

SECTION TABLE OF CONTENTS DIVISION 32 - EXTERIOR IMPROVEMENTS

SECTION 32 12 15.13 ASPHALT PAVING FOR AIRFIELDS

11/17

Table of Contents

PART 1	GENERAL	2
1.1	REFERENCES	2
1.2	SUBMITTALS	4
1.3	QUALITY CONTROL	5
1.4	ENVIRONMENTAL REQUIREMENTS	7
PART 2	PRODUCTS	7
2.1	SYSTEM DESCRIPTION	7
2.2	AGGREGATES	10
2.3	ASPHALT CEMENT BINDER	11
2.4	MIX DESIGN	12
2.5	RECYCLED ASPHALT PAVEMENT	13
PART 3	EXECUTION	13
3.1	CONTRACTOR QUALITY CONTROL	13
3.2	PREPARATION OF ASPHALT BINDER MATERIAL	17
3.3	PREPARATION OF MINERAL AGGREGATE	17
3.4	PREPARATION OF HOT-MIX ASPHALT MIXTURE	17
3.5	PREPARATION OF THE UNDERLYING SURFACE	17
3.6	TEST SECTION	17
3.7	TESTING LABORATORY	18
3.8	TRANSPORTING AND PLACING	19
3.9	COMPACTION OF MIXTURE	19
3.10	JOINTS	20

SECTION 32 12 15.13
ASPHALT PAVING FOR AIRFIELDS
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PART 1 GENERAL.

1.1 REFERENCES.

The publications listed below form a part of this specification to the extent referenced. The publications are referred to within the text by the basic designation only.

AMERICAN ASSOCIATION OF STATE HIGHWAY AND TRANSPORTATION OFFICIALS
(AASHTO)

- | | |
|--------------|---|
| AASHTO M 156 | (2013; R 2017) Standard Specification for Requirements for Mixing Plants for Hot-Mixed, Hot-Laid Bituminous Paving Mixtures |
| AASHTO M 320 | (2017) Standard Specification for Performance-Graded Asphalt Binder |
| AASHTO T 304 | (2011; R 2015) Standard Method of Test for Uncompacted Void Content of Fine Aggregate |
| AASHTO T 308 | (2016) Standard Method of Test for Determining the Asphalt Binder Content of Hot Mix Asphalt (HMA) by the Ignition Method |
| AASHTO T 329 | (2015) Standard Test Method for Moisture Content of Hot Mix Asphalt (HMA) by Oven Method |

ASPHALT INSTITUTE (AI)

- | | |
|---------|-----------------------------------|
| AI MS-2 | (2015) Asphalt Mix Design Methods |
|---------|-----------------------------------|

ASTM INTERNATIONAL (ASTM)

- | | |
|---------------|---|
| ASTM C29/C29M | (2017a) Standard Test Method for Bulk Density ("Unit Weight") and Voids in Aggregate |
| ASTM C88 | (2018) Standard Test Method for Soundness of Aggregates by Use of Sodium Sulfate or Magnesium Sulfate |
| ASTM C117 | (2017) Standard Test Method for Materials Finer than 75-um (No. 200) Sieve in Mineral Aggregates by Washing |
| ASTM C127 | (2015) Standard Test Method for Density, Relative Density (Specific Gravity), and |

	Absorption of Coarse Aggregate
ASTM C128	(2015) Standard Test Method for Density, Relative Density (Specific Gravity), and Absorption of Fine Aggregate
ASTM C131/C131M	(2020) Standard Test Method for Resistance to Degradation of Small-Size Coarse Aggregate by Abrasion and Impact in the Los Angeles Machine
ASTM C136/C136M	(2019) Standard Test Method for Sieve Analysis of Fine and Coarse Aggregates
ASTM C142/C142M	(2017) Standard Test Method for Clay Lumps and Friable Particles in Aggregates
ASTM C566	(2013) Standard Test Method for Total Evaporable Moisture Content of Aggregate by Drying
ASTM D75/D75M	(2019) Standard Practice for Sampling Aggregates
ASTM D140/D140M	(2016) Standard Practice for Sampling Asphalt Materials
ASTM D242/D242M	(2009; R 2014) Mineral Filler for Bituminous Paving Mixtures
ASTM D946/D946M	(2020) Standard Specification for Penetration-Graded Asphalt Cement for Use in Pavement Construction
ASTM D979/D979M	(2015) Sampling Bituminous Paving Mixtures
ASTM D1461	(2017) Standard Test Method for Moisture or Volatile Distillates in Asphalt Mixtures
ASTM D2041/D2041M	(2011) Theoretical Maximum Specific Gravity and Density of Bituminous Paving Mixtures
ASTM D2172/D2172M	(2017; E 2018) Standard Test Methods for Quantitative Extraction of Asphalt Binder from Asphalt Mixtures
ASTM D2419	(2014) Sand Equivalent Value of Soils and Fine Aggregate
ASTM D2489/D2489M	(2016) Standard Test Method for Estimating Degree of Particle Coating of Asphalt Mixtures
ASTM D2726/D2726M	(2019) Standard Test Method for Bulk Specific Gravity and Density of Non-Absorptive Compacted Bituminous Mixtures
ASTM D3203/D3203M	(2017) Standard Test Method for Percent

ASTM D3665	Air Voids in Compacted Asphalt Mixtures (2012; R 2017) Standard Practice for Random Sampling of Construction Materials
ASTM D3666	(2016) Standard Specification for Minimum Requirements for Agencies Testing and Inspecting Road and Paving Materials
ASTM D4125/D4125M	(2010) Asphalt Content of Bituminous Mixtures by the Nuclear Method
ASTM D4791	(2019) Flat Particles, Elongated Particles, or Flat and Elongated Particles in Coarse Aggregate
ASTM D4867/D4867M	(2009; R 2014) Effect of Moisture on Asphalt Concrete Paving Mixtures
ASTM D5444	(2015) Mechanical Size Analysis of Extracted Aggregate
ASTM D5821	(2013; R 2017) Standard Test Method for Determining the Percentage of Fractured Particles in Coarse Aggregate
ASTM D6307	(2019) Standard Test Method for Asphalt Content of Asphalt Mixture by Ignition Method
ASTM D6925	(2014) Standard Test Method for Preparation and Determination of the Relative Density of Hot Mix Asphalt (HMA) Specimens by Means of the Superpave Gyratory Compactor
ASTM D6926	(2020) Standard Practice for Preparation of Asphalt Mixture Specimens Using Marshall Apparatus
ASTM D6927	(2015) Standard Test Method for Marshall Stability and Flow of Bituminous Mixtures
ASTM E1274	(2018) Standard Test Method for Measuring Pavement Roughness Using a Profilograph

1.2 SUBMITTALS.

Government approval is required for submittals with a "G" designation; submittals not having a "G" designation are for information only. When used, a designation following the "G" designation identifies the government officer that will review the submittal for the Government.

SD-02 Shop Drawings

Placement Plan; G, COR

SD-03 Product Data

Diamond Grinding Plan; G, COR

Mix Design; G, COR
Contractor Quality Control; G, COR

SD-06 Test Reports

Aggregates; G, COR
QC Monitoring

SD-07 Certificates

Asphalt Cement Binder; G, COR
Testing Laboratory
Warm-mix Additive

1.3 QUALITY CONTROL.

1.3.1 Sublot Sampling

Total area of a lot is 30,000 square feet. For projects with less than 30,000 square feet, the entire project can be considered as a single lot. One random mixture sample for determining laboratory air voids, theoretical maximum density, and for any additional testing the COR specifies, will be taken from a loaded truck delivering mixture to each sublot, or other appropriate location for each sublot. All samples will be selected randomly, using commonly recognized methods of assuring randomness conforming to ASTM D3665 and employing tables of random numbers or computer programs. Laboratory air voids will be determined from three laboratory compacted specimens of each sublot sample in accordance with ASTM 3203/D3203M. The specimens will be compacted within 2 hours of the time the mixture was loaded into trucks at the asphalt plant. Samples will not be reheated prior to compaction and insulated containers will be used as necessary to maintain the temperature.

1.3.2 In-place Density

For determining in-place density, obtain one random core (4 inches or 6 inches in diameter) at locations identified by the COR from the mat (interior of the lane and at least 12 inches from longitudinal joint or pavement edge) of each sublot, and one random core taken from the joint (immediately over joint) of each sublot, in accordance with ASTM D979/D979M. Fill all core holes with asphalt pavement and compact using a standard Marshall hammer to a mat density as specified. Tack coat dry core holes before filling. Each random core will be full thickness of the layer being placed. When the random core is less than 1 inch thick, it will not be included in the analysis. In this case, another random core will be taken. After air drying to meet the requirements for laboratory-prepared, thoroughly dry specimens, cores obtained from the mat and from the joints will be used for in-place density determination in accordance with ASTM D2726/D2726M.

1.3.3 Surface Smoothness

Use a straightedge and profilograph for measuring surface smoothness of runway pavements. Use a straightedge for measuring surface smoothness of all other pavement surfaces. Perform all testing in the presence of the COR. Maintain detailed notes of the testing results and provide a copy to the COR immediately after each day's testing. Where drawings show required deviations from a plane surface (for instance crowns, drainage inlets), finish the surface to meet the approval of the COR.

1.3.3.1 Smoothness Requirements

1.3.3.1.1 Straightedge Testing

Provide finished surfaces of the pavements with no abrupt change of $1/8$ inch or more, and all pavements within the tolerances specified in Table 3 when checked with an approved 12 foot straightedge.

Table 3. Straightedge Surface Smoothness--Pavements		
Pavement Category	Direction of Testing	Tolerance, inch
Runways and taxiway	Longitudinal	1/8
	Transverse	1/4
Shoulders (outside edge stripe)	Longitudinal	1/4
	Transverse	1/4
Calibration hardstands and compass swinging bases	Longitudinal	1/8
	Transverse	1/8
All other airfields and helicopter paved areas	Longitudinal	1/4
	Transverse	1/4

1.3.3.1.2 Profilograph Testing

Provide finished surfaces of runways with a Profile Index not greater than 7 inches per mile when tested with an approved California-type profilograph.

1.3.3.2 Testing Method

After the final rolling, but not later than 24 hours after placement, test the surface of the pavement in each entire lot in a manner to reveal surface irregularities exceeding the tolerances specified above. If any pavement areas are diamond ground, retest these areas immediately after diamond grinding. The maximum area allowed to be corrected by diamond grinding is 10 percent of the total area of the lot. Test the entire area of the pavement with a profilograph. Check a number of random locations along with any observed suspicious locations primarily at transverse and longitudinal joints with the straightedge.

1.3.3.2.1 Straightedge Testing

Hold the straightedge in contact with the pavement surface and measure the maximum distance between the straightedge and the pavement surface. Determine the amount of surface irregularity by placing the freestanding

(unleveled) straightedge on the pavement surface and allowing it to rest upon the two highest spots covered by its length, and measuring the maximum gap between the straightedge and the pavement surface in the area between these two high points. Use the straightedge to measure abrupt changes in surface grade.

1.3.3.2.2 Profilograph Testing

Perform profilograph testing using an approved California profilograph and procedures described in [ASTM E1274](#). Provide equipment that utilizes electronic recording and automatic computerized reduction of data to indicate "must-grind" bumps and the Profile Index for the pavement. Use a "blanking band" that is [0.2 inch](#) wide and the "bump template" spanning [1 inch](#) with an offset of [0.4 inch](#). Provide profilograph operated by an approved, factory-trained operator on the alignments specified above.

Provide a copy of the reduced tapes to the [COR](#) at the end of each day's testing.

1.3.3.2.3 Bumps ("Must Grind" Areas)

Reduce any bumps ("must grind" areas) shown on the profilograph trace which exceed 0.4 inch in height by diamond grinding until they do not exceed 0.3 inch when retested. Taper diamond grinding in all directions to provide smooth transitions to areas not requiring diamond grinding. The following will not be permitted: (1) skin patching for correcting low areas, (2) planing or milling for correcting high areas. Perform additional profilograph testing in all areas corrected by diamond grinding.

1.4 ENVIRONMENTAL REQUIREMENTS.

Do not place asphalt pavement upon a wet surface or when the surface temperature of the underlying course is less than specified in Table 4. The temperature requirements may be waived by the [COR](#), if requested; provided all other requirements, including compaction, are met.

Table 4. Surface Temperature Limitations of Underlying Course	
Mat Thickness, inches	Degrees F
3 or greater	40
Less than 3	45

PART 2 PRODUCTS.

2.1 SYSTEM DESCRIPTION.

Perform the work consisting of pavement courses composed of mineral aggregate and asphalt material heated and mixed in a central mixing plant and placed on a prepared course. Provide hot-mix asphalt (HMA) warm-mix asphalt (WMA) pavement designed and constructed in accordance with this section conforming to the lines, grades, thicknesses, and typical cross sections shown on the drawings. Construct each course to the depth, section, or elevation required by the drawings and rolled, finished, and approved before the placement of the next course. Submit proposed Placement Plan, indicating lane widths, longitudinal joints, and transverse joints for each

course or lift.

2.1.1 Asphalt Mixing Plant

Provide plants used for the preparation of asphalt mixture conforming to the requirements of **AASHTO M 156** with the following changes:

2.1.1.1 Truck Scales

Weigh the asphalt mixture on approved scales, or on certified public scales at no additional expense to the Government. Inspect and seal scales at least annually by an approved calibration laboratory.

2.1.1.2 Inspection of Plant

Inspection of Plant. Provide access to the COR at all times, to all areas of the plant for checking adequacy of equipment; inspecting operation of the plant; verifying weights, proportions, and material properties; checking the temperatures maintained in the preparation of the mixtures and for taking samples. Provide assistance as requested, for the COR to procure any desired samples.

2.1.1.3 Storage Bins

The asphalt mixture may be stored in non-insulated storage bins for a period of time not exceeding 3 hours. The asphalt mixture may be stored in insulated storage bins for a period of time not exceeding 8 hours. Provide the mix drawn from bins that meets the same requirements as mix loaded directly into trucks.

2.1.2 Hauling Equipment

Provide trucks used for hauling asphalt mixture that have tight, clean, and smooth metal beds. To prevent the mixture from adhering to them, lightly coat the truck beds with a minimum amount of paraffin oil, lime solution, or other approved material. Do not use petroleum based products as a release agent. Provide each truck with a suitable cover to protect the mixture from adverse weather. When necessary to ensure that the mixture is delivered to the site at the specified temperature, provide insulated or heated truck beds with covers (tarps) that are securely fastened.

2.1.3 Asphalt Pavers

Provide mechanical spreading and finishing equipment consisting of a self-powered paver, capable of spreading and finishing the mixture to the specified line, grade, and cross section. Provide paver screed capable of laying a uniform mixture to meet the specified thickness, smoothness, and grade without physical or temperature segregation, the full width of the material being placed. Provide a screed equipped with a compaction device to be used during all placement.

2.1.3.1 Receiving Hopper

Provide paver with a receiving hopper of sufficient capacity to permit a uniform spreading operation and a distribution system to place the mixture uniformly in front of the screed without segregation. Provide a screed that effectively produces a finished surface of the required evenness and texture without tearing, shoving, or gouging the mixture.

2.1.3.2 Automatic Grade Controls

If an automatic grade control device is used, provide a paver equipped with a control system capable of automatically maintaining the specified screed elevation that is automatically actuated from either a reference line or through a system of mechanical sensors or sensor-directed mechanisms or devices which maintain the paver screed at a predetermined transverse slope and at the proper elevation to obtain the required surface. Provide transverse slope controller capable of maintaining the screed at the desired slope within plus or minus 0.1 percent. Do not use the transverse slope controller to control grade. Provide controls capable of working in conjunction with any of the following attachments:

- a. Ski-type device of not less than 30 feet in length.
- b. Taut stringline set to grade.
- c. Short ski or shoe for joint matching.
- d. Laser control.

2.1.4 Rollers

Provide rollers in good condition and operated at slow speeds to avoid displacement of the asphalt mixture. Provide sufficient number, type, and weight of rollers to compact the mixture to the required density while it is still in a workable condition. Do not use equipment which causes excessive crushing of the aggregate.

2.1.5 Diamond Grinding

Those performing diamond grinding are required to have a minimum of three years' experience in diamond grinding of airfield pavements. In areas not meeting the specified limits for surface smoothness and plan grade, reduce high areas to attain the required smoothness and grade, except as depth is limited below. Reduce high areas by diamond grinding the asphalt pavement with approved equipment after the asphalt pavement is at a minimum age of 14 days. Perform diamond grinding by sawing with saw blades impregnated with an industrial diamond abrasive. Assemble the saw blades in a cutting head mounted on a machine designed specifically for diamond grinding that produces the required texture and smoothness level without damage to the asphalt pavement or joint faces. Provide diamond grinding equipment with saw blades that are 1/8-inch wide, a minimum of 60 blades per 12 inches of cutting head width, and capable of cutting a path a minimum of 3 feet wide. Diamond grinding equipment that causes raveling, fracturing of aggregate, or disturbance to the underlying material will not be allowed. The maximum area corrected by diamond grinding the surface of the asphalt pavement is 10 percent of the total area of any subplot. The maximum depth of diamond grinding is 1/2 inch. Provide diamond grinding machine equipped to flush and vacuum the pavement surface. Dispose of all debris from diamond grinding operations off Government property. Prior to diamond grinding, submit a Diamond Grinding Plan for review and approval. At a minimum, include the daily reports for the deficient areas, the location and extent of deficiencies, corrective actions, and equipment. Remove and replace all pavement areas requiring plan grade or surface smoothness corrections in excess of the limits specified.

Prior to production diamond grinding operations, perform a test section at the approved location, consisting of a minimum of two adjacent passes with a minimum length of 40 feet to allow evaluation of the finish and transition between adjacent passes. Production diamond grinding operations cannot be

performed prior to approval.

2.2 AGGREGATES.

Aggregates. Obtain samples in accordance with ASTM D75/D75M and be representative of the materials to be used for the project. Provide aggregates consisting of crushed stone, crushed gravel, crushed slag, screenings, and natural sand and mineral filler, as required. The portion of material retained on the No. 4 sieve is coarse aggregate. The portion of material passing the No. 4 sieve and retained on the No. 200 sieve is fine aggregate. The portion passing the No. 200 sieve is defined as mineral filler. Submit sufficient materials to produce 90 kg 200 pounds of blended mixture for mix design verification. Submit all aggregate test results to the COR at least 14 days prior to start of construction.

2.2.1 Coarse Aggregate

Coarse Aggregate. Provide coarse aggregate consisting of sound, tough, durable particles, free from films of material that would prevent thorough coating and bonding with the asphalt material and free from organic matter and other deleterious substances. Provide coarse aggregate particles meeting the following requirements:

- a. The percentage of loss not be greater than 40 percent after 500 revolutions when tested in accordance with ASTM C131/C131M.
- b. At least 75 percent by weight of coarse aggregate contain at least two or more fractured faces when tested in accordance with ASTM D5821 with fractured faces produced by crushing.
- c. The particle shape essentially cubical and the aggregate containing not more than 20 percent, by weight, of flat particles and elongated particles (3:1 ratio of maximum to minimum) when tested in accordance with ASTM D4791.
- d. Slag consisting of air-cooled, blast furnace slag, with a compacted weight of not less than 1200 kg per cubic meter 75 pounds per cubic foot when tested in accordance with ASTM C29/C29M.
- e. Clay lumps and friable particles not exceeding 0.3 percent, by weight, when tested in accordance with ASTM C142/C142M.

2.2.2 Fine Aggregate

Fine Aggregate. Provide fine aggregate consisting of clean, sound, tough, durable particles. Provide aggregate particles that are free from coatings of clay, silt, or any objectionable material, contain no clay balls, and meet the following requirements:

- a. Quantity of natural sand (noncrushed material) added to the aggregate blend not exceeding 15 percent by weight of total aggregate.
- b. Individual fine aggregate sources with a sand equivalent value greater than 45 when tested in accordance with ASTM D2419.
- c. Fine aggregate portion of the blended aggregate with an uncompact void content greater than 45.0 percent when tested in accordance with AASHTO T 304 Method A.
- d. Clay lumps and friable particles not exceeding 0.3 percent, by weight,

when tested in accordance with ASTM C142/C142M.

2.2.3 Mineral Filler

Provide mineral filler consisting of a nonplastic material meeting the requirements of [ASTM D242/D242M](#).

2.2.4 Aggregate Gradation

Provide a combined aggregate gradation that conforms to gradations specified in Table 5, when tested in accordance with ASTM C136/C136M and ASTM C117, and does not vary from the low limit on one sieve to the high limit on the adjacent sieve or vice versa, but grades uniformly from coarse to fine. Provide a JMF within the specification limits; however, the gradation can exceed the limits when the allowable deviation from the JMF shown in Tables 8 and 9 are applied.

Table 5. Aggregate Gradations			
	Gradation 1	Gradation 2	Gradation 3
Sieve Size, inch	Percent Passing by Mass	Percent Passing by Mass	Percent Passing by Mass
1	100	---	---
3/4	90-100	100	---
1/2	68-88	90-100	100
3/8	60-82	69-89	90-100
No. 4	45-67	53-73	58-78
No. 8	32-54	38-60	40-60
No. 16	22-44	26-48	28-48
No. 30	15-35	18-38	18-38
No. 50	9-25	11-27	11-27
No. 100	6-18	6-18	6-18
No. 200	3-6	3-6	3-6

2.3 ASPHALT CEMENT BINDER.

For shoulder pavement areas, provide asphalt cement binder that conforms to AASHTO M 320 Performance Grade (PG) 64-22. For taxiway and overrun pavements, provide asphalt cement binder that conforms to AASHTO M 320 Performance Grade (PG) 70-28. Provide test data indicating grade certification by the supplier at the time of delivery of each load to the mix plant. Submit copies of these certifications to the Government. The

supplier is defined as the last source of any modification to the binder.

2.4 MIX DESIGN.

2.4.1 JMF Requirements

JMF Requirements. Submit the proposed JMF in writing, for approval, at least 14 days prior to the start of the test section, including as a minimum:

- a. Percent passing each sieve size.
- b. Percent of asphalt cement.
- c. Percent of each aggregate and mineral filler to be used.
- d. Asphalt viscosity grade, penetration grade, or performance grade.
- e. Number of blows of hand-held hammer per side of molded specimen. (NA for Superpave)
- f. Number of gyrations of Superpave gyratory compactor, (N/A for Marshall mix design)
- g. Laboratory mixing temperature.
- h. Lab compaction temperature.
- i. Temperature-viscosity relationship of the asphalt cement.
- j. Plot of the combined gradation on the 0.45 power gradation chart, stating the nominal maximum size.
- k. Graphical plots of stability (NA for Superpave), flow (NA for Superpave), air voids, voids in the mineral aggregate, and unit weight versus asphalt content as shown in AI MS-2.
- l. Specific gravity and absorption of each aggregate.
- m. Percent natural sand.
- n. Percent particles with 2 or more fractured faces (in coarse aggregate).
- o. Fine aggregate angularity.
- p. Percent flat or elongated particles (in coarse aggregate).
- q. Tensile Strength Ratio(TSR).
- r. Antistrip agent (if required) and amount.
- s. List of all modifiers and amount.
- t. Correlation of hand-held hammer with mechanical hammer (NA for Superpave).

Table 6. Superpave Gyratory Compaction Criteria	
Test Property	Value
Air voids, percent	4 ¹
Percent Voids in mineral aggregate (minimum)	See Table 7
Dust Proportion ²	0.8-1.2
TSR, minimum percent	75
¹ Select the JMF asphalt content corresponding to an air void content of 4 percent. Verify the other properties of Table 6 meet the specification requirements at this asphalt content.	
² Dust Proportion is calculated as the aggregate content, expressed as a percent of mass, passing the No. 200 sieve, divided by the effective asphalt content, in percent of total mass of the	

Table 7. Minimum Percent Voids in Mineral Aggregate (VMA) ⁽¹⁾	
Aggregate (See Table 5)	Minimum VMA, percent
Gradation 1	13
Gradation 2	14
Gradation 3	15
(1) Calculate VMA in accordance with AI MS-2, based on ASTM D2726/D2726M bulk specific gravity for the aggregate.	

2.4.2 Adjustments to JMF

The JMF for each mixture is in effect until a new formula is approved in writing by the Government. Should a change in sources of any materials be made, perform a new mix design and a new JMF approved before the new material is used. Make minor adjustments within the specification limits to the JMF to optimize mix volumetric properties. Adjustments to the original JMF are limited to plus or minus 4 percent on the No. 4 and coarser sieves; plus or minus 3 percent on the No. 8 to No. 50 sieves; and plus or minus 1 percent on the No. 100 sieve. Adjustments to the JMF are limited to plus or minus 1.0 percent on the No. 200 sieve. Asphalt content adjustments are limited to plus or minus 0.40 from the original JMF. If adjustments are needed that exceed these limits, develop a new mix design.

2.5 RECYCLED ASPHALT PAVEMENT.

Recycled HMA is not allowed.

PART 3 EXECUTION.

3.1 CONTRACTOR QUALITY CONTROL.

NOTE: The Contractor may be able to meet the specified quality control requirements with in-house capability or may have to hire a material testing firm to provide the required quality control testing.

3.1.1 General Quality Control Requirements

General Quality Control Requirements. Submit the Quality Control Plan for approval. Do not start construction until the quality control plan has been approved. In the quality control plan, address all elements which affect the quality of the pavement including, but not limited to:

- a. Mix Design and unique JMF identification code
- b. Aggregate Grading
- c. Quality of Materials
- d. Stockpile Management and procedures to prevent contamination
- e. Proportioning
- f. Mixing and Transportation
- g. Correlation of mechanical hammer to hand hammer. Determine the number of blows of the mechanical hammer required to provide the same density

of the JMF as provided by the hand hammer. Use the average of three specimens per trial blow application.

- h. Mixture Volumetrics
- i. Moisture Content of Mixtures
- j. Placing and Finishing
- k. Joints
- l. Compaction, including HMA-Portland Cement Concrete joints
- m. Surface Smoothness
- n. Truck bed release agent

3.1.2 Testing Laboratory

Provide laboratory facilities that are kept clean and all equipment maintained in proper working condition. Provide the Government with unrestricted access to inspect the laboratory facility, to witness quality control activities, and to perform any check testing desired. The Government will advise in writing of any noted deficiencies concerning the laboratory facility, equipment, supplies, or testing personnel and procedures. When the deficiencies are serious enough to adversely affect test results, immediately suspend the incorporation of the materials into the work. Incorporation of the materials into the work will not be permitted to resume until the deficiencies are corrected.

3.1.3 Quality Control Testing

Perform all quality control tests applicable to these specifications and as set forth in the Quality Control Program. Required elements of the testing program include, but are not limited to, tests for the control of asphalt content, aggregate gradation, temperatures, aggregate moisture, moisture in the asphalt mixture, laboratory air voids, stability, flow, in-place density, grade and smoothness. Develop a Quality Control Testing Plan as part of the Quality Control Program.

3.1.3.1 Asphalt Content

A minimum of two tests to determine asphalt content will be performed per lot by one of the following methods: extraction method in accordance with ASTM D2172/D2172M, Method A or B, the ignition method in accordance with the AASHTO T 308, ASTM D6307, or the nuclear method in accordance with ASTM D4125/D4125M, provided each method is calibrated for the specific mix being used. For the extraction method, determine the weight of ash, as described in ASTM D2172/D2172M, as part of the first extraction test performed at the beginning of plant production; and as part of every tenth extraction test performed thereafter, for the duration of plant production. Use the last weight of ash value in the calculation of the asphalt content for the mixture.

3.1.3.2 Aggregate Properties

Determine aggregate gradations a minimum of twice per lot from mechanical analysis of recovered aggregate in accordance with ASTM D5444 or ASTM D6307. For batch plants, test aggregates in accordance with ASTM C136/C136M using actual batch weights to determine the combined aggregate gradation of the mixture. Determine the specific gravity of each aggregate size grouping for each 20,000 tons in accordance with ASTM C127 or ASTM C128. Determine fractured faces for gravel sources for each 20,000 tons in accordance with COE CRD-C 171. Determine the uncompacted void content of manufactured sand for each 20,000 tons in accordance with AASHTO T 304 Method A.

3.1.3.3 Temperatures

Check temperatures at least four times per lot, at necessary locations, to determine the temperature at the dryer, the asphalt cement in the storage tank, the asphalt mixture at the plant, and the asphalt mixture at the job site.

3.1.3.4 Aggregate Moisture

Determine the moisture content of aggregate used for production a minimum of once per lot in accordance with [ASTM C566](#).

3.1.3.5 Moisture Content of Mixture

Determine the moisture content of the mixture at least once per lot in accordance with [AASHTO T 329](#).

3.1.3.6 Laboratory Air Voids, VMA, Marshall Stability and Flow

Obtain mixture samples at least four times per lot and if less than one lot is placed, then at least four times per day. Compact samples into specimens, using 50 gyrations of the Superpave gyratory compactor as described in ASTM D6925 for all shoulder pavement and 75 gyrations of the Superpave gyratory compactor as described in ASTM D6925 for all taxiway and overrun pavements. After compaction, determine the laboratory air voids and VMA of each specimen. Provide VMA within the limits of Table 7.

3.1.3.7 In-Place Density

Conduct any necessary testing to ensure the specified density is achieved. A nuclear gauge or other non-destructive testing device may be used to monitor pavement density.

3.1.3.8 Grade and Smoothness

Conduct the necessary checks to ensure the grade and smoothness requirements are met in accordance with paragraph [QUALITY ASSURANCE](#).

3.1.3.9 Additional Testing

Perform any additional testing, deemed necessary to control the process.

3.1.3.10 QC Monitoring

Submit all QC test results to the [COR](#) on a daily basis as the tests are performed. The [COR](#) reserves the right to monitor any of the Contractor's quality control testing and to perform duplicate testing as a check to the Contractor's quality control testing.

3.1.4 Sampling

When directed by the [COR](#), sample and test any material which appears inconsistent with similar material being produced, unless such material is voluntarily removed and replaced or deficiencies corrected. Perform all sampling in accordance with standard procedures specified.

3.1.5 Control Charts

Control Charts. For process control, establish and maintain linear control charts on both individual samples and the running average of last four samples for the parameters listed in Table 8, as a minimum. Post the control

charts as directed by the Government and maintain current at all times. Identify the following on the control charts, the project number, the test parameter being plotted, the individual sample numbers, the Action and Suspension Limits listed in Table 8 applicable to the test parameter being plotted, and the test results. Also show target values (JMF) on the control charts as indicators of central tendency for the cumulative percent passing, asphalt content, and laboratory air voids parameters. When the test results exceed either applicable Action Limit, take immediate steps to bring the process back in control. When the test results exceed either applicable Suspension Limit, halt production until the problem is solved. When the Suspension Limit is exceeded for individual values or running average values, the Government has the option to require removal and replacement of the material represented by the samples or to leave in place and base acceptance on mixture volumetric properties and in place density. Use the control charts as part of the process control system for identifying trends so that potential problems can be corrected before they occur. Make decisions concerning mix modifications based on analysis of the results provided in the control charts. In the Quality Control Plan, indicate the appropriate action to be taken to bring the process into control when certain parameters exceed their Action Limits.

Table 8. Action and Suspension Limits for the Parameters to be Plotted on Individual and Running Average Control Charts				
Parameter to be Plotted	Individual Samples		Running Average of Last Four Samples	
	Action Limit	Suspension Limit	Action Limit	Suspension Limit
No. 4 sieve, Cumulative Percent Passing, deviation from JMF target; plus or minus values	6	8	4	5
No. 30 sieve, Cumulative Percent Passing, deviation from JMF target; plus or minus values	4	6	3	4
No. 200 sieve, Cumulative Percent Passing, deviation from JMF target; plus or minus values	1.4	2.0	1.1	1.5
Asphalt content, percent deviation from JMF target; plus or minus value	0.4	0.5	0.2	0.3
Laboratory Air Voids, percent deviation from JMF target value	No specific action and suspension limits set			
In-place Mat Density,	No specific action and suspension limits			

	percent of TMD	set		
VMA				
Gradation 2	14.3	14.0	14.5	14.0

3.2 PREPARATION OF ASPHALT BINDER MATERIAL.

Heat the asphalt cement material while avoiding local overheating and providing a continuous supply of the asphalt material to the mixer at a uniform temperature. Maintain the temperature of unmodified asphalts to no more than 325 degrees F when added to the aggregates. The temperature of modified asphalts is not to exceed 350 degrees F.

3.3 PREPARATION OF MINERAL AGGREGATE.

Heat and dry the aggregate for the mixture prior to mixing. No damage to the aggregates due to the maximum temperature and rate of heating used is allowed. Maintain the temperature no lower than is required to obtain complete coating and uniform distribution on the aggregate particles and to provide a mixture of satisfactory workability.

3.4 PREPARATION OF HOT-MIX ASPHALT MIXTURE.

Weigh or meter the aggregates and the asphalt cement and introduce into the mixer in the amount specified by the JMF. Mix the combined materials until the aggregate obtains a thorough and uniform coating of asphalt binder (testing in accordance with ASTM D2489/D2489M may be required by the Contracting Officer) and is thoroughly distributed throughout the mixture. The moisture content of all hot-mix asphalt upon discharge from the plant is not to exceed 0.5 percent by total weight of mixture as measured by ASTM D1461.

3.5 PREPARATION OF THE UNDERLYING SURFACE.

Immediately before placing the hot mix asphalt, clean the underlying course of dust and debris. Apply a prime coat or tack coat in accordance with the contract drawings and specifications.

3.6 TEST SECTION.

Prior to full production, place a test section for each JMF used. Construct a test section consisting of a maximum of 250 tons and two paver passes wide placed in two lanes, with a longitudinal cold joint. Do not place the second lane of test section until the temperature of pavement edge is less than 175 degrees F. Construct the test section with the same depth as the course which it represents. Ensure the underlying grade or pavement structure upon which the test section is to be constructed is the same or very similar to the underlying layer for the project. Use the same equipment in construction of the test section as on the remainder of the course represented by the test section. Construct the test section as part of the project pavement as approved by the COR.

3.6.1 Sampling and Testing for Test Section

Obtain one random sample at the plant, triplicate specimens compacted, and tested for stability, flow, and laboratory air voids. Test a portion of the same sample for theoretical maximum density (TMD), aggregate gradation and asphalt content. Test an additional portion of the sample to determine the Tensile Strength Ratio (TSR). Adjust the compactive effort as required to

provide TSR specimens with an air void content of 7 plus or minus 1 percent. Obtain four randomly selected cores from the finished pavement mat, and four from the longitudinal joint, and tested for density. Perform random sampling in accordance with procedures contained in ASTM D3665. Construction may continue provided the test results are within the tolerances or exceed the minimum values shown in Table 9. If all test results meet the specified requirements, the test section may remain as part of the project pavement. If test results exceed the tolerances shown, remove and replace the test section and construct another test section at no additional cost to the Government.

Table 9. Test Section Requirements for Material and Mixture Properties	
Property	Specification Limit
Aggregate Gradation-Percent Passing (Individual Test Result)	
No. 4 and larger	JMF plus or minus 8
No. 8, No. 16, No. 30, and No. 50	JMF plus or minus 6
No. 100 and No. 200	JMF plus or minus 2.0
Asphalt Content, Percent (Individual Test Result)	JMF plus or minus 0.5
Laboratory Air Voids, Percent (Average of 3 specimens)	JMF plus or minus 1.0
VMA, Percent (Average of 3 specimens)	See Table 7
Tensile Strength Ratio (TSR) (At 7 percent plus/minus 1 percent air void content)	75 percent minimum
Conditioned Strength	60 psi minimum
Mat Density, Percent of TMD (Average of 4 Random Cores)	92.0 - 96.0
Joint Density, Percent of TMD (Average of 4 Random Cores)	90.5 minimum

3.6.2 Additional Test Sections

If the initial test section proves to be unacceptable, make the necessary adjustments to the JMF, plant operation, placing procedures, and rolling procedures before beginning construction of a second test section. Construct and evaluate additional test sections, as required, for conformance to the specifications. Full production paving is not allowed until an acceptable test section has been constructed and accepted.

3.7 TESTING LABORATORY.

Testing Laboratory. Laboratories used to develop the JMF, perform Contractor Quality Control testing, and Government quality assurance and acceptance testing are required to meet the requirements of ASTM D3666. Perform all required test methods by an accredited laboratory. The Government will inspect the laboratory equipment and test procedures prior to the start of hot-mix operations for conformance with ASTM D3666. Maintain the laboratory validation for the duration of the project. Submit a certification of compliance signed by the manager of the laboratory stating that it meets

these requirements to the Government prior to the start of construction. At a minimum, include the following certifications:

- a. Qualifications of personnel; laboratory manager, supervising technician, and testing technicians.
- b. A listing of equipment to be used in developing the job mix.
- c. A copy of the laboratory's quality control system.
- d. Evidence of participation in the AASHTO Materials Reference Laboratory (AMRL) program.

3.8 TRANSPORTING AND PLACING.

3.8.1 Transporting

Transport asphalt mixture from the mixing plant to the site in clean, tight vehicles. Schedule deliveries so that placing and compacting of mixture is uniform with minimum stopping and starting of the paver. Provide adequate artificial lighting for night placements. Hauling over freshly placed material is not permitted until the material has been compacted as specified, and allowed to cool to 140 degrees F.

3.8.2 Placing

Place the mix in lifts of adequate thickness and compacted at a temperature suitable for obtaining density, surface smoothness, and other specified requirements. Upon arrival, place the mixture to the full width by an asphalt paver; strike off in a uniform layer of such depth that, when the work is completed, the required thickness and conform to the grade and contour indicated. Do not broadcast waste mixture onto the mat or recycled into the paver hopper. Collect waste mixture and dispose off site. Regulate the speed of the paver to eliminate pulling and tearing of the asphalt mat. Begin placement of the mixture along the centerline of a crowned section or on the high side of areas with a one-way slope. Place the mixture in consecutive adjacent strips having a minimum width of 10 feet. Offset the longitudinal joint in one course from the longitudinal joint in the course immediately below by at least 1 foot; however, locate the joint in the surface course at the centerline of the pavement. Offset transverse joints in one course by at least 10 feet from transverse joints in the previous course. Offset transverse joints in adjacent lanes a minimum of 10 feet. On isolated areas where irregularities or unavoidable obstacles make the use of mechanical spreading and finishing equipment impractical, the mixture may be spread and luted by hand tools.

3.9 COMPACTION OF MIXTURE.

3.9.1 General

- a. After placing, thoroughly and uniformly compact the mixture by rolling. Compact the surface as soon as possible without causing displacement, cracking or shoving. Determine the sequence of rolling operations and the type of rollers used, except as specified in paragraph ASPHALT PAVEMENT-PORTLAND CEMENT CONCRETE JOINTS and with the exception that application of more than three passes with a vibratory roller in the vibrating mode is prohibited. Maintain the speed of the roller, at all times, sufficiently slow to avoid displacement of the asphalt mixture and be effective in compaction. Correct at once any displacement occurring as a result of reversing the direction of the roller, or from any other cause.

- b. Furnish sufficient rollers to handle the output of the plant. Continue rolling until the surface is of uniform texture, true to grade and cross section, and the required field density is obtained. To prevent adhesion of the mixture to the roller, keep the wheels properly moistened, but excessive water is not permitted. In areas not accessible to the roller, thoroughly compact the mixture with hand tampers. Remove the full depth of any mixture that becomes loose and broken, mixed with dirt, contains check-cracking, or is in any way defective, replace with fresh asphalt mixture and immediately compact to conform to the surrounding area. Perform this work at no expense to the Government. Skin patching is not allowed.

3.9.2 Segregation

The COR can sample and test any material that looks deficient. When the in-place material appears to be segregated, the COR has the option to sample the material and have it tested and compared to the aggregate gradation, asphalt content, and in-place density requirements in Table 9. If the material fails to meet these specification requirements, remove and replace the extent of the segregated material the full depth of the layer of asphalt mixture at no additional cost to the Government. When segregation occurs in the mat, take appropriate action to correct the process so that additional segregation does not occur.

3.10 JOINTS.

Construct joints to ensure a continuous bond between the courses and to obtain the required density. Provide all joints with the same texture as other sections of the course and meet the requirements for smoothness and grade.

3.10.1 Transverse Joints

Do not pass the roller over the unprotected end of the freshly laid mixture, except when necessary to form a transverse joint. When necessary to form a transverse joint, construct by means of placing a bulkhead or by tapering the course. Utilize a dry saw cut on the transverse joint full depth and width on a straight line to expose a vertical face prior to placing the adjacent lane. Cutting equipment that uses water as a cooling or cutting agent nor is milling equipment permitted. Remove the cutback material from the project. In both methods, provide a light tack coat of asphalt material to all contact surfaces before placing any fresh mixture against the joint.

3.10.2 Longitudinal Joints

Cut back longitudinal joints which are irregular, damaged, uncompacted, cold (less than 175 degrees F at the time of placing the adjacent lane), or otherwise defective, a maximum of 3 inches from the top edge of the lift with a cutting wheel to expose a clean, sound, near vertical surface for the full depth of the course. Remove all cutback material from the project. Cutting equipment that uses water as a cooling or cutting agent nor is milling equipment permitted. Provide a light tack coat of asphalt material to all contact surfaces prior to placing any fresh mixture against the joint.

3.10.3 Asphalt Pavement-Portland Cement Concrete Joints

Joints between asphalt pavement and Portland Cement Concrete (PCC) require

specific construction procedures for the asphalt pavement. The following criteria are applicable to the first 10 feet or paver width of asphalt pavement adjacent to the PCC.

- a. Pave the HMA side of the joint in a direction parallel to the joint.
- b. Place the HMA side sufficiently high so that when fully compacted the HMA is greater than 1/8 inch but less than 1/4 inch higher than the PCC side of the joint.
- c. Compact with steel wheel rollers and at least one rubber tire roller. Compact with a rubber tire roller that weights at least 20 tons with tires inflated to at least 90 psi. Avoid spalling the PCC during placement and compaction of the HMA. Operate steel wheel rollers in a way that prevents spalling the PCC. Repair any damage to PCC edges or joints as directed by the Government. If damage to the PCC joint or panel edge exceeds a total of 3 feet, remove and replace the PCC panel at no additional expense to the Government.
- d. After compaction is finished, diamond grind the HMA so that the HMA side is less than 1/8 inch higher than the PCC side. Perform diamond grinding in accordance with subparagraph DIAMOND GRINDING above. The HMA immediately adjacent to the joint is not allowed to be lower than the PCC after the grinding operation. Transition the grinding into the HMA in a way that ensures good smoothness and provides drainage of water. The joint and adjacent materials when completed is required to meet all of the requirements for grade and smoothness. Measure smoothness across the HMA-PCC joint using a 12 feet straightedge. The acceptable tolerance is 1/8 inch.
- e. All procedures, including repair of damaged PCC, are required to be in accordance with the approved Quality Control Plan.

-- End of Section --