

<b>COLORADO DEPARTMENT OF TRANSPORTATION SUBMITTAL OF NEW SPECIFICATION OR SPECIFICATION CHANGE</b>		Log No. (Assigned by Standards and Specifications Unit) 105-7-fy21
TO: Standards & Specifications Unit Project Development Branch		FROM: Michael Stanford / MAC (Region, Branch or Technical Committee)
SPECIFICATION SECTION NO. 105, 106 & 401	ITEM Longitudinal Joint Density	Priority Routine <input checked="" type="checkbox"/> Fast <input type="checkbox"/>
Reason for this new or changed specification:  This Pilot Project Specification will increase the requirements for Longitudinal Joint Density for HMA and SMA Pavements. This specification was a collaboration between CDOT and the Asphalt Industry. This Pilot Project Specification is intended to be used on a minimum of two projects per Region, in the 2021 and 2022 construction season. At the end of 2022, the test data for the Pilot Projects will be evaluated, with the intent of have this specification become the new standard for Longitudinal Joint Density.  The change to this Longitudinal Joint Density Specification was presented to the Asphalt Industry in the Spring of 2021 and approved by the Materials Advisory Committee in May of 2021.		
New or Revised Specification:  See Attached		
NOTE: See Procedural Directive 513.1 for a description of appropriate specification development procedures.		

## REVISION OF SECTION 105 CONTROL OF WORK

Revise Section 105 of the Standard Specifications as follows:

Delete subsection 105.05 and replace with the following:

**105.05 Conformity to the Contract of Hot Mix Asphalt.** Conformity to the Contract of all Hot Mix Asphalt, Item 403, except Hot Mix Asphalt (Patching) and temporary pavement will be determined by tests and evaluations of elements that include asphalt content, gradation, in-place density, and joint density in accordance with the following: All work performed and all materials furnished shall conform to the lines, grades, cross sections, dimensions, and material requirements, including tolerances, shown in the Contract.

When the Engineer finds the materials or work furnished, work performed, or the finished product are not in conformity with the Contract and has resulted in an inferior or unsatisfactory product, the work or material shall be removed and replaced or otherwise corrected at the expense of the Contractor.

Materials will be sampled randomly and tested by the Department in accordance with subsection 106.05 and with the applicable procedures contained in the Department's Field Materials Manual. The approximate maximum quantity represented by each sample will be as set forth in subsection 106.05. Additional samples may be selected and tested as set forth in subsection 106.05 at the Engineer's discretion.

A process will consist of either a single test value or a series of values resulting from related tests of an element of the Contractor's work and materials. An element is a material or workmanship property that can be tested and evaluated for quality level by the Department approved sampling, testing, and analytical procedures. All materials produced will be assigned to a process. A change in process is defined as a change that affects the element involved. For any element, with the exception of the joint density element, a process normally will include all produced materials associated with that element prior to a change in the job mix formula (Form 43). For joint density, a new process will be established for each new layer of pavement or for changes in joint construction. Density measurements taken within each compaction test section will be a separate process. The Engineer may separate a process in order to accommodate small quantities or unusual variations.

Evaluation of materials for pay factors (PF) will be done using only the Department's acceptance test results. Each process will have a PF computed in accordance with the requirements of this Section. Test results determined to have sampling or testing errors will not be used.

Except for density measurements taken within a compaction test section, any test result for an element greater than the distance 2 times V (see Table 105-2) outside the tolerance limits will be designated as a separate process and the pay factor will be calculated in accordance with subsection 105.05(a). A pay factor less than zero shall be zero. The calculated PF will be used to determine the Incentive or Disincentive Payment (I/DP) for the process.

In the case of in-place density or joint density, the Contractor will be allowed to core the exact location (or immediately adjacent location for joint density) of a test result more than 2 times V outside the tolerance limit. The core must be taken and furnished to the Engineer within eight hours after notification by the Engineer of the test result. The result of this core will be used in lieu of the previous test result. Cores not taken within eight hours after notification by the Engineer will not be used in lieu of the test result. All costs associated with coring shall be at the Contractor's expense.

(a) *Representing Small Quantities.* When it is necessary to represent a process by only one or two test results, PF will be the average of PFs resulting from the following:

If the test result is within the tolerance limits then

$$\text{PF} = 1.00$$

If the test result is above the maximum specified limit, then

$$\text{PF} = 1.00 - [0.25(T_O - T_U)/V]$$

If the test result is below the minimum specified limit, then

$$PF = 1.00 - [0.25(T_L - T_O)/V]$$

Where: PF = pay factor.

V = V factor from Table 105-2.

T<sub>O</sub> = the individual test result.

T<sub>U</sub> = upper specification limit.

T<sub>L</sub> = lower specification limit.

The calculated PF will be used to determine the I/DP for the process.

- (b) *Determining Quality Level.* Each process with three or more test results will be evaluated for a quality level (QL) in accordance with Colorado Procedure 71.
- (c) *Gradation Element.* Each specified sieve, with the exception of 100 percent passing sieves, will be evaluated for QL separately. The lowest calculated QL for a sieve will be designated as the QL for gradation element for the process.
- (d) *Joint Density Element.* Joint Density will be tested according to subsection 401.17.

If the Joint Density test result is 88.0%-89.9% then

$$PF=1.00$$

If the Joint Density test result is 90.0% or above, then PF follows Table 105-3

- (e) *Process Pay Factor.* Using the calculated QL for the process, compute the PF as follows: The final number of random samples (P<sub>n</sub>) in each process will determine the final pay factor. As test values are accumulated for each process, P<sub>n</sub> will change accordingly. When the process has been completed, the number of random samples it contains will determine the computation of PF, based on Table 105-3 and formula (1) below. When P<sub>n</sub> is from 3 to 9, or greater than 200, PF will be computed using the formulas designated in Table 105-3. Where P<sub>n</sub> is equal to or greater than 10 and less than 201, PF will be computed by Formula (1):

$$PF = \frac{PF_1 + PF_2}{2} + \left[ \frac{PF_2 + PF_3}{2} - \frac{PF_1 + PF_2}{2} \right] \cdot \frac{(P_{n_2} - P_{n_x})}{(P_{n_2} - P_{n_3})}$$

**Formula (1)**

Where, when referring to Table 105-3:

PF<sub>1</sub>= PF determined at the next lowest P<sub>n</sub> formula using process QL

PF<sub>2</sub>= PF determined using the P<sub>n</sub> formula shown for the process QL

PF<sub>3</sub>= PF determined at the next highest P<sub>n</sub> formula using process QL

P<sub>n<sub>2</sub></sub>= the lowest P<sub>n</sub> in the spread of values listed for the process P<sub>n</sub> formula

P<sub>n<sub>3</sub></sub>= the lowest P<sub>n</sub> in the spread of values listed for the next highest P<sub>n</sub> formula

P<sub>n<sub>x</sub></sub>= the actual number of test values in the process

When evaluating the item of Furnish Hot Mix Asphalt, the PF for the element of In-Place Density shall be 1.0.

Regardless of QL, the maximum PF in relation to P<sub>n</sub> is limited in accordance with Table 105-3.

As test results become available, they will be used to calculate QL and PF numbers for each process. The process I/DPs will then be calculated and accumulated for each element and for the item. The test results and the accumulated calculations will be made available to the Contractor upon request.

Numbers from the calculations will be carried to significant figures and rounded according to AASHTO Standard Recommended Practice R-11, Rounding Method.

- (f) *Evaluation of Work.* When the PF of a process is 0.75 or greater, the finished quantity of work represented by the process will be accepted at the appropriate pay factor. If the PF is less than 0.75, the Engineer may:
- (1) Require complete removal and replacement with specification material at the Contractor's expense; or

- (2) Where the finished product is found to be capable of performing the intended purpose and the value of the finished product is not affected, permit the Contractor to leave the material in place.

If the material is permitted to remain in place, the PF for the process will not be greater than 0.75. When condition red, as described in subsection 106.05(g), exists for any element, resolution and correction will be in accordance with Section 106. Material which the Engineer determines is defective may be isolated and rejected without regard to sampling sequence or location within a process.

If removal and replacement is required because the joint density PF for a process is below 0.75, the Contractor shall remove and replace the full lane width adjacent to and including at least 6 inches beyond the visible joint line for the entire length of joint representing the process. If the lane removed is adjacent to another joint, that joint shall also be removed to a point 6 inches beyond the visible joint line. When a single joint density core is more than 2V outside the tolerance limits, the removal and replacement limits shall be identified by coring the failing joint at 25 foot intervals until two successive cores are found to be 1V or less below the minimum tolerance limit. If removal and replacement is required, the Contractor shall submit documentation identifying the process to be used to correct the area in question in writing. The process will be approved by the Engineer before commencing the corrective work.

**Table 105-2**  
**“W” and “V” Factors For Various Elements**

<b>Hot Mix Asphalt</b>		
<b>Element</b>	<b>V Factor</b>	<b>W Factor</b>
2.36 mm (No. 8) mesh and larger sieves	2.80	N/A
600 µm (No. 30) mesh sieve	1.80	N/A
75 µm (No. 200) mesh sieve	0.80	N/A
Gradation	N/A	15
Asphalt Content	0.20	25
In-place Density	1.10	45
Joint Density <sup>‡</sup>	1.60	15
<sup>‡</sup> 2V will be evaluated off of the 88% Joint Density.		

**Table 105-3**  
**Formulas For Calculating PF Based on Pn**

<b>Pn</b>	<b>When Pn as shown at left is 3 to 9, or greater than 200, use designated formula below to calculate Pay Factor, PF = ..., when Pn is 10 to 200, use formula (1) above:</b>	<b>Maximum PF</b>
3	$0.31177 + 1.57878 (QL/100) - 0.84862 (QL/100)^2$	1.025
4	$0.27890 + 1.51471 (QL/100) - 0.73553 (QL/100)^2$	1.030
5	$0.25529 + 1.48268 (QL/100) - 0.67759 (QL/100)^2$	1.030
6	$0.19468 + 1.56729 (QL/100) - 0.70239 (QL/100)^2$	1.035
7	$0.16709 + 1.58245 (QL/100) - 0.68705 (QL/100)^2$	1.035
8	$0.16394 + 1.55070 (QL/100) - 0.65270 (QL/100)^2$	1.040
9	$0.11412 + 1.63532 (QL/100) - 0.68786 (QL/100)^2$	1.040
10 to 11	$0.15344 + 1.50104 (QL/100) - 0.58896 (QL/100)^2$	1.045
12 to 14	$0.07278 + 1.64285 (QL/100) - 0.65033 (QL/100)^2$	1.045
15 to 18	$0.07826 + 1.55649 (QL/100) - 0.56616 (QL/100)^2$	1.050
19 to 25	$0.09907 + 1.43088 (QL/100) - 0.45550 (QL/100)^2$	1.050
26 to 37	$0.07373 + 1.41851 (QL/100) - 0.41777 (QL/100)^2$	1.055
38 to 69	$0.10586 + 1.26473 (QL/100) - 0.29660 (QL/100)^2$	1.055
70 to 200	$0.21611 + 0.86111 (QL/100)$	1.060
$\geq 201$	$0.15221 + 0.92171 (QL/100)$	1.060

(g) *Process I/DP Computation.*

$$I/DP = (PF - 1)(QR)(UP)(W/100)$$

Where: I/DP = Incentive or Disincentive Payment

PF = Pay Factor

QR = Quantity in Tons of HMA Represented by the Process

UP = Unit Bid Price of Asphalt Mix

W = Element factor from Table 105-2

When AC is paid for separately, UP shall be:

$$UP = [(Ton_{HMA})(UP_{HMA}) + (Ton_{AC})(UP_{AC})] / Ton_{HMA}$$

Where:  $Ton_{HMA}$  = Tons of Asphalt Mix

$UP_{HMA}$  = Unit Bid Price of Asphalt Mix

$Ton_{AC}$  = Tons of Asphalt Cement

$UP_{AC}$  = Unit Bid Price of Asphalt Cement

For the joint density element:

$$UP = UP_{HMA}$$

Where:  $UP_{HMA}$  is as defined above

When AC is paid for separately, UP shall be:

$$UP = [(BTon_{HMA})(BUP_{HMA}) + (BTon_{AC})(BUP_{AC})] / (BTon_{HMA})$$

Where:  $BTon_{HMA}$  = Bid Tons of Asphalt Mix

$BUP_{HMA}$  = Unit Bid Price of Asphalt Mix

$BTon_{AC}$  = Bid Tons of Asphalt Cement

$BUP_{AC}$  = Unit Bid Price of Asphalt Cement

- (h) *Element I/DP.* The I/DP for an element shall be computed by accumulating the process I/DPs for that element.
- (i) *I/DP for a Mix Design.* The I/DP for a mix design shall be computed by accumulating the process I/DPs for the asphalt content, in-place density, and gradation elements for that mix design. The accumulated quantities of materials for each element must be the same at the end of I/DP calculations for a mix design.
- (j) *Project I/DP.* The I/DP for the project shall be computed by accumulating the mix design I/DPs and the joint density I/DPs. The accumulated quantities of materials for each element must be the same at the end of I/DP calculations for the project.

## REVISION OF SECTION 106 CONTROL OF MATERIAL

Revise Section 106 of the Standard Specifications as follows:

Delete subsection 106.05 and replace with the following:

**106.05 Sampling and Testing of Hot Mix Asphalt.** All HMA, Item 403, except HMA (Patching) and temporary pavement shall be tested in accordance with the following program of process control testing and acceptance testing:

- (a) *Process Control Testing.* The Contractor shall be responsible for process control testing on all elements listed in Table 106-1. Process control testing shall be performed at the expense of the Contractor. The Contractor shall develop a process control plan (PCP) in accordance with the following:
1. **Process Control Plan.** For each element listed in Table 106-1, the PCP must provide adequate details to ensure that the Contractor will perform process control. The Contractor shall submit the PCP to the Engineer at the Pre-construction Conference. The Contractor shall not start any work on the project until the Engineer has approved the PCP in writing.
    - A. **Frequency of Tests or Measurements.** The PCP shall indicate a random sampling frequency, which shall not be less than that shown in Table 106-1. The process control tests shall be independent of acceptance tests.
    - B. **Worksheets, Forms, and Charts.** The Contractor shall submit examples of worksheets, test result forms, and test results charts in accordance with CP 12 as part of the PCP.
    - C. **Test Result Chart.** Each process control test result, the appropriate tonnage and the tolerance limits shall be plotted. For in place density tests, only results after final compaction shall be shown. The chart shall be posted daily at a location convenient for viewing by the Engineer.
    - D. **Quality Level Chart.** The Quality Level (QL) for each element used to calculate incentive or disincentive in Table 106-1 and each required sieve size shall be plotted. The QL will be calculated in accordance with the procedure in CP 71 for Determining Quality Level (QL). The QL will be calculated on tests 1 through 3, then tests 1 through 4, then tests 1 through 5, then thereafter the last five consecutive test results. The tonnage of material represented by the last test result shall correspond to the QL. For in place density tests, only results after final compaction shall be shown. The chart shall be posted daily at a location convenient for viewing by the Engineer.
  2. **Elements Not Conforming to Process Control.** The QL of each discrete group of five test results, beginning with the first group of five test results, shall be a standard for evaluating material not conforming to process control. When the group QL is below 65, the process shall be considered as not conforming to the PCP. In this case, the Contractor shall take immediate action to bring the process back into control. Except where the cause of the problem is readily apparent and corrected without delay, production shall be suspended until the source of the problem is determined and corrected. A written explanation of actions taken to correct control problems shall accompany the test data and be submitted to the Engineer on the day the actions are taken.
  3. **Point of Sampling.** The material for process control testing shall be sampled by the Contractor using approved procedures. Acceptable procedures are Colorado Procedures, AASHTO and ASTM. The order of precedence is Colorado Procedures, AASHTO procedures and then ASTM procedures. The location where material samples will be taken shall be indicated in the PCP.
  4. **Testing Standards.** The PCP shall indicate which testing standards will be followed. Acceptable standards are Colorado Procedures, AASHTO and ASTM. The order of precedence is Colorado Procedures, AASHTO procedures and then ASTM procedures.
  5. **Testing Supervisor Qualifications.** The person responsible for the process control sampling and testing shall be identified in the PCP and be qualified according to the requirements of CP 10

6. **Technician Qualifications.** Technicians taking samples and performing tests must be qualified according to the requirements of CP 10.
  7. **Testing Equipment.** All of the testing equipment used to conduct process control testing shall conform to the standards specified in the test procedures and be in good working order. Nuclear testing devices used for process control testing of in-place density do not have to be calibrated on the Department's calibration blocks.
  8. **Reporting and Record Keeping.** The Contractor shall report the results of the process control tests to the Engineer in writing at least once per day. The Contractor shall assemble a process control (PC) notebook and update it daily. This notebook shall contain all worksheets, test results forms, test results charts and quality level charts for each of the elements listed in Table 106-1. The Contractor shall submit the PC notebook to the Engineer for review once a month on the date agreed to at the Pre-Paving Conference. The PC notebook will be returned to the Contractor within one working day after submittal. The Engineer will notify the Contractor in writing of any deficiencies in the PC notebook, including the failure to submit the notebook on time or an absence of the required reports. Upon the second failure to submit the complete PC notebook on time or with an absence of the required reports, the Engineer will notify the Contractor, and the pay estimate will be withheld until the Contractor submits, in writing, a report detailing the cause for the failure to submit the complete PC notebook on time or the cause for the absence of required reports. The report shall include how the Contractor plans to resolve the failures. Additional failures to submit the PC notebook on time or absent the required reports will result in a delay of the pay estimate until the Contractor has identified and resolved the failure along with revising and resubmitting his PCP to address these issues. Once the Engineer has reviewed and approved the revised PCP the estimate may be paid. Upon submittal of the PC notebook for the semi-final estimate, the PC notebook shall become the property of the Department. The Contractor shall make provisions such that the Engineer can inspect process control work in progress, including PC notebook, sampling, testing, plants, and the Contractor's testing facilities at any time.
- (b) *Acceptance Testing.* Acceptance testing is the responsibility of the Department and shall not be addressed in the PCP. The Department will determine the locations where samples or measurements are to be taken. The maximum quantity of material represented by each test result and the minimum number of test results will be in accordance with Table 106-1. The location or time of sampling will be based on a stratified random procedure as described in CP 75. Acceptance sampling and testing procedures will be in accordance with the Schedule for Minimum Materials Sampling, Testing and Inspection in the Department's Field Materials Manual. Samples for project acceptance testing shall be taken by the Contractor in accordance with the designated method. The samples shall be taken in the presence of the Engineer. Where appropriate, the Contractor shall reduce each sample to the size designated by the Engineer. The Contractor may retain a split of each sample which cannot be included as part of the PCP.

If the Contractor elects to question the Hot Mix Asphalt (HMA) acceptance test results, the steps outlined in CP 17 shall be followed. The results from the CP 17 resolution process shall be binding on both the Department and the Contractor. Requests for CP 17 process for all elements except density shall be submitted in writing to the Engineer within five work days from the date the Contractor receives acceptance test data from the Engineer. The specific element questioned shall be identified in writing. All requests for the CP 17 process for the density element shall be submitted in writing to the Engineer within 24 hours of receiving test data from the Engineer.

The Contractor shall choose either the CDOT Materials and Geotechnical Branch or a consultant laboratory not associated with the project to perform the third party testing. The Contractor shall document his choice in writing at the Pre-Paving Conference. If a consultant laboratory is chosen, the CDOT Materials and Geotechnical Branch will determine the consultant that will be used from a pre-established list and ensure there is no conflict of interest.

If third party testing is required, the responsibility for the testing expenses shall be assigned in accordance with CP 17. The costs for testing are shown in CP 17, Table 17-2.

All materials being used are subject to inspection and testing at any time prior to, during, or after incorporation

into work. Acceptance tests will be made by and at the expense of the Department, except when otherwise provided.

- (c) *Check Testing Program (CTP)*. Prior to, or in conjunction with, placing the first 500 tons of asphalt pavement, under the direction of the Engineer, a CTP will be conducted between acceptance testing and process control testing programs. The CTP will consist of testing for asphalt content, theoretical maximum specific gravity, HMA 4.75 mm (#4) sieve, HMA 2.36 mm (#8) sieve, HMA 0.075 mm (#200) sieve, in-place density, and joint density in accordance with CP 13. If the Contractor intends to test to determine air voids and VMA, check testing for these tests is recommended. The CTP will be continued until the acceptance and process control tests are within the acceptable limits shown in Table 13-1 of CP 13. For joint density, the initial check test will be a comparison of the seven cores tested by CDOT and the seven cores tested by the Contractor. These are the cores from the compaction test section used for nuclear gauge calibration and test section payment.

During production, a split sample check will be conducted at the frequency shown in Table 106-1. Except for joint density, the split samples will be from an acceptance sample obtained in accordance with subsection 106.05(b). The acceptance test result will be compared to the process control test result obtained by the Contractor using the acceptable limits shown in Table 13-1 of CP 13. For joint density, the comparison sample for testing by the Contractor will be obtained by taking a second core adjacent to the joint density acceptance core. The acceptance test result will be compared to the process control test result obtained by the Contractor using the acceptable limits as shown in Table 13-1 of CP 13 and following the check testing procedure given in CP 13.

If production has been suspended and then resumed, the Engineer may order a CTP between process control and acceptance testing persons to assure the test results are within the acceptable limits shown in Table 13-1 of CP 13. Check test results shall not be included in process control testing. The Region Materials Engineer shall be called upon to resolve differences if a CTP shows unresolved differences beyond the values shown in Table 13-1 of CP 13.

- (d) *Stability Verification Testing*. After the mix design has been approved and production commences, the Department will perform a minimum of three stability verification tests to verify that the field produced HMA conforms to the approved mix design:

The test frequency shall be one per day unless otherwise directed by the Engineer.

The test results will be evaluated and the Contractor shall make adjustments if required in accordance with the following:

1. The minimum value for stability will be the minimum specified in Table 403-1 of the specifications. There will be no tolerance limit.
2. Quality Level. Calculate a QL for stability.
  - (b) If the QL for stability is less than 65, then production shall be halted and the Contractor shall submit a written proposal for a mix design revision to the Engineer. The Engineer shall give written approval to the proposed mix design revision before production continues.
  - (c) After a new or revised mix design is approved, three additional stability tests will be performed on asphalt produced with the new or revised mix design. The test frequency shall be one per day unless altered by the Engineer.
  - (d) If the stability QL is less than 65, then production shall be halted until a new mix design has been completed and approved using plant produced material or the Contractor shall submit a written proposal for a mix design revision to the Engineer. The Engineer shall give written approval to the proposed mix design revision before production continues.
3. New or Revised Mix Design. Whenever a new or revised mix design is used and production resumes, three additional stability field verification tests shall be performed and the test results evaluated in accordance with the above requirements. The test frequency shall be one per day unless altered by the Engineer.
4. Field Verification Process Complete. When the field verification process described above is complete and production continues, the sample frequency will revert back to 1 per 10,000 tons.

(e) *Mix Verification Testing.* After the mix design has been approved and production commences, the Department will perform a minimum of three volumetric verification tests for each of the following elements to verify that the field produced Hot Mix Asphalt (HMA) conforms to the approved mix design:

- (1) Air Voids.
- (2) Voids in Mineral Aggregate (VMA).
- (3) Asphalt Content (AC).

The test frequency shall be one per day unless altered by the Engineer.

The test results will be evaluated and the Contractor shall make adjustments if required in accordance with the following:

1. **Target Values.** The target value for VMA will be the average of the first three volumetric field test results on project produced hot mix asphalt or the target value specified in Table 403-1 and Table 403-2 of the specifications, whichever is higher. The target value for VMA will be set no lower than 0.5 percent below the VMA target on Form 43 prior to production. The target values for the test element of air voids and AC shall be the mix design air voids and mix design AC as shown on Form 43.

2. **Tolerance Limits.** The tolerance limits for each test element shall be:

AC	± 0.3 percent
Air Voids	± 1.2 percent
VMA	± 1.2 percent

3. **Quality Levels.** Calculate an individual QL for each of the elements using the volumetric field verification test results. If the QL for VMA or AC is less than 65 or if the QL for air voids is less than 70, the production shall be halted and the Contractor shall submit a written proposal for a mix design revision to the Engineer. Production shall only commence upon receipt of written approval from the Engineer of the proposed mix design revision.

After a new or revised mix design is approved, three additional volumetric field verification tests will be performed on asphalt produced with the new or revised mix design. The test frequency shall be one per day unless altered by the Engineer.

If the QL for VMA or AC is less than 65 or the QL for the test element of air voids is less than 70, then production shall be halted until a new mix design has been completed in accordance with CP 52 or CP 54, a new Form 43 issued, and the Contractor demonstrates that he is capable of producing a mixture meeting the verification requirements in accordance with A or B below:

- A. The Contractor shall produce test material at a site other than a CDOT project. The Contractor shall notify the Engineer a minimum of 48 hours notice prior to the requested test. The location and time of the test are subject to the approval of the Engineer, prior to placement. Three samples will be tested for volumetric properties. If the QL for VMA or AC is equal or greater than 65 and the QL for the element of air voids is equal or greater than 70, full production may resume or;
- B. The Contractor may construct a 500 ton test strip on the project. Three samples in the last 200 tons will be tested for volumetric properties. After construction of the test section, production shall be halted until the testing is complete and element QLs are calculated. If the QL for VMA or AC is equal to or greater than 65 or the QL for the element of air voids is equal to or greater than 70, full production may resume. If the QL for VMA or AC is less than 65 or the QL for the element of air voids is less than 70, the material shall be removed and replaced at no cost to the Department. The time count will continue, and any delay to the project will be considered to have been caused by the Contractor and will not be compensable.

The costs associated with mix designs shall be solely at the Contractor's expense.

If the Contractor fails to verify the new mix design in accordance with A or B, then production shall be halted until a new mix design has been completed in accordance with CP 52 or CP 54, a new Form 43 issued, and the Contractor demonstrates they are capable of producing a mixture meeting the verification

requirements in accordance with A or B.

4. New or Revised Mix Design. Whenever a new or revised mix design is used and production resumes, three additional volumetric field verification tests shall be performed and the test results evaluated in accordance with the above requirements. The test frequency shall be one per day unless altered by the Engineer.
  5. Field Verification Process Complete. When the field verification process described above is complete and production continues, the sample frequency will revert back to a minimum of 1/10,000 tons. The Engineer has the discretion to conduct additional verification tests at any time.
- (f) *Testing Schedule.* Process control and project acceptance testing frequency shall be in accordance with Table 106-1.
- (g) *Reference Conditions.* Three reference conditions can exist determined by the Moving Quality Level (MQL). The MQL will be calculated in accordance with the procedure in CP 71 for Determining Quality Level (QL). The MQL will be calculated using only acceptance tests. The MQL will be calculated on tests 1 through 3, then tests 1 through 4, then tests 1 through 5, then thereafter on the last five consecutive test results. The MQL will not be used to determine pay factors. The three reference conditions and actions that will be taken are described as follows:
1. Condition green will exist for an element when an MQL of 90 or greater is reached, or maintained, and the past five consecutive test results are within the specification limits.
  2. Condition yellow will exist for all elements at the beginning of production or when a new process is established because of changes in materials or the job-mix formula, following an extended suspension of work, or when the MQL is less than 90 and equal to or greater than 65. Once an element is at condition green, if the MQL falls below 90 or a test result falls outside the specification limits, the condition will revert to yellow or red as appropriate.
  3. Condition red will exist for any element when the MQL is less than 65. The Contractor shall be notified immediately in writing and the process control sampling and testing frequency increased to a minimum rate of 1 per 250 tons for that element. The process control sampling and testing frequency shall remain at 1 per 250 tons until the process control QL reaches or exceeds 78. If the QL for the next five process control tests is below 65, production will be suspended.

If gradation is the element with MQL less than 65, the Department will test one randomly selected sample in the first 1250 tons produced in condition red. If this test result is outside the tolerance limits, production will be suspended. (This test result will not be included as an acceptance test.)

After condition red exists, a new MQL will be started. Acceptance testing will stay at the frequency shown in Table 106-1. After three acceptance tests, if the MQL is less than 65, production will be suspended.

Production will remain suspended until the source of the problem is identified and corrected. Each time production is suspended, corrective actions shall be proposed in writing by the Contractor and approved in writing by the Engineer before production may resume.

Upon resuming production, the process control sampling and testing frequency for the elements causing the condition red shall remain at 1 per 250 tons. If the QL for the next five process control tests is below 65, production will be suspended again. If gradation is the element with MQL less than 65, the Department will test one randomly selected sample in the first 1250 tons produced in condition red. If this test result is outside the tolerance limits, production will be suspended.

**Table 106-1  
SCHEDULE FOR MINIMUM SAMPLING AND  
TESTING FOR HMA**

<b>Element</b>	<b>Process Control</b>	<b>Acceptance<sup>1,2</sup></b>	<b>Check (CTP)</b>
Asphalt Content	1/500 tons	1/1000 tons	1/10,000 tons
Gradation	1/Day	1/2000 tons	1/20,000 tons
Theoretical Maximum Specific Gravity	1/1000 tons, minimum 1/Day	1/1000 tons, minimum 1/Day	1/10,000 tons
In-place Density	1/500 tons	1/500 tons	1/5000 tons
Joint Density	1 core/2500 linear feet of joint	1 core/5000 linear feet of joint	1 core/50,000 linear feet of joint
Aggregate Percent Moisture <sup>3</sup>	1/2000 tons, minimum 1/Day	1/2000 tons	Not applicable
Percent Lime <sup>3,4</sup>	1/Day	Not applicable	Not applicable

<sup>1</sup> The minimum number of acceptance tests will be: 5 asphalt content, 3 gradation, 10 in-place density and 5 joint density for all projects.

<sup>2</sup> When unscheduled job mix formula changes are made (Form 43) acceptance of the elements, except for in-place density, will be based on the actual number of samples that have been selected up to that time, even if the number is below the minimum listed in the schedule. At the Engineer's discretion, additional random in-place density tests may be taken in order to meet scheduled minimums, provided the applicable pavement layer is available for testing under safe conditions. Beginning with the new job mix formula, the quantity it will represent shall be estimated. A revised schedule of acceptance tests will be based on that estimate.

<sup>3</sup> Not to be used for incentive or disincentive pay. Test according to CP 60B and report results from Form 106 or Form 565 on Form 6.

<sup>4</sup> Verified per Contractor's PC Plan

**SECTION 401**  
**PLANT MIX PAVEMENTS—GENERAL**

**Revise Section 401 of the Standard Specifications as follows:**

**Delete subsection 401.16 & 401.17 and replace with the following:**

**401.16 Spreading and Finishing.** Asphalt pavers shall be used to distribute the mixture to the established grade and required thickness over the entire width or partial width as practicable.

The longitudinal joint in both a new pavement and an overlay pavement layer shall offset the joint in the layer immediately below by 6 inches. In every pavement layer the longitudinal joints shall not be constructed in the wheel paths. The Contractor shall submit a longitudinal joint and pavement marking plan three days prior to the Pre-Paving Conference. The plan shall show the location and configuration of the proposed longitudinal joints and pavement markings, and shall detail the methods to be used to field establish a control line. The Contractor shall use a continuous string line to delineate every longitudinal joint during paving operations. All exposed string line shall be picked up and disposed of at the end of each day's paving. Paving shall not commence until the plan has been approved in writing by the Engineer. The joints in the top layer of pavement shall be located as follows unless otherwise approved in writing by the Engineer:

- (1) For 2-lane roadways, offset 6 to 12 inches from the center of pavement and from the outside edge of travel lanes.
- (2) For roadways of more than 2 lanes, offset 6 to 12 inches from lane lines and outside edge of travel lanes.

Longitudinal joints shall not cross the centerline, lane line, or edge line unless approved by the Engineer.

Where paving operations are on the present traveled roadway, the Contractor shall arrange paving operations so there will be no exposed longitudinal joints between adjacent travel lanes at the end of a day's run. With the approval of the Engineer, the Contractor may leave an exposed longitudinal joint conforming to the following:

- (1) When the thickness of the pavement course being placed is 1.5 inches or less a vertical exposed longitudinal joint may be constructed.
- (2) When the thickness of the pavement course being placed is greater than 1.5 inches the joint shall be constructed according to one of the following:
  - (i) The entire joint shall be tapered 3:1 or flatter. A Taper steeper than 3:1 shall be considered vertical.
  - (ii) The top portion of the longitudinal joint may be vertical. The vertical portion shall be a maximum of 1.5 vertical inches. The remainder of the joint, below the vertical portion, shall be tapered 3:1 or flatter.

On areas where the use of mechanical spreading and finishing equipment is impracticable, the mixture shall be dumped, spread, raked, screeded, and luted by hand tools to the required compacted thickness and grades.

Production of the mixture shall be maintained so pavers can be used in echelon to place the wearing course in adjacent lanes.

The asphalt mixture shall be transported and placed on the roadway without segregation. All segregated areas behind the paver shall be removed immediately upon discovery. The segregated material shall be replaced with specification material before the initial rolling has taken place. If more than 50 square feet of segregated pavement is ordered removed and replaced in any continuous 500 linear feet of paver width laydown, operations shall be discontinued until the source of the segregation has been found and corrected.

If at any time, the Engineer observes segregated areas of pavement, he will notify the Contractor immediately.

After rolling, segregated areas will be delineated by the Engineer and evaluated as follows:

- (1) The Engineer will delineate the segregated areas to be evaluated and inform the Contractor of the location and extent of these areas within two calendar days, excluding weekends and holidays, of placement.
- (2) In each segregated area or group of areas to be evaluated, the Contractor shall take five 10 inch cores at random locations designated by the Engineer. In accordance with CP 75, the Contractor shall also take five 10 inch cores at random locations designated by the Engineer in non-segregated pavement adjacent to the segregated area. These cores shall be within 30 feet of the boundary of the segregated area and in the newly placed pavement. The coring shall be in the presence of the Engineer and the Engineer will take immediate possession of the cores. The Contractor may take additional cores at the Contractor's expense.
- (3) Gradation of the aggregate of the cores will be determined by CDOT in accordance with CP 46.
- (4) The core aggregate gradations from the segregated area will be compared to the core aggregate gradations of the corresponding non-segregated area.
- (5) Two key sieves of the core gradations from the segregated area will be compared to the core gradations from the corresponding non-segregated area to determine the difference. If differences for both key sieves exceed the allowable difference specified in the table below, the area is segregated.

### SEGREGATION DETERMINATION

Mix Grading	Key Sieves	Allowable Difference, %
SX	2.36 mm (#8), 4.75 mm (#4)	9
S	2.36 mm (#8), 4.75 mm (#4)	9

- (6) Segregated areas in the top lift shall be removed and replaced, full lane width, at the Contractor's expense. The Engineer may approve a method equivalent to removal and replacement that results in a non-segregated top lift. Segregated areas, in lifts below the top lift that are smaller than 50 square feet per 100 linear feet of lane width shall be corrected by the Contractor at the Contractor's expense in a manner acceptable to the Engineer. Segregated areas larger than 50 square feet per 100 linear feet of lane width in any lift shall be removed and replaced, full lane width, by the Contractor at the Contractor's expense.

If the area is determined to be segregated, the coring shall be at the expense of the Contractor. If the area is determined to be non-segregated, the Engineer will reimburse the Contractor \$2,000 for obtaining the ten cores.

The Engineer will perform a systematic segregation check in accordance with CP 58 as early in the project as is feasible to determine if temperature segregation problems exist. Temperature segregation will be of concern on the project if, across the width of the mat, temperatures vary by 25 °F or more. Densities will not need to be taken in the systematic segregation check. The Engineer will discuss the temperature findings of the systematic segregation check with the Contractor.

The Engineer may evaluate the HMA for low density due to temperature segregation whenever industry best practices, as detailed on Form 1346, are not being followed or the Engineer suspects temperature segregation is occurring. The Engineer will first meet with the Contractor to discuss the paving practices that are triggering the temperature investigation. Areas across the mat, excluding the outside 1 foot of both edges of the mat, that are more than 25 °F cooler than other material across the width may be marked for density testing. Material for temperature comparison will be evaluated in 3-foot intervals behind the paver across the width of the mat. The material shall be marked and tested in accordance with CP 58. If four or more areas within a lot of 500 tons have densities of less than 93 percent of the material's maximum specific gravity for SMA mixes or less than 92 percent of the material's maximum specific gravity for all other HMA mixes, a 5 percent price disincentive will be applied to the 500 ton lot. The 500 ton count begins when the Engineer starts looking for cold areas, not when the first cold area is detected. This price disincentive will be in addition to those described in Sections 105 and 106. Only one area per delivered truck will be counted toward the number of low density areas. Temperature segregation checks will be performed

only in areas where continuous paving is possible.

**401.17 Compaction.** The hot mix asphalt shall be compacted by rolling. Both steel wheel and pneumatic tire rollers will be required. The number, weight, and type of rollers furnished shall be sufficient to obtain the required density while the mixture is in a workable condition. Compaction shall begin immediately after the mixture is placed and be continuous until the required density is obtained. When the mixture contains unmodified asphalt cement (PG 58 28 or PG 64 22) or modified (PG 58 34), and the surface temperature falls below 185 °F, further compaction effort shall not be applied unless approved, provided the Contractor can demonstrate that there is no damage to the finished mat. If the mixture contains modified asphalt cement (PG 76 28, PG 70-28 or PG 64 28) and the surface temperature falls below 230 °F, further compaction effort shall not be applied unless approved, provided the Contractor can demonstrate that there is no damage to the finished mat.

Warm Mix Asphalt compaction requirements shall conform to CP 59.

All roller marks shall be removed with the finish rolling. Use of vibratory rollers with the vibrator on will not be permitted during surface course final rolling and will not be permitted on any rolling on bridge decks covered with waterproofing membrane.

SMA shall be compacted to a density of 93 to 97-98 percent of the daily theoretical maximum specific gravity, determined according to CP 51. All other HMA shall be compacted to a density of 92 to 96-98 percent of the daily theoretical maximum specific gravity, determined according to CP 51. If more than one theoretical maximum specific gravity test is taken in a day, the average of the theoretical maximum specific gravity results will be used to determine the percent compaction. Field density determinations will be made in accordance with CP 44 or 81.

The longitudinal joints shall be compacted to a target density of 92-94 percent of the theoretical maximum specific gravity. The tolerance shall be  $\pm 4$  percent. The theoretical maximum specific gravity used to determine the joint density will be the average of the daily theoretical maximum specific gravities for the material that was placed on either side of the joint. Density (percent relative compaction) will be determined in accordance with CP 44.

The Contractor shall obtain one 6-inch diameter core at a random location within each longitudinal joint sampling section for determination of the joint density. The Contractor shall mark and drill the cores at the location directed by the Engineer and in the presence of the Engineer. The Engineer will take possession of the cores for testing. The Contractor may take additional cores at his own expense. Coring locations shall be centered on the visible line where the joint between the two adjacent lifts abuts the surface. The center of all joint cores shall be within 1 inch of this visible joint line. Core holes shall be repaired by the Contractor using materials and methods approved by the Engineer. PC and OA joint coring shall be completed within five calendar days of joint construction.

Longitudinal joint coring applies to all pavement layers. When constructing joints in an echelon paving process, the joints shall be clearly marked to ensure consistent coring location. In small areas, such as intersections, where the Engineer prescribes paving and phasing methods, the Engineer may temporarily waive the requirement for joint density testing

Incentive or disincentive payment determined for joint density in accordance with subsection 105.05 will apply to the HMA on each side of the joint. If a layer of pavement has joints constructed on both sides, incentive or disincentive payment for each of those joints will apply to one half of the pavement between the joints.

Along forms, curbs, headers, walls, and all other places not accessible to the rollers, the mixture shall be thoroughly compacted with mechanical tampers.

Any mixture that becomes loose and broken, mixed with dirt, or is in any way defective, shall be immediately removed and replaced with fresh hot mixture, and compacted to conform to the surrounding area.

The Contractor shall construct a compaction pavement test section (CTS) for each job mix for which 2000 or more tons are required for the project. The CTS will be used to evaluate the number of rollers and the most effective combination of rollers and rolling patterns for achieving the specified densities. Factors to be considered include, but are not limited to, the following:

- (1) Number, size, and type of rollers.
- (2) Amplitude, frequency, size and speed of vibratory rollers.
- (3) Size, speed, and tire pressure of rubber tire rollers.
- (4) Temperature of mixture being compacted.
- (5) Roller patterns.

The CTS shall be constructed according to the following procedures:

The CTS shall be constructed to provide the nominal layer thickness specified. The first 500 tons of hot mix asphalt on the project location shall constitute the CTS. The production and placement rates of the CTS shall closely approximate the anticipated production and placement rates for the remainder of the Contract.

Compaction of the CTS shall commence immediately after the hot mix asphalt has been spread, and shall be continuous and uniform over the entire CTS. For the CTS, compaction shall continue until no discernible increase in density is obtained by additional compactive efforts. All compaction shall be completed before the surface temperature of the mixture drops below 185 °F.

Approved types of rollers shall be used to achieve the specified density. The Contractor shall determine what methods and procedures are to be used for the compaction operation. The compaction methods and procedures shall be used uniformly over the entire last 200 tons. The Contractor shall record the following information and a copy of this data shall be furnished to the Engineer.

- (1) Type, size, amplitude, frequency, and speed of roller.
- (2) Tire pressure for rubber tire rollers, and whether the pass for vibratory rollers is vibratory or static.
- (3) Surface temperature of mixture behind the laydown machine and subsequent temperatures and densities after each roller pass.
- (4) Sequence and distance from laydown machine for each roller, and number of passes of each roller to obtain specified density.

Two sets of random cores shall be taken within the last 200 tons of the CTS. Each set shall consist of seven random cores. The Engineer will determine the coring locations using a stratified random sampling process. The locations of these cores will be such that one set can serve as a duplicate of the other. One set of these cores shall be immediately submitted to the Engineer. This set will be used for determining acceptance of the CTS and determining density correction factors for nuclear density equipment. Densities of the random samples will be determined by cores according to CP 44. Density correction factors for nuclear density equipment will be determined according to CP 81. Coring shall be performed under CDOT observation. Coring will not be measured and paid for separately but shall be included in the work. For SMA, a CTS is not used. The Contractor shall follow the requirements for the demonstration control strip in accordance with the Revision of Section 403, Stone Matrix Asphalt Pavement.

The CTS meets requirements if the Quality Level of the random samples is greater than or equal to 75. The Quality Level will be determined according to CP 71. Once constructed and accepted, the CTS shall remain in place and become part of the hot mix asphalt on the project.

When the Quality level is less than 75 the Contractor shall construct an additional test section, utilizing different rollers, or roller positions, or roller patterns as required. A written proposal detailing the changes in methods and

procedures that will be used to obtain density is to be submitted to the Engineer for review before constructing the additional test section.

If the Quality Level of a CTS is less than 75 and greater than or equal to 44, the Engineer may accept the material at a reduced price in accordance with Section 105.

If the Quality Level of a CTS is less than 44, the Engineer may:

- (1) Require complete removal and replacement with specification material at the Contractor's expense.
- (2) Where the finished product is found to be capable of performing the intended purpose and the value of the finished product is not affected, as determined by the Engineer, permit the Contractor to leave the material in place with a pay factor, but not more than 75 percent of the bid price.

Each CTS shall be 500 tons. If in-place densities of the CTS, as determined by nuclear density equipment prior to determining density of the cores, meet the CTS density requirements, the Contractor may begin production paving and continue to place hot mix asphalt pavement under the following conditions:

- (1) The period during which the Contractor continues to pave without test results from cores shall not exceed one work day.
- (2) Construction proceeds at the Contractor's risk. If correlation with the cores reveals that the densities do not meet the CTS requirements, the hot mix asphalt pavement placed subsequently will be subject to price reduction or removal and replacement.

After production paving work has begun, a new Roller Pattern shall be demonstrated when a change in the compaction process is implemented.

All additional costs associated with construction of the CTS shall be at the Contractor's expense. The hot mix asphalt placed in the CTS will be paid for in accordance with subsection 401.22, at the contract price for the hot mix asphalt.