October 31, 2013

REVISION OF SECTION 713

EPOXY PAVEMENT MARKING

**NOTICE**

This is a standard special provision that revises or modifies CDOT’s *Standard Specifications for Road and Bridge Construction.* It has gone through a formal review and approval process and has been issued by CDOT’s Project Development Branch with formal instructions for its use on CDOT construction projects. It is to be used as written without change. Do not use modified versions of this special provision on CDOT construction projects, and do not use this special provision on CDOT projects in a manner other than that specified in the instructions unless such use is first approved by CDOT’s Standards and Specifications Unit. The instructions for use on CDOT construction projects appear below.

Other agencies which use the *Standard Specifications for Road and Bridge Construction* to administer construction projects may use this special provision as appropriate and at their own risk.

**Instructions for use on CDOT construction projects:**

Use in projects having epoxy pavement marking.

October 31, 2013

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Section 713 of the Standard Specifications is hereby revised for this project as follows:

Delete subsection 713.17 and replace with the following:

**713.17 Epoxy Pavement Marking Material.**  Only epoxy pavement marking material that is on the Department's Approved Products List may be used. Batches or lots of approved products will be accepted on the project by certified test report (CTR). The CTR shall confirm that the material meets all CDOT requirements and is the same material that was preapproved in the product evaluation process.

1. *Formulation.*  Epoxy pavement marking material shall be a two component, 100 percent solids, material formulated to provide simple volumetric mixing ratio of two volumes of component A and one volume of component B unless otherwise recommended by the material manufacturer.
2. *Composition.*  The component A of both white and yellow shall be within the following limits:

**Resin / Pigment Components (% by Weight)**

|  |  |  |
| --- | --- | --- |
| **Pigment** | **WHITE:** | **YELLOW:** |
| TiO2, ASTM D476, Type II | 18-25 | 10-17 |
| Organic Yellow |  | 6-10 |
| Epoxy Resin | 75-82 | 73-84 |

The pigment for yellow epoxy shall contain no lead or other material such that the cured epoxy could be considered a hazardous waste under EPA or CDPHE regulations. The Contractor shall submit to the Engineer a manufacturer's certification of compliance with this requirement.

1. *Epoxide Number.*  The epoxy number of the epoxy resin shall be the manufacturers target value ± 50 as determined by ASTM D 1652 for white and yellow component A on pigment free basis.
2. *Amine Number.* The amine number on the curing agent (component B) shall be the manufacturers target value ± 50 per ASTM D 2071.
3. *Toxicity.*  Upon heating to application temperature, the material shall not produce fumes which are toxic or injurious to persons or property.
4. *Color.*  The epoxy material, without drop-on beads, shall visually match the color chips that visually correspond to the Federal Standard Number 595B for the following colors:

White - Federal Standard No. 595B-17925.

 Yellow - Federal Standard No. 595B-13538.

The mixed epoxy compound, both white and yellow, when applied to 3 inch x 6 inch aluminum panels at 20 ± 1 mil of thickness with no glass beads and exposed in the Q-panel Ultraviolet (QUV) Environmental Testing Chamber as described in ASTM G 154, shall conform to the following minimum requirements. The test shall be conducted for 72 hours at 122º F, 4 hours humidity, and 4 hours U.V., in alternating cycles. The color of the coatings shall be within ± 5 units of the Federal Standards shown above.

1. *Yellowness Index.* The Yellowness Index shall be tested in accordance with ASTM E-313. The prepared Q-panels shall be cured at 77° F for 72 hours prior to exposure. Immediately after this, the yellow index reading QUV at XYZ C/2° shall be measured. QUV testing shall begin after this initial measurement and shall conform to ASTM G-53. The QUV prior to testing shall not exceed 8.0. The QUV after 72-hour testing shall not exceed 20.0. The QUV after 500-hour testing shall not exceed 35.0
2. *Drying Time.* The epoxy pavement marking material shall have a setting time to a no-tracking condition of not more than 25 minutes at a temperature of 73° F and above.
3. *Curing.*  The epoxy material shall be capable of fully curing under the constant surface temperature condition of 35° F and above.

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1. *Adhesion to Concrete.* The catalyzed epoxy pavement marking material, when tested according to ACI Method 503, shall *have* such a high degree of adhesion to the specified (4000 psi minimum) concrete surface that there shall be a 100 percent concrete failure in the performance of this test
2. *Hardness.*  The epoxy pavement marking materials, when tested according to ASTM D 2240, shall have a minimum Shore D Hardness value of 80. Samples shall be allowed to cure at room temperature, 75 ± 2 °F for a minimum of 72 hours and a maximum of 168 hours prior to performing the indicated test.
3. *Abrasion Resistance.*  The abrasion resistance shall be evaluated on Taber Abrader with a 1000 gram load and CS-17 wheels. The duration of the test shall be 1000 cycles. The wear index shall be calculated based on ASTM test method C-501 and the wear index for the catalyzed material shall not be more than 80. The tests shall be run on cured samples of material which have been applied at film thickness of 15 ± ½ mils to code S-16 stainless steel plates. The samples shall be allowed to cure at 75 ± 2 °F for a minimum of 72 hours prior to performing the indicated tests.
4. *Tensile Strength.*  When tested according to ASTM D 638, the epoxy pavement marking materials shall have a tensile strength of not less than 6000 psi. The Type IV Specimens shall be cast in a suitable mold and pulled at the rate of ¼ inch per minute by a suitable dynamic testing machine. The samples shall be allowed to cure at room temperature (75 ± 2 °F) for a minimum of 72 hours and a maximum of 168 hours prior to performing the indicated tests.
5. *Compressive Strength.*  When tested according to ASTM D 695, the catalyzed epoxy pavement marking materials shall have a compressive strength of not less than 12,000 psi. The cast sample shall be conditioned at room temperature, 75 ± 2 °F, for a minimum of 72 hours and a maximum of 168 hours prior to performing the tests. The rate of compression of these samples shall be no more than ¼ inch per minute.