10-1.__ WARM MIX ASPHALT TECHNOLOGY OPTION

GENERAL

Summary

You may produce HMA Type A, Type B, or RHMA-G using an approved warm mix asphalt (WMA) technology. For Department-approved WMA technologies, go to:

http://www.dot.ca.gov/hq/esc/approved_products_list/

HMA using WMA technology must comply with Section 39, "Hot Mix Asphalt," of the Standard Specifications.

AASHTO T 324 (Modified) is AASHTO T 324, "Hamburg Wheel-Track Testing of Compacted Hot Mix Asphalt (HMA)," with the following parameters:

1. Target air voids is 7±1 percent
2. 4 test specimens
3. 6-inch gyratory compacted test specimen
4. Test temperature is 122±2 °F
5. Impression measurements at every 100 passes
6. Inflection point as the number of wheel passes at the intersection of the creep slope and the stripping slope.
7. Testing shut off after 25,000 passes
8. For RHMA test specimens:
   8.1 Superpave Gyratory Compactor ram pressure may be increased to a maximum 825 kilopascals.
   8.2 Specimens may be held at a constant height for a maximum of 90 minutes.

HMA samples must be prepared under California Test 304, except the samples must be cured in a forced air draft oven at 275 °F for 4 hours ± 10 minutes.

Definitions

WMA: HMA produced at temperatures no greater than 275 °F.

HMA with WMA technology: HMA produced using additives to aid with mixing and compaction of HMA produced at temperatures greater than 275 °F.

Submittals

General

With your JMF submittal, submit:

1. For WMA water injection foam technology:

   1.1. Name of technology

1.2. Laboratory Procedure 12 (LP-12) test result for foamed bitumen expansion ratio dated within 12 months of submittal
1.3. Laboratory Procedure 12 (LP-12) test result for foamed bitumen half-life dated within 12 months of submittal
1.4. Optimum foaming water content
1.5. Proposed HMA production temperature range

2. For WMA additive technology:

2.1. Name of technology
2.2. Percent admixture by weight of binder and percent admixture by total weight of HMA as recommended by the manufacturer
2.3. Methodology for inclusion of admixture in laboratory produced HMA
2.4. Proposed HMA production temperature range

3. California Test 371 test results for dry strength for untreated plant produced HMA
4. California Test 371 test results for tensile strength ratio for untreated plant produced HMA
5. California Test 204 test results for plasticity index if untreated plant produced HMA test result determined under California Test 371 is below the specified HMA mix design requirements
6. California Test 371 test results for treated plant produced HMA if untreated plant produced HMA test result determined under California Test 371 is below the specified HMA mix design requirements
7. AASHTO T 324 (Modified) test results data showing number of passes with rut depth for plant produced HMA
8. AASHTO T 324 (Modified) test results data showing number of passes at inflection point for plant produced HMA.

Prepaving Conference

With your JMF submittal, submit a list of names participating in the prepaving conference. Identify each participant's name, employer, title, and role in the production and placement of WMA or HMA with WMA technology.

Tests and Samples

At production start-up and within ±1000 tons of the halfway point of production of HMA produced using WMA technology, submit samples split from your HMA production sample for California Test 371 and AASHTO T 324 (Modified) test to the Engineer and the Transportation Laboratory, Attention: Moisture Test.

With the JMF submittal, at JMF verification, at production start-up, and for each 10,000 tons of HMA produced, submit the California Test 371 test results and AASHTO T 324 (Modified) test results for mix design and production to the Engineer and electronically to:

Moisture_Tests@dot.ca.gov

With the JMF submittal, at JMF verification, at production start-up evaluation, and for each 10,000 tons of HMA produced, submit one tested sample set from AASHTO T 324 (Modified) test to the Engineer.

Daily Production Log

Submit the log of production data daily and upon request.

Quality Control and Assurance

Technical Representative

A technical representative from the WMA technology supplier must be present during the first 3 days of production and placement of WMA or HMA using WMA technology. The technical representative must advise you, the Engineer, and the HMA producer. The technical representative must direct the HMA mix operation as it relates to the WMA technology.

The technical representative must advise the HMA producer regarding HMA plant and HMA plant process-controller modifications necessary for integrating WMA technology with HMA plant. HMA plant modifications and WMA technology equipment, scales, and meters must comply with Department's Materials Plant Quality Program (MPQP).

Prepaving Conference

Schedule a prepaving conference with the Engineer at a mutually agreed time and place. Make arrangements for the conference facility. Be prepared to discuss:

1. HMA production and placement
2. Method for incorporating WMA technology and any impacts on HMA production and placement including requirements for compaction and workmanship
3. Contingency plan

The following personnel must attend the prepaving conference:

1. Project Manager
2. Superintendent
3. Technical representative for WMA technology
4. Asphalt binder supplier
5. HMA plant manager
6. HMA plant operators
7. HMA paving foreman

Quality Control Testing

Perform sampling and testing at the specified frequency and location for the following additional quality characteristics:

Minimum Quality Control

Quality characteristic	Test method	Minimum sampling and testing frequency	Requirement			Sampling location	Maximum reporting time allowance
			HMA Type				
			A	B	RHMA-G		
Moisture susceptibility (minimum dry strength, psi)	California Test 371	First production day and 1 per every 10,000 tons	120	120	120	Loose mix behind the paver. See California Test 125	15 days
Moisture susceptibility (tensile strength ratio, %)	California Test 371		Report Only	Report Only	Report Only		
Hamburg wheel track (minimum number of passes at 0.5 inch average rut depth)	AASHTO T 324 (Modified)	First production day and 1 per every 10,000 tons				Loose mix behind the paver. See California Test 125	7 days[a]
PG-58			10,000	10,000	15,000		
PG-64			15,000	15,000	20,000		
PG-70			20,000	20,000	25,000		
PG-76			25,000	25,000	--		
Hamburg wheel track (inflection point minimum number of passes)	AASHTO T 324 (Modified)						
PG-58			10,000	10,000	10,000		
PG-64			10,000	10,000	12,500		
PG-70			12,500	12,500	15,000		
PG-76			15,000	15,000	--		

Notes:
[a] Submit test data and 1 tested sample set.

If requirements for Quality Control / Quality Assurance process are specified in the section titled "Hot Mix Asphalt" or "Rubberized Hot Mix Asphalt (Gap Graded)" of these special provisions, the minimum sampling and testing frequency for California Test 371 is replaced with the minimum sampling and testing frequency for California Test 371 shown in the table above.

Engineer's Acceptance

The Engineer samples HMA for acceptance testing and tests for the following additional quality characteristic:

HMA Acceptance

Quality characteristic	Test method	Requirement			Sampling location
		HMA Type			
		A	B	RHMA-G	
Moisture susceptibility (minimum dry strength, psi)	California Test 371	120	120	120	Loose mix behind the paver. See California Test 125
Moisture susceptibility (tensile strength ratio, %)	California Test 371	Report Only[a]	Report Only[a]	Report Only[a]	
Hamburg wheel track (minimum number of passes at 0.5 inch average rut depth) PG-58 PG-64 PG-70 PG-76	AASHTO T 324 (Modified)	 10,000 15,000 20,000 25,000	 10,000 15,000 20,000 25,000	 15,000 20,000 25,000 --	Loose mix behind the paver. See California Test 125
Hamburg wheel track (inflection point minimum number of passes) PG-58 PG 64 PG-70 PG-76	AASHTO T 324 (Modified)	 10,000 10,000 12,500 15,000	 10,000 10,000 12,500 15,000	 10,000 12,500 15,000 --	

[a]The Department does not use California Test 371 tensile strength ratio test results from production to determine specification compliance.

MATERIALS

Foaming Bitumen

When water injection is used by the WMA technology, the foamed bitumen must have the following quality characteristics:

Quality Requirements for Foaming Bitumen

Quality characteristic	Test method	Requirement
Expansion ratio (minimum)	Laboratory Procedure-12	4
Half life (seconds minimum)	Laboratory Procedure-12	4

For Laboratory Procedure 12 (LP-12), go to:

http://www.dot.ca.gov/hq/esc/Translab/ofpm/fmplab.htm

Hot Mix Asphalt
Mix Design

For WMA additive technology, produce HMA mix samples for your mix design using your methodology for inclusion of WMA admixture in laboratory produced HMA. For WMA water injection foam technology, the use of foamed asphalt for mix design is not required.

HMA mix design must meet the following quality characteristics:

Hot Mix Asphalt Mix Design Requirements

Quality characteristic	Test method	HMA Type		
		A	B	RHMA
Moisture susceptibility (minimum dry strength, psi)	California Test 371	120	120	120
Moisture susceptibility (tensile strength ratio, %)	California Test 371	70	70	70
Hamburg wheel track (minimum number of passes at 0.5 inch average rut depth)	AASHTO			
PG-58	T 324	10,000	10,000	15,000
PG 64	(Modified)	15,000	15,000	20,000
PG-70		20,000	20,000	25,000
PG-76		25,000	25,000	--
Hamburg wheel track (inflection point minimum number of passes)	AASHTO			
PG-58	T 324	10,000	10,000	10,000
PG 64	(Modified)	10,000	10,000	12,500
PG-70		12,500	12,500	15,000
PG-76		15,000	15,000	--

If the determined test results under California Test 371 or AASHTO T 324 (Modified) for untreated plant produced HMA is less than minimum requirement for the mix design, determine the plasticity index of the aggregate blend under California Test 204. Choose from the antistrip treatments based on plasticity index in compliance with:

Hot Mix Asphalt Antistrip Treatment Options

Quality characteristic	Test method	Treatment requirement
Plasticity index		
Plasticity index from 4 to 10 [a]	California Test 204	Dry hydrated lime with marination Lime slurry with marination
Plasticity index less than 4		Liquid Antistrip Dry hydrated lime without marination Dry hydrated lime with marination Lime slurry with marination

Notes:
[a] If the plasticity index is greater than 10, do not use that aggregate blend.

Mix design for treated plant produced HMA must meet the mix design requirements, except if the tensile strength ratio test result for treated plant produced RHMA-G is less than the mix design requirement for tensile strength ratio, the minimum tensile strength ratio requirement is waived, but you must use any of the following antistrip treatments:

1. HMA aggregate lime treatment – slurry method
2. HMA aggregate lime treatment – dry lime method
3. Liquid antistrip treatment using 0.5 percent liquid antistrip

Job Mix Formula Verification

HMA produced for JMF verification must be produced using the WMA technology shown in the JMF submittal.

Use the optimum bitumen content (OBC) specified on your CEM-3512. No adjustments are allowed. When RAP is used, the asphalt binder set point for HMA must be the OBC specified on your CEM-3512 minus RAP percentage multiplied by the combined average asphalt binder content of the processed fractioned RAP stockpiles.

Perform AASHTO T 324 (Modified) for compliance with the mix design requirements. Submit test data and one tested sample set from AASHTO T 324 (Modified) test.

The Engineer may verify that the HMA complies with the mix design requirements for AASHTO T 324 (Modified) and California Test 371.

For RHMA-G with WMA technology and upon request, the Engineer verifies RHMA-G quality requirements within 5 business days of sampling.

Production

General

For the Standard and QC/QA process, HMA produced using WMA technology must be produced at a temperature between 240 °F and 325 °F.

For the Method process, HMA produced using WMA technology must be produced at temperatures in accordance with Section 39, "Hot Mix Asphalt," of the Standard Specifications.

Comply with Section 39-1.08A, "General," of the Standard Specifications except the HMA plant asphalt binder set point for HMA production must be the OBC specified on your CEM-3511. When RAP is used, asphalt binder set point for HMA production must be the OBC specified on your CEM-3511 minus RAP percentage multiplied by the combined average asphalt binder content of the processed fractioned RAP stockpiles.

HMA additives used for anti-strip treatment and warm mix technologies may be either in a liquid or dry state.

The HMA plant must have a sampling device in the feed line connecting the additive storage to the additive metering system. The sampling equipment must comply with California Test 125.

Proportioning Warm Mix Asphalt Technologies

HMA plants using WMA technology must comply with the Department's MPQP.

Proportion all ingredients by weight. The HMA plant process-controller (PPC) must be the sole source of ingredient proportioning control and be fully interfaced with all scales and meters used in the production process. The addition of the HMA additive must be controlled by the PPC.

Weighing and metering devices used for the production of additive enhanced HMA must meet the requirements of the MPQP. If a loss-in-weight meter is used for dry HMA additive, the meter must:

1. Meet the requirements of the MPQP
2. Have an automatic and integral material delivery control system for the refill cycle

Calibrate the loss-in-weight meter by:

1. Including at least 1 complete system refill cycle during each calibration test run
2. Operating the device in a normal run mode for 10 minutes immediately before starting the calibration process
3. Isolating the scale system within the loss-in-weight feeder from surrounding vibration
4. Checking the scale system within the loss-in-weight feeder for accuracy before and after the calibration process and daily during mix production
5. Using a 15-minute or 250-pound-minimum test run size for a dry ingredient delivery rate of less than 1 ton per hour
6. Complying with the limits of Table B, "Conveyor Scale Testing Extremes," in the MPQP

Produce additive enhanced HMA by using either a continuous mixing or a batch type HMA plant.

Liquid ingredient additive, including a normally dry ingredient made liquid, must be proportioned with a mass flow meter at continuous mixing plants. Use a mass flow meter or a container scale to proportion liquid additives at batch mixing plants.

Continuous mixing plants using HMA additives must comply with the following:

1. Dry ingredient additives for continuous production must be proportioned with a conveyor scale or a loss-in-weight meter.
2. HMA PPC and ingredient measuring systems must be capable of varying all ingredient feed rates proportionate with the dry aggregate delivery at all production rates and rate changes.

3. Liquid HMA additive must enter the production stream with the binder. Dry HMA additive must enter the production stream at or before the mixing area.
4. When dry HMA additives are used at continuous mixing HMA plants, baghouse dust systems must return all captured material to the mix.
5. HMA additive must be proportioned to within ±0.3 percent of the target additive rate.

Batch mixing plants using HMA additives must comply with the following:

1. Metered HMA additive must be placed in an intermediate holding vessel before being added to the stream of asphalt binder as it enters the pugmill.
2. When a container scale is used, weigh additive before combining with asphalt binder. Keep the container scale separate from other ingredient proportioning. The container scale capacity must be no more than twice the volume of the maximum additive batch size. The container scale's graduations must be smaller than the proportioning tolerance or 0.001 times the container scale capacity.
3. Dry HMA additive proportioning devices must be separate from metering devices for the aggregates and asphalt binder. Proportion dry HMA additive directly into the pugmill or place in an intermediate holding vessel to be added to the pugmill at the appropriate time in the batch cycle. Dry ingredients for batch production must be proportioned with a hopper scale.
4. Zero tolerance for the HMA additive batch scale is ±0.5 percent of the target additive weight. The indicated HMA additive batch scale weight may vary from the preselected weight setting by up to ±1.0 percent of the target additive weight.

Production Data Collection

The HMA PPC must produce an electronic log of production data consisting of a series of snapshots captured at a maximum of 1-minute intervals throughout the period of daily production. Each snapshot of production data must be a register of production activity at that time and not a summation of the data over the preceding interval to the previous snapshot. The amount of material represented by each snapshot is the amount produced during the 0.5 minute interval before and the 0.5 minute interval after the capture time. Collect and hold data for the duration of the contract and submit the electronic media to the Engineer, daily or upon request. The snapshot of production data must include the following:

1. Date of production
2. Production location
3. Time of day the data is captured
4. HMA mix type being produced and target binder rate
5. HMA additive type, brand and target rate
6. Temperature of the binder and HMA mixture
7. For a continuous mix operation, the rate of flow of the dry aggregate calculated from the wet aggregate flow rate as determined by the conveyor scale
8. For a continuous mix plant operation, the rate of flow of the asphalt meter
9. For a continuous mix plant operation, the rate of flow of HMA additive meter

10. For a batch plant operation, actual batch weights of all ingredient
11. The dry aggregate/binder ratio calculated from metered ingredient output
12. The dry aggregate/HMA additive ratio calculated from metered output

Electronic media must be presented in a Comma-Separated Values (CSV) or Tab-Separated Values (TSV) format. Captured data, for the ingredients represented by production snapshot, must have allowances for sufficient fields to satisfy the amount of data required by these specifications and include data titles at least once per report.

CONSTRUCTION

You must request adjustments to the plant asphalt binder set point based on new RAP stockpiles average binder content. Do not adjust the HMA plant asphalt binder set point until approved by the Engineer.

The specified temperatures for HMA in Section 39, "Hot Mix Asphalt," of the Standard Specifications, for transporting, spreading and compacting of HMA apply to HMA produced using WMA technology.

Include the following three treatment methods for projects where method or standard construction processes are specified. Delete the treatment methods specifications for projects with QC/QA construction process because the following specifications are already in the project special provisions.

10-1.__ HOT MIX ASPHALT AGGREGATE LIME TREATMENT - SLURRY METHOD

GENERAL

Summary

This work includes treating hot mix asphalt (HMA) aggregate with lime using the slurry method and placing it in stockpiles to marinate.

Submittals

Determine the exact lime proportions for fine and coarse virgin aggregate and submit them as part of the proposed job mix formula (JMF) under Section 39, "Hot Mix Asphalt," of the Standard Specifications.

Submit the averaged aggregate quality test results to the Engineer within 24 hours of sampling.

Submit a treatment data log from the slurry proportioning device in the following order:

1. Treatment date
2. Time of day the data is captured
3. Aggregate size being treated
4. Wet aggregate flow rate collected directly from the aggregate weigh belt
5. Moisture content of the aggregate just before treatment, expressed as a percent of the dry aggregate weight
6. Dry aggregate flow rate calculated from the wet aggregate flow rate
7. Lime slurry flow rate measured by the slurry meter
8. Dry lime flow rate calculated from the slurry meter output
9. Approved lime ratio for each aggregate size being treated
10. Actual lime ratio calculated from the aggregate weigh belt and the slurry meter output, expressed as a percent of the dry aggregate weight
11. Calculated difference between the approved lime ratio and the actual lime ratio
12. Dry lime and water proportions at the slurry treatment time

Every day during lime treatment, submit the treatment data log on electronic media in tab delimited format on a removable CD-ROM storage disk. Each continuous treatment data set must be a separate record using a line feed carriage return to present the specified data on one line. The reported data must include data titles at least once per report.

Quality Control and Assurance

Your quality control plan (QCP) must include aggregate quality control sampling and testing during aggregate lime treatment. Perform sampling and testing in compliance with:

Aggregate Quality Control During Lime Treatment

Quality Characteristic	Test Method	Minimum sampling and testing frequency
Sand Equivalent	CT 217	Once per 1,000 tons of aggregate treated with lime
Percent of crushed particles	CT 205	As necessary and as designated in the QCP
Los Angeles Rattler	CT 211	
Fine aggregate angularity	CT 234	
Flat and elongated particles	CT 235	

Note: During lime treatment, sample coarse and fine aggregate from individual stockpiles. Combine aggregate in the JMF proportions. Run tests for aggregate quality in triplicate and report test results as the average of 3 tests.

The Engineer orders proportioning operations stopped for any of the following if you:

1. Do not submit the treatment data log.
2. Do not submit the aggregate quality control data.
3. Submit incomplete, untimely, or incorrectly formatted data.
4. Do not take corrective actions.
5. Take late or unsuccessful corrective actions.
6. Do not stop treatment when proportioning tolerances are exceeded.
7. Use malfunctioning or failed proportioning devices.

If you stop treatment, notify the Engineer of any corrective actions taken and conduct a successful 20-minute test run before resuming treatment.

For the aggregate to be treated, determine the moisture content at least once during each 2 hours of treatment. Calculate moisture content under California Test 226 or California Test 370 and report it as a percent of dry aggregate weight. Use the moisture content calculations as a set point for the proportioning process controller.

MATERIALS

High-calcium hydrated lime and water must comply with Section 24-1.02, "Materials," of the Standard Specifications.

Before virgin aggregate is treated, it must comply with the aggregate quality specifications. Do not test treated aggregate for quality control except for gradation. The Engineer does not test treated aggregate for acceptance except for gradation.

The Engineer determines the combined aggregate gradation during HMA production after you have treated aggregate. If reclaimed asphalt pavement (RAP) is used, the Engineer determines combined aggregate gradations containing RAP under Laboratory Procedure LP-9.

Treated aggregate must not have lime balls or clods.

CONSTRUCTION

General

Notify the Engineer at least 24 hours before the start of aggregate treatment.

Treat aggregate separate from HMA production.

Do not treat RAP.

Add lime to the aggregate as slurry consisting of mixed dry lime and water at a ratio of 1 part lime to between 2 parts and 3 parts water by weight. The slurry must completely coat the aggregate.

Lime treat and marinate coarse and fine aggregates separately.

Immediately before mixing lime slurry with aggregate, water must not visibly separate from aggregate.

Treat aggregate and stockpile for marination only once.

The lime ratio is the pounds of dry hydrated lime per 100 pounds of dry virgin aggregate expressed as a percent. Water content of slurry or untreated aggregate must not affect the lime ratio.

Lime ratio ranges are:

Aggregate Gradation	Lime Ratio
Coarse	0.4 to 1.0
Fine	1.5 to 2.0
Combined virgin aggregate	0.8 to 1.5

The lime ratio for fine and coarse aggregate must be within ±0.2 percent of the lime ratio in the accepted JMF. The lime ratio must be within ±0.2 percent of the approved lime ratio when you combine the individual aggregate sizes in the JMF proportions. The lime ratio must be determined before the addition of RAP.

If 3 consecutive sets of recorded treatment data indicate deviation more than 0.2 percent above or below the lime ratio in the accepted JMF, stop treatment.

If a set of recorded treatment data indicates a deviation of more than 0.4 percent above or below the lime ratio in the accepted JMF, stop treatment and do not use the material represented by that set of data in HMA.

If 20 percent or more of the total daily treatment indicates deviation of more than 0.2 percent above or below the lime ratio in the accepted JMF, stop treatment and do not use the day's total treatment in HMA.

If you stop treatment for noncompliance, you must implement corrective action and successfully treat aggregate for a 20-minute period. Notify the Engineer before beginning the 20-minute treatment period.

Lime Slurry Proportioning

Proportion lime and water with a continuous or batch operation.

The device controlling slurry proportioning must produce a treatment data log. The log consists of a series of data sets captured at 10-minute intervals throughout daily treatment. The data must be a treatment activity register and not a summation. The material represented by the data set is the amount produced 5 minutes before and 5 minutes after the capture time. For the contract's duration, collected data must be stored by the controller.

Proportioning and Mixing Lime Slurry Treated Aggregate

Treat HMA aggregate by proportioning lime slurry and aggregate by weight in a continuous operation.

Marinate treated aggregate in stockpiles from 24 hours to 60 days before using in HMA. Do not use aggregate marinated longer than 60 days.

10-1.__ HOT MIX ASPHALT AGGREGATE LIME TREATMENT - DRY LIME METHOD

GENERAL

Summary

This work includes treating hot mix asphalt (HMA) aggregate with lime using the dry lime method either with marination or without.

Marinate aggregate if the plasticity index determined under California Test 204 is from 4 to 10.

Submittals

Determine the exact lime proportions for fine and coarse virgin aggregate and submit them as part of the proposed job mix formula (JMF) under Section 39, "Hot Mix Asphalt," of the Standard Specifications.

If marination is required, submit in writing the averaged aggregate quality test results to the Engineer within 24 hours of sampling.

Submit in writing a treatment data log from the dry lime and aggregate proportioning device in the following order:

1. Treatment date
2. Time of day the data is captured
3. Aggregate size being treated
4. HMA type and mix aggregate size
5. Wet aggregate flow rate collected directly from the aggregate weigh belt
6. Aggregate moisture content, expressed as a percent of the dry aggregate weight
7. Flow rate of dry aggregate calculated from the flow rate of wet aggregate
8. Dry lime flow rate
9. Lime ratio from the accepted JMF for each aggregate size being treated
10. Lime ratio from the accepted JMF for the combined aggregate
11. Actual lime ratio calculated from the aggregate weigh belt output, the aggregate moisture input, and the dry lime meter output, expressed as a percent of the dry aggregate weight
12. Calculated difference between the approved lime ratio and the actual lime ratio

Every day during lime treatment, submit the treatment data log on electronic media in tab delimited format on a removable CD-ROM storage disk. Each continuous treatment data set must be a separate record using a line feed carriage return to present the specified data on one line. The reported data must include data titles at least once per report.

Quality Control and Assurance

If marination is required, the quality control plan (QCP) specified in Section 39-2, "Standard," must include aggregate quality control sampling and testing during lime treatment. Perform sampling and testing in compliance with:

Quality Characteristic	Test Method	Minimum sampling and testing frequency
Sand Equivalent	CT 217	Once per 1,000 tons of aggregate treated with lime
Percent of crushed particles	CT 205	As necessary and as designated in the QCP
Los Angeles Rattler	CT 211	
Fine aggregate angularity	CT 234	
Flat and elongated particles	CT 235	

Note: During lime treatment, sample coarse and fine aggregate from individual stockpiles. Combine aggregate in the JMF proportions. Run tests for aggregate quality in triplicate and report test results as the average of 3 tests.

The Engineer orders proportioning operations stopped for any of the following if you:

1. Do not submit the treatment data log
2. Do not submit the aggregate quality control data for marinated aggregate
3. Submit incomplete, untimely, or incorrectly formatted data

4. Do not take corrective actions
5. Take late or unsuccessful corrective actions
6. Do not stop treatment when proportioning tolerances are exceeded
7. Use malfunctioning or failed proportioning devices

If you stop treatment, notify the Engineer of any corrective actions taken and conduct a successful 20-minute test run before resuming treatment.

MATERIALS

Lime must be high-calcium hydrated lime. Lime and water must comply with Section 24-1.02, "Materials," of the Standard Specifications.

Before virgin aggregate is treated, it must comply with the aggregate quality specifications. Do not test treated aggregate for quality control except for gradation. The Engineer does not test treated aggregate for acceptance except for gradation.

The Engineer determines the combined aggregate gradation during HMA production after you have treated aggregate. If reclaimed asphalt pavement (RAP) is used, the Engineer determines combined aggregate gradations containing RAP under Laboratory Procedure LP-9.

Treated aggregate must not have lime balls or clods.

CONSTRUCTION

General

Notify the Engineer in writing at least 24 hours before the start of aggregate treatment.

Do not treat RAP.

If marination is required:

1. Treat and marinate coarse and fine aggregates separately.
2. Treat aggregate and stockpile for marination only once.
3. Treat aggregate separate from HMA production.

The lime ratio is the pounds of dry hydrated lime per 100 pounds of dry virgin aggregate expressed as a percent. Water content of untreated aggregate must not affect the lime ratio.

Lime ratio ranges are:

Aggregate Gradation	Lime Ratio
Coarse	0.4 to 1.0
Fine	1.5 to 2.0
Combined virgin aggregate	0.8 to 1.5

The lime ratio for fine and coarse aggregate must be within ±0.2 percent of the lime ratio in the accepted JMF. The lime ratio must be within ±0.2 percent of the approved lime ratio when you combine the individual aggregate sizes in the JMF proportions. Determine the lime ratio before you add RAP.

Proportion dry lime by weight with a continuous operation.

The device controlling dry lime and aggregate proportioning must produce a treatment data log. The log consists of a series of data sets captured at 10-minute intervals throughout daily treatment. The data must be a treatment activity register and not a summation. The material represented by a data set is the amount produced 5 minutes before and 5 minutes after the capture time. For the duration of the contract, collected data must be stored by the controller.

If 3 consecutive sets of recorded treatment data indicate deviation more than 0.2 percent above or below the lime ratio in the accepted JMF, stop treatment of lime treated aggregates.

If a set of recorded treatment data indicates a deviation of more than 0.4 percent above or below the lime ratio in the accepted JMF, stop treatment of lime treated aggregates and do not use the material represented by that set of data in HMA.

If 20 percent or more of the total daily treatment indicates deviation of more than 0.2 percent above or below the lime ratio in the accepted JMF, stop treatment and do not use the day's treated aggregate in HMA.

If you stop treatment for noncompliance, you must implement corrective action and successfully treat aggregate for a 20-minute period. Notify the Engineer before beginning the 20-minute treatment period.

If you use a batch-type proportioning operation for HMA production, control proportioning in compliance with the specifications for continuous mixing plants. Use a separate dry lime aggregate treatment operation from HMA batching operations including:

1. Pugmill mixer
2. Controller
3. Weigh belt for the lime
4. Weigh belt for the aggregate

If using a continuous mixing operation for HMA without lime marinated aggregates, use a controller that measures the blended aggregate weight after any additional water is added to the mixture. The controller must determine the amount of lime added to the aggregate from the aggregate weigh belt input in connection with the manually input total aggregate moisture, the manually input target lime content, and the lime proportioning system output. Use a continuous aggregate weigh belt and pugmill mixer for the lime treatment operation in addition to the weigh

belt for the aggregate proportioning to asphalt binder in the HMA plant. If you use a water meter for moisture control for lime treatment, the meter must comply with MPQP.

At the time of mixing dry lime with aggregate, the aggregate moisture content must ensure complete lime coating. The aggregate moisture content must not cause aggregate to be lost between the point of weighing the combined aggregate continuous stream and the dryer. Add water for mixing and coating aggregate to the aggregate before dry lime addition. Immediately before mixing lime with aggregate, water must not visibly separate from aggregate.

The HMA plant must be equipped with a bag house dust system. Material collected in the dust system must be returned to the mix.

Mixing Dry Lime and Aggregate

Mix aggregate, water, and dry lime with a continuous pugmill mixer with twin shafts. Immediately before mixing lime with aggregate, water must not visibly separate from aggregate. Store dry lime in a uniform and free flowing condition. Introduce dry lime to the pugmill in a continuous operation. The introduction must occur after the aggregate cold feed and before the point of proportioning across a weigh belt and the aggregate dryer. Prevent loss of dry lime.

If marination is required, marinate treated aggregate in stockpiles between 24 hours and 60 days before using in HMA. Do not use aggregate marinated more than 60 days.

The pugmill must be equipped with paddles arranged to provide sufficient mixing action and mixture movement. The pugmill must produce a homogeneous mixture of uniformly coated aggregates at mixer discharge.

If the aggregate treatment operation is stopped longer than 1 hour, clean the equipment of partially treated aggregate and lime.

Aggregate must be completely treated before introduction into the mixing drum.

10-1.__ LIQUID ANTISTRIP TREATMENT

GENERAL

Summary

This work includes treating asphalt binder with liquid antistrip (LAS) treatment to bond the asphalt binder to aggregate in hot mix asphalt (HMA).

Submittals

For LAS, submit with the proposed job mix formula (JMF) submittal under Section 39, "Hot Mix Asphalt," of the Standard Specifications:

1. Materials Safety Data Sheet (MSDS)

2. One 1-pint sample
3. Infrared analysis including copy of absorption spectra

Submit a certified copy of test results and a MSDS for each LAS lot.

Submit a Certificate of Compliance under Section 6-1.07, "Certificates of Compliance," of the Standard Specifications for each LAS shipment. With each certificate also submit:

1. Your signature and printed name
2. Shipment number
3. Material type
4. Material specific gravity
5. Refinery
6. Consignee
7. Destination
8. Quantity
9. Contact or purchase order number
10. Shipment Date

Submit proportions for LAS as part of the JMF submittal specified in Section 39-1.03, "Hot Mix Asphalt Mix Design Requirements," of the Standard Specifications. If you change the brand or type of LAS, submit a new JMF.

For each job site delivery of LAS, submit one 1/2-pint sample to the Transportation Laboratory. Submit shipping documents to the Engineer. Label each LAS sampling container with:

1. LAS type
2. Application rate
3. Sample date
4. Contract number

At the end of each day's production shift, submit production data in electronic and printed media. Present data on electronic media in tab delimited format. Use line feed carriage return with one separate record per line for each production data set. Allow sufficient fields for the specified data. Include data titles at least once per report. For each mixing operation type, submit in order:

1. Batch Mixing:

    1.1. Production date
    1.2. Time of batch completion
    1.3. Mix size and type
    1.4. Each ingredient's weight
    1.5. Asphalt binder content as percentage of dry aggregate weight

1.6. LAS content as percentage of asphalt binder weight

2. Continuous Mixing:

2.1. Production date
2.2. Data capture time
2.3. Mix size and type
2.4. Flow rate of wet aggregate collected directly from the aggregate weigh belt
2.5. Aggregate moisture content as percentage of dry aggregate weight
2.6. Flow rate of asphalt binder collected from the asphalt binder meter
2.7. Flow rate of LAS collected from the LAS meter
2.8. Asphalt binder content as percentage of dry aggregate weight calculated from:

2.8.1. Aggregate weigh belt output
2.8.2. Aggregate moisture input
2.8.3. Asphalt binder meter output

2.9. LAS content as percentage of asphalt binder weight calculated from:

2.9.1. Asphalt binder meter output
2.9.2. LAS meter output

Quality Control and Assurance

For continuous mixing and batch mixing operations, sample asphalt binder before adding LAS. For continuous mixing operations, sample combined asphalt binder and LAS after the static mixer.

The Engineer orders proportioning operations stopped for any of the following if you:

1. Do not submit data
2. Submit incomplete, untimely, or incorrectly formatted data
3. Do not take corrective actions
4. Take late or unsuccessful corrective actions
5. Do not stop production when proportioning tolerances are exceeded
6. Use malfunctioning or failed proportioning devices

If you stop production, notify the Engineer of any corrective actions taken before resuming.

MATERIALS

LAS-treated asphalt binder must comply with Section 39, "Hot Mix Asphalt," of the Standard Specifications. LAS does not substitute for asphalt binder.

LAS total amine value must be 325 minimum when tested under ASTM D 2074.

Use only 1 LAS type or brand at a time. Do not mix LAS types or brands.

Store and mix LAS under the manufacturer's recommendations.

CONSTRUCTION

LAS must be between 0.5 and 1.0 percent by weight of asphalt binder.

If 3 consecutive sets of recorded production data show actual delivered LAS weight is more than ±1 percent of the approved mix design LAS weight, stop production and take corrective action.

If a set of recorded production data shows actual delivered LAS weight is more than ±2 percent of the approved mix design LAS weight, stop production. If the LAS weight exceeds 1.2 percent of the asphalt binder weight, do not use the HMA represented by that data.

The continuous mixing plant controller proportioning the HMA must produce a production data log. The log consists of a series of data sets captured at 10-minute intervals throughout daily production. The data must be a production activity register and not a summation. The material represented by the data is the amount produced 5 minutes before and 5 minutes after the capture time. For the duration of the contract, collected data must be stored by the plant controller or a computer's memory at the plant.