify any additional quality control

samples taken and tested at times other than the regularly scheduled random samples or directed samples that take the place of regularly scheduled as process control (PC) samples on the appropriate forms. Process Control test results shall not be plotted on control charts nor reported to Quality Assurance Laboratory.

Obtain minimum 25 lb. samples for PADC and Ultrathin HMA. Split and retain in accordance with procedures in the Department's *HMA/QMS Manual*. For OGAF C Types FC-1, FC-1 Modified and FC-2 Modified, obtain minimum 1500-2000 gram samples each for QC, QA, and for retained samples. OGAF C QC samples shall be tested immediately. Place QA samples and retained samples of OGAF C in lubricated gill cans and store for possible testing in accordance with the procedures established below.

Retain the untested split portion of quality control aggregate and mix samples and the tested TSR specimens for 5 calendar days at the plant site, commencing the day the samples are tested. Permission for disposal may be given by Quality Assurance personnel prior to these minimum storage periods. Retain the split portion of the Contractor's mix verification and referee mix samples until either procured by or permission for disposal is given by QA. Store all retained samples in a dry and protected location.

(2) Required Sampling and Testing Frequencies

All mix sampling, testing, data analysis and data posting shall be performed or directly supervised by a certified QMS Asphalt Plant Technician.

Maintain minimum test frequencies as established in the schedule below. Complete all tests within 24 hours of the time the sample is taken, unless specified otherwise within these provisions. Should the specified tests not be completed within the required time frame, cease production at that point until such time the tests are completed.

Should the Contractor's testing frequency fail to meet the minimum frequency requirements as specified, all mix without the specified test representation will be considered unsatisfactory. If the Engineer allows the mix to remain in place, payment will be made at 50 percent of the contract unit bid price for the mixture.

If desired, innovative equipment or techniques not addressed by these specifications to produce or monitor the production of mix may be utilized, subject to approval.

Quality Control Minimum Sampling and Testing Schedule

Sample and test the completed mixture from each mix design (OGAF C and Ultrathin HMA) or job mix formula (PADC) at the following minimum frequency during mix production:

<u>Accumulative Production Increment</u>	<u>Number of Samples per Increment</u>
500 tons	1

If production is discontinued or interrupted before the accumulative production increment tonnage is completed, continue the increment on the next production

day(s) until the increment tonnage is completed. Obtain a random sample within the specified increment at the location determined in accordance with the Department's *HMA/QMS Manual*. Conduct quality control sampling and testing on each random sample as scheduled below. When daily production of each mix design exceeds 100 tons and a regularly scheduled test series random sample location for that mix design is not reached during that day's production, perform a test series as scheduled below. This test series does not substitute for the regularly scheduled random sample for that increment.

Perform the following test series on all regularly scheduled random samples:

Asphalt Mixture - Sampled From Truck at Plant (AASHTO T-168 Modified) (Split Sample Required)

- (a) Asphalt Binder Content, % (Contractor may select either option below)
  - 1. Ignition Furnace (AASHTO T 308 Modified)
  - 2. Other (Contractor may request and use other means of determining percent asphalt binder subject to approval by the Engineer)
- (b) Gradation on Recovered Blended Aggregate from Mix Sample (AASHTO T-30 Modified) (Graded on all sieves specified on the job mix formula.)

In addition to the above schedule, conduct the following sampling and testing as indicated:

- (a) Aggregate Stockpile Gradations (AASHTO T 27 and T 11) (Sampled from stockpiles or cold feed system as follows; split samples not required)
  - 1. Coarse Aggregates (Approved Standard Sizes)
    - a. At beginning of production\*
    - b. Weekly thereafter\*
  - 2. Fine Aggregates (Stone Screenings, Natural Sands, Etc.)
    - a. At or within 1 week prior to mix verification (Gradations valid for multiple mix designs).
    - b. Weekly after mix verification \*
    - c. Anytime production is stopped due to plant mix gradation related problems.
  - 3. Reclaimed Asphalt Shingle Material (RAS) Binder Content and Gradation (AASHTO T 308 Modified or T 164 and AASHTO T 30 Modified) (sample from stockpiles or cold feed system at beginning of production and weekly thereafter). Have RAS approved for use in accordance with Article 1012-1 (F). (Split Sample Required)

\*In lieu of the aggregate stockpile gradations performed by QC personnel, gradation quality control data conducted by the aggregate producer, which is representative of the Contractor's current stockpiles, may be furnished.

- (b) Combined Aggregate Moisture Content (AASHTO T 255) Drum Plant Only (sampled from stockpiles or cold feed system a minimum of once daily).

- (c) Asphalt Drain Down Test Procedure, AASHTO T 305; Copy of procedure may be obtained from the Engineer. Mix sampled from truck at plant within the first day's production and weekly thereafter.  
**Note:** Drain Down Test not required for Permeable Asphalt Drainage Course.
- (d) Retained Tensile Strength (TSR) - (AASHTO T 283 Modified)  
**Note:** TSR only required for Ultrathin HMA.
1. Option 1  
 Mix sampled from truck at plant, tested, and results furnished to the Engineer within 7 calendar days after beginning production of each new mix design. From the split sample, QC will prepare and submit within 5 calendar days of the sample date, an additional set of specimens to the QA Lab for TSR testing (Split Sample Required).
  2. Option 2  
 Mix sampled from truck at plant with one set of specimens prepared by the Contractor and then tested jointly by QA and QC at a mutually agreed upon lab site within the first seven (7) calendar days after beginning production of each new mix design. Specimens shall be tested on either a recording test press or a test press that maintains the peak load reading after the specimen has broken.

Additional TSR testing required prior to mix production in accordance with above procedures is required when a change is made in anti-strip additive dosage or when a new anti-strip additive source or grade is utilized, unless otherwise approved. Other TSR test(s) may be directed as deemed necessary. TSR testing not required for mix verification, but may be performed at that time.

(3) Control Charts

Maintain standardized control charts furnished by the Department at the field laboratory. For mix incorporated into the project, record test data from all regularly scheduled random samples or directed samples which replace regularly scheduled random samples, on control charts the same day the tests results are obtained. Process Control (PC) test results shall not be plotted on control charts nor reported to Quality Assurance Laboratory.

Results of quality assurance tests performed by the Engineer will be posted on the Contractor's control charts as data becomes available.

Record the following data on the standardized control charts:

- (a) Aggregate Gradation Test Results:
1. 1/2" (Types P57 & FC-2 Mod. Only)
  2. 3/8" (Excluding Type P57)
  3. No. 4
  4. No. 8
  5. No. 200 Sieves

- (b) Binder Content, %,  $P_b$   
 Both the individual test values and the moving average of the last 4 data points shall be plotted on each chart. The Contractor's test data shall be shown in black and the moving average in red. The Engineer's assurance data will be plotted in blue. Denote the warning control limits with a dash green line, the moving average control limits with a dashed blue line, and individual test limits with a dash red line.  
 Maintain a continuous moving average with the following exceptions. Re-establish a new moving average only when:
1. A change in the binder percentage or aggregate blend is made in the JMF, or,
  2. When the Contractor elects to stop or is required to stop production after one or two moving average values, respectively, fall outside the warning limits or,
  3. If failure to stop production after two consecutive moving averages exceed the warning limits occurs, but production does stop at a subsequent time, re-establish a new moving average beginning at the actual production stop point.

In addition, re-establish the moving averages for all mix properties. Moving averages will not be re-established when production stoppage occurs due to an individual test result exceeding the individual test limits and/or specifications.

All individual test results for regularly scheduled samples or directed samples which replace regularly scheduled samples are part of the plant quality control record and shall be included in moving average calculations with the following exception. When the Contractor's testing data has been proven incorrect, use the correct data as determined by the Engineer in lieu of the Contractor's data to determine the appropriate pay factor. In this case, replace the data in question and any related data proven incorrect.

(4) Control Limits

The following are established as control limits for mix production. Control limits for the warning and moving average limits are based on a moving average of the last 4 data points. Apply all control limits to data given on the job mix formula.

<b>Mix Control Criteria</b>	<b>Control Limits,</b>		
	<b>%</b>		
	<b>Warning</b>	<b>Moving Average</b>	<b>Individual Test</b>
Asphalt Binder Content	+/-0.3	+/-0.5	+/-0.7
1/2" Sieve (Types P57 & FC-2 Mod)	+/-4.0	+/-5.0	+/-8.0
3/8" Sieve (Excluding Type P57)	+/-4.0	+/-5.0	+/-8.0
No. 4 Sieve	+/-4.0	+/-5.0	+/-8.0
No. 8 Sieve	+/-4.0	+/-5.0	+/-8.0
No. 200 Sieve	+/-1.5	+/-2.0	+/-2.5
TSR (Ultrathin Only)	N/A	N/A	15%

(5) Warning Bands

Warning bands are defined as the area between the warning limits and moving average limits

(6) Corrective Actions

All required corrective actions are based upon initial test results and shall be taken immediately upon obtaining those results. In the event situations occur that warrant more than one corrective action and/or adjustment, give precedence to the more severe of these actions. Stopping production when required takes precedence over all other corrective actions. Document all corrective actions.

Immediately cease production and immediately notify the Engineer when any of the following occur:

- (a) When an individual test result for a mix control criteria exceeds both the individual test control limits and the applicable specification design criteria, or,
- (b) When two consecutive field TSR values fail to meet the minimum specification requirement, or,
- (c) When two consecutive binder content test results exceed the individual limits.

Do not resume normal plant production until one of the following has occurred:

- (a) Option 1 - Approval has been granted by the appropriate QA Supervisor.
- (b) Option 2 - The mix in question has been satisfactorily verified. Normal production may resume based on the approval of the contractor's Level II technician, provided notification and the verification test results have been furnished to the QA Laboratory.

Failure to fully comply with one of the above provisions will result in immediate production stoppage by the Engineer. Normal production shall not then resume until a complete reverification process has been performed and approved by the Engineer.

Acceptance of all mix failing to meet the individual test control or minimum TSR requirements as described above will be determined in accordance with Article 105-3. In addition, any mix, which is deemed unacceptable, will be rejected for use in the work.

Failure to stop production when required due to an individual mix test not meeting the specified requirements shall subject all mix from the stop point tonnage to the point when the next individual test is back on or within the warning limits, or to the tonnage point when production is actually stopped, whichever occurs first, to being considered unacceptable.

Failure to stop production when required due to two consecutive TSR tests failing to meet the specification requirements will subject all mix from the stop point tonnage to the point when the next TSR test meets or exceeds the specification requirement, or to the tonnage point when production is actually stopped, whichever occurs first, to being considered unacceptable.

In either case, remove and replace this mix with materials that comply with the specifications at no additional costs to the Department, unless otherwise approved. Payment will be made for the actual quantities of materials required to replace the removed quantities, not to exceed the original amounts.

Immediately notify the Engineer when any moving average value exceeds the warning limit. If two consecutive moving average values for any one of the mix control criteria fall outside the warning limits, cease production of that mix and make adjustments. The Contractor may elect to stop production after only one moving average value falls outside the warning limits. In either case, do not determine a new moving average until the fourth test after the elective or mandatory stop in production.

Do not resume normal plant production until one of the following has occurred:

- (a) Option 1 - Approval has been granted by the appropriate QA Supervisor.
- (b) Option 2 - The mix in question has been satisfactorily verified. Normal production may resume based on the approval of the contractor's Level II technician, provided notification and the verification test results have been furnished to the QA Laboratory.

Failure to fully comply with one of the above provisions will result in immediate production stoppage by the Engineer. Normal production shall not then resume until a complete reverification process has been performed and approved by the Engineer.

If the process adjustment improves the property in question such that the moving average after four additional tests is on or within the warning limits, the Contractor may continue production with no reduction in payment.

If the adjustment does not improve the property in question such that the moving average after four additional individual tests stays in the warning bands, the mix will be considered not to be within reasonably close conformity, but reasonably acceptable. Reduced payment for the mix in question will be applied starting from the plant sample tonnage at the stop point to the sample tonnage when the moving average is on or within the warning limits in accordance with the following table.

**Payment for Mix Produced in the Warning Bands**

<b>Mix Property</b>	<b>Pay Factor Percent Bid Price for Mix**</b>
1/2" Sieve (Types P57 & FC-2 Mod. Only)	90
3/8" (Excluding Type P57)	90
No. 4	90
No. 8	90
No. 200	90
Asphalt Binder Content	85

\*\* When two or more properties are in question, only the lower pay factor will be applied to the mix unit bid price.

If the adjustment does not improve the property in question such that the moving average after four additional tests exceeds the moving average control limits, the mix will be



considered not to be within reasonably close conformity with specifications. If the Engineer determines the mix is reasonably acceptable based on test data and an inspection of the completed pavement and allows it to remain in place, the mix will be accepted in accordance with Article 105-3. If the mix is determined to be unacceptable, the mix will be removed and replaced with materials that comply with the specifications. In either case, the adjustment or removal, respectively, for the mix in question will be applied starting from the plant sample tonnage at the stop point to the sample tonnage when the moving average is on or within the warning limits. In addition, any mix that is deemed unacceptable will be rejected for use in the work.

Failure to stop production and make adjustments when required due to two consecutive moving average values falling outside the warning limits will subject all mix produced from the stop point tonnage to the tonnage point when the moving average is back on or within the warning limits or to the tonnage point when production is actually stopped, whichever occurs first, to being considered unacceptable. Remove this material and replaced with materials which comply with the specifications at no additional costs to the Department, unless otherwise approved. Payment will be made for the actual quantities of materials required to replace the removed quantities, not to exceed the original amounts.

(7) Allowable Retesting for Mix Deficiencies

The Contractor may elect to resample and retest for plant mix deficiencies when individual QC test(s) exceed one or more mix property target(s) by more than the tolerances indicated below. Perform the retesting within 10 days after initial test results are determined. Retesting shall be approved prior to being performed and in accordance with the Department's Guidelines for Retests of Plant Mix Deficiencies as shown in the *HMA/QMS Manual*. The Contractor, under the supervision of the Department's QA personnel will perform these retests. Retests for any mix deficiency other than as listed below will not be allowed unless otherwise permitted. Acceptance of the mix in question will be based on the retest data in accordance with Article 105-3.

The Department reserves the right to require the Contractor to resample and retest at any time or location as directed.

(a) % Binder Content	--	by more than +/- 1.0%
(b) 1/2" Sieve (Types P 57 & FC-2 Mod)	--	by more than +/- 9.0%
(c) 3/8" Sieve (Excluding Type P 57)	--	by more than +/- 9.0%
(d) No. 4 sieve	--	by more than +/- 9.0%
(e) No. 8 sieve	--	by more than +/- 9.0%
(f) No. 200 sieve	--	by more than +/- 3.0%
(g) TSR (Ultrathin only)	--	by more by more than -15% from Specification limit

(8) Documentation (Records)

Document all quality control observations, records of inspection, samples taken, adjustments to the mix, and test results on a daily basis. Note the results of

observations and records of inspection as they occur in a permanent field record. Record adjustment to mix production and test results on forms provided.

Identify any additional quality control samples taken and tested at times other than the regularly scheduled random samples or directed samples which take the place of regularly scheduled as process control (PC) samples on the appropriate forms. Process Control test results shall not be plotted on control charts nor reported to Quality Assurance Laboratory. Process control sample test results are for the Contractor's informational purposes only.

Make all such records available to the Engineer, upon request, at any time during project construction. Complete all QC records and forms and distribute in accordance with the most current edition of the Department's *HMA/QMS Manual*. Maintain all QC records, forms and equipment calibrations for a minimum of 3 years from their completion date. Failure to maintain QC records and forms as required, or to provide these records and forms to the Engineer upon request, may result in production and/or placement stoppage until the problem is resolved.

Falsification of test results, documentation of observations, records of inspection, adjustments to the process, discarding of samples and/or test results, or any other deliberate misrepresentation of the facts will result in the revocation of the applicable person's QMS certification. The Engineer will determine acceptability of the mix and/or pavement represented by the falsified results or documentation. If the mix and/or pavement in question is determined to be acceptable, the Engineer may allow the mix to remain in place at no pay for the mix, asphalt binder and other mix components. If the mix and/or pavement represented by the falsified results are determined not to be acceptable, remove and replace with mix that complies with the Specifications. Payment will be made for the actual quantities of materials required to replace the falsified quantities, not to exceed the original amounts.

### **Quality Assurance**

The Department's quality assurance program will be conducted by a certified QMS technician(s) and will be accomplished in the following ways:

#### **Plant Mix Quality Assurance**

- (A) By conducting assurance testing of split samples obtained by the Contractor at a frequency equal to or greater than 5% of the frequency required of the Contractor;
- (B) By periodically observing sampling and testing procedures performed by the Contractor;
- (C) By monitoring required control charts exhibiting test results of control parameters;
- (D) By directing the Contractor to take additional samples at any time and any location during production (in lieu of the next scheduled random sample for that increment);
- (E) By conducting verification sampling and testing on samples taken independently of the Contractor's quality control samples at a frequency equal to or greater than 10% of the QC sample frequency; or

(F) By any combination of the above

The Engineer will periodically obtain quality assurance and verification samples for testing independently of the Contractor's quality control process. The Engineer will conduct assurance tests on both split QC samples taken by the Contractor and verification samples taken by the Department. These samples may be the regular quality control samples or a sample selected by the Engineer from any location in the process, or verification samples taken at random by the Department. The Engineer may select any or all split samples for assurance testing.

Results of quality assurance tests will be provided to the Contractor within 3 working days after the sample has been obtained, except for verification TSR test results which will be provided within 7 calendar days.

#### Limits of Precision

Differences between the Contractor's and the Department's split sample test results will be considered acceptable if within the following limits of precision:

<b>Mix Property</b>	<b>Acceptable Limits of Precision</b>
Asphalt Binder Content	±0.5 %
1/2" Sieve (Types P 57 & FC-2 Mod. Only)	±6.0 %
3/8" Sieve (Excluding Type P 57)	±5.0 %
No. 4 Sieve	±5.0 %
No. 8 Sieve	±5.0 %
No. 200 Sieve	±2.0 %
TSR (Ultrathin HMA Only)	±15.0 %

The Engineer will immediately investigate the reason for differences if any of the following occur:

- (A) QA test results of QC split sample does not meet above limits of precision, or
- (B) QA test results of QC split sample does not meet the individual test control limits or the specification requirements, or
- (C) QA verification sample test results exceed the allowable retesting tolerances.

If the potential for a pavement failure exist, the Engineer may suspend production, wholly or in part, in accordance with Article 108-7 while the investigation is in progress. The Engineer's investigation may include, but not be limited to the following:

- (A) Joint testing of any remaining split samples,
- (B) Review and observation of the QC technician's sampling and testing procedures,
- (C) Evaluation and calibration of QC testing equipment, and/or
- (D) Comparison testing of other retained quality control samples

If additional mix samples or core samples are necessary to resolve the difference, these samples will be taken as directed and tested jointly by the Contractor's quality control and Department's quality assurance personnel. If reasons for the difference cannot be determined, payment for the

mix in question will be determined in accordance with Article 105-3. If the reason for the difference is determined to be an error or other discrepancy in the quality control test results, the applicable quality assurance test results or verification test results will be used to determine compliance with the applicable mix specification requirements.

The Engineer will periodically witness the sampling and testing being performed by the Contractor. If the Engineer observes that the sampling and quality control tests are not being performed in accordance with the applicable test procedures, the Engineer may stop production until corrective action is taken. The Engineer will promptly notify the Contractor of observed deficiencies, both verbally and in writing. The Engineer will document all witnessed samples and tests.

### **Acceptance**

The Engineer will base final acceptance of the mix on the results of random testing made on split samples during the assurance process and validation of the Contractor's quality control process.

### **Measurement and Payment**

Produce and construct all asphalt mixtures and pavements in accordance with these Specifications. There will be no direct payment for work covered by this specification. Payment at the contract unit prices for the various asphalt items will be full compensation for all work covered by these specifications.

### **PRICE ADJUSTMENT - ASPHALT BINDER FOR PLANT MIX:**

(11-21-00)

R6 R25

Price adjustments for asphalt binder for plant mix will be made in accordance with Section 620 of the *2006 Standard Specifications*.

The base price index for asphalt binder for plant mix is **\$408.00** per ton.

This base price index represents an average of F.O.B. selling prices of asphalt binder at supplier's terminals on **September 1, 2009**.

### **RESURFACING EXISTING BRIDGES:**

(7-1-95)

R6 R61

The Contractor's attention is directed to the fact that he will be required to resurface the bridges on this project if directed by the Engineer.

Place the surface so as to follow a grade line set by the Engineer with the minimum thickness as shown on the sketch herein or as directed by the Engineer. State Forces will make all necessary repairs to the bridge floors prior to the time that the Contractor places the proposed surfacing. Give the Engineer at least 15 days notice prior to the expected time to begin operations so that State Forces will have sufficient time to complete their work.

At all bridges that are not to be resurfaced, taper out the proposed resurfacing layer adjacent to the bridges to insure a proper tie-in with the bridge surface.

**REMOVAL OF EXISTING CONCRETE PAVEMENT SLABS:****Description:**

The work covered by these provisions consists of removing existing concrete pavement slabs and undercutting loose material at locations as directed by the Engineer. The slab removal shall be performed in a manner to minimize damage to the adjacent slabs and underlying base material. Concrete slabs to be removed are approximately 12 ft. by 30 ft. non-continuous, non-reinforced with a thickness of approximately 9.5 inches.

**Construction:**

The extent of slab removal shall be as directed by the Engineer.

When necessary, the slab to be removed shall be sawed full depth on its sides adjacent to existing slabs, including existing transverse and longitudinal joints where applicable. When necessary to prevent shoulder damage, an additional cut shall be made in the adjacent shoulder joint. The defective slab shall be removed in a minimum of three (3) sections, with the middle section removed first in a manner to minimize damage of the adjacent slabs.

All existing unitube material, existing joint material, and debris shall be removed from the existing transverse and longitudinal joints which are exposed by the slab removal before the slab is replaced. All loose underlying base material, earth material and/or subseal grout shall be undercut to sound well compacted base. This material will be considered undercut excavation.

Aggregate Base Course will be placed on Fabric for Soil Stabilization in areas of undercut under removed slabs. Aggregate Base Course will be placed in 12" depths according to the Typical Section and as directed by the Engineer.

The Contractor may develop and submit an alternate method of slab removal for approval by the Engineer which satisfactorily avoids damage to the adjacent slabs and underlying base material.

**Method of Measurement:**

The quantity of pavement removal, full slab or partial slab, will be the actual number of square yards removed and disposed of. The quantity will be determined by actual surface measurement of pavement prior to its removal.

**Basis of Payment**

The quantity of pavement removal measured as provided above will be paid for at the contract unit price per square yard for "Removal of Existing Concrete Pavement Slabs".

Aggregate Base Course will be measured and paid for in accordance with Article 520-11 of the Standard Specifications.

Undercut excavation will be measured and paid for in accordance with Section 225 of the Standard Specifications.

Payment will be made under:

<u>Pay Item</u>	<u>Pay Unit</u>
Removal of the Existing Concrete Pavement Slabs.....	Square Yard
Undercut Excavation.....	Cubic Yard
Aggregate Base Course.....	Ton
Fabric for Soil Stabilization.....	Square Yard

The above price and payment will be full compensation for all work covered by this provision for furnishing all labor, materials, tools, equipment, sawing, removal of loose underlying base material and/or subseal grout, and satisfactory disposal of the concrete and existing ultrathin overlay and any underlying base material or subseal grout as directed.

**PATCHING EXISTING MILLED RUMBLE STRIPS:**

In order to completely fill in the depressed areas the Contractor shall patch the existing milled rumble strips prior to paving operations as directed by the Engineer.

Patch material shall meet the requirements of Section 610 of the Standard Specifications for Asphalt concrete Surface Course, Type S4.75A.

No separate payment will be made for Patching Existing Milled Rumble Strips as the cost of such work shall be incidental to other paving items in the contract.

**SEALING EXISTING PAVEMENT CRACKS AND JOINTS:**

Sealing Existing Pavement Cracks and Joints shall be in accordance with Section 657 of the 2006 *Standard Specifications* and the following:

Revise the 2006 *Standard Specifications* as follows:

**Page 6-66, Article 657-1, Description, delete the second sentence and add the following:**

The Contractor will be required to seal the existing edge joints.

**BORROW EXCAVATION AND SHPO DOCUMENTATION FOR BORROW/WASTE SITES:**

(12-18-07)(4-15-08)

R8 R02

Revise the 2006 *Standard Specifications* as follows:

**Division 2 Earthwork**

**Page 2-16, Subarticle 230-1(D),** add the words: *The Contractor specifically waives* as the first words of the sentence.

**Page 2-17, Article 230-4(B) Contractor Furnished Sources, first paragraph, first sentence replace with the following:**

Prior to the approval of any borrow sources developed for use on any project, obtain certification from the State Historic Preservation Officer of the State Department of Cultural Resources certifying that the removal of the borrow material from the borrow sources(s) will have no effect on any known district, site building, structure, or object, architectural and/or archaeological that is included or eligible for inclusion in the National Register of Historic Places.

**Division 8 Incidentals**

**Page 8-9, Article 802-2 General Requirements, add the following as the 1st paragraph:**

Prior to the removal of any waste from any project, obtain certification from the State Historic Preservation Officer of the State Department of Cultural Resources certifying that the deposition of the waste material to the proposed waste area will have no effect on any known district, site building, structure, or object, architectural and/or archaeological that is included or eligible for inclusion in the National Register of Historic Places. Furnish a copy of this certification to the Engineer prior to performing any work in the proposed waste site.

**Page 8-10, Article 802-2, General Requirements, 4th paragraph, add the following as the 2nd sentence:**

The Department's borrow and waste site reclamation procedures for contracted projects is available on the NCDOT website and shall be used for all borrow and waste sites on this project.

**AGGREGATE PRODUCTION:**

(11-20-01) (Rev. 11-21-06)

R10 R05

Provide aggregate from a producer who uses the current Aggregate Quality Control/Quality Assurance Program which is in effect at the time of shipment.

No price adjustment is allowed to contractors or producers who use the program. Participation in the program does not relieve the producer of the responsibility of complying with all requirements of the *2006 Standard Specifications*. Copies of this procedure are available upon request from the Materials and Test Unit.

**CONCRETE BRICK AND BLOCK PRODUCTION:**

(11-20-01) (Rev. 11-21-06)

R10 R10

Provide concrete brick and block from a producer who uses the current Solid Concrete Masonry Brick/Unit Quality Control/Quality Assurance Program that is in effect on the date that material is received on the project.

No price adjustment is allowed to contractors or producers who use the program. Participation in the program does not relieve the producer of the responsibility of complying with all

requirements of the *2006 Standard Specifications*. Copies of this procedure are available upon request from the Materials and Test Unit.

**AGGREGATES FOR ASPHALT PAVEMENTS AND SURFACE TREATMENTS**

**(Ultra-Thin):**

(7-18-06)

R10 R15

Revise the *2006 Standard Specifications* as follows:

**Page 10-40, Subarticle 1012-1(A)**, add the following at the end of the last paragraph, last sentence:

or ultra-thin bonded wearing course.

**Page 10-41, Table 1012-1**, add the following as the last row of the Table:

UBWC	100/85	40	45	10
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**Page 10-42, Subarticle 1012-1(B)(6)**, add as the last sentence:

The percentage loss for aggregate used in UBWC shall be no more than 35%.

**GLASS BEADS:**

(7-18-06)

R10 R35

Revise the *2006 Standard Specifications* as follows:

**Page 10-223, 1087-4(C) Gradation & Roundness**

Replace the second sentence of the first paragraph with the following:

*All Drop-On and Intermixed Glass Beads shall be tested in accordance with ASTM D1155.*

Delete the last paragraph.

**ENGINEERING FABRICS TABLE 1056-1:**

(7-18-06)

R10 R40

Revise the *2006 Standard Specifications* as follows:

**Page 10-100, Table 1056-1**, replace the values for Trapezoidal Tear Strength with the following:

Physical Property	ASTM Test Method	Type 1	Type 2	Type 3		Type 4
				Class A	Class B	
Typical Applications		Shoulder Drain	Under Riprap	Temporary Silt Fence		Soil Stabilization
Trapezoidal Tear Strength	D4533	45 lb	75 lb	--	--	75 lb



