

Special Specification 3081

Thin Overlay Mixtures



1. DESCRIPTION

Construct a thin surface course composed of a compacted mixture of aggregate and asphalt binder mixed hot in a mixing plant. Produce a thin overlay mixture (TOM) with a minimum lift thickness of 1/2 in. for a Type F mixture and 3/4 in. for a Type C mixture.

2. MATERIALS

Furnish uncontaminated materials of uniform quality that meet the requirements of the plans and specifications.

Notify the Engineer of all material sources and before changing any material source or formulation. The Engineer will verify that the specification requirements are met when the Contractor makes a source or formulation change, and may require a new laboratory mixture design, trial batch, or both. The Engineer may sample and test project materials at any time during the project to verify specification compliance in accordance with Item 6, "Control of Materials."

2.1. **Aggregate.** Furnish aggregates from sources that conform to the requirements in accordance with Table 1 and as specified in this Section. Aggregate requirements in this Section, including those shown in Table 1, may be modified or eliminated when shown on the plans. Additional aggregate requirements may be specified when shown on the plans. Provide aggregate stockpiles that meet the definitions in this Section for coarse, intermediate, or fine aggregate. Do not use reclaimed asphalt pavement (RAP) or recycled asphalt shingles (RAS). Supply aggregates that meet the definitions in accordance with [Tex-100-E](#) for crushed gravel or crushed stone. The Engineer will designate the plant or the quarry as the sampling location. Provide samples from materials produced for the project. The Engineer will establish the Surface Aggregate Classification (SAC) and perform Los Angeles abrasion, magnesium sulfate soundness, and Micro-Deval tests. Perform all other aggregate quality tests in accordance with Table 1. Document all test results on the mixture design report. The Engineer may perform tests on independent or split samples to verify Contractor test results. Stockpile aggregates for each source and type separately. Determine aggregate gradations for mixture design and production testing based on the washed sieve analysis in accordance with [Tex-200-F](#), Part II.

2.1.1. **Coarse Aggregate.** Coarse aggregate stockpiles must have no more than 20% material passing the No. 8 sieve. Aggregates from sources listed in the Department's *Bituminous Rated Source Quality Catalog* (BRSQC) are preapproved for use. Use only the rated values for hot-mix listed in the BRSQC. Rated values for surface treatment (ST) do not apply to coarse aggregate sources used in hot-mix asphalt.

For sources not listed on the Department's BRSQC:

- build an individual stockpile for each material;
- request the Department test the stockpile for specification compliance;
- approved only when tested by the Engineer;
- once approved, do not add material to the stockpile unless otherwise approved; and
- allow 30 calendar days for the Engineer to sample, test, and report results.

2.1.1.1. **Blending Class A and Class B Aggregates.** Class B aggregate meeting all other requirements in blending Class A and B aggregates to meet a Class A requirement, ensure that at least 50% by weight, or volume if required, of all aggregates used in the mixture design retained on the No. 8 sieve comes from the Class A

aggregate source, unless otherwise shown on the plans. Blend by volume if the bulk specific gravities of the Class A and B aggregates differ by more than 0.300. Class B aggregate may be disallowed when shown on the plans.

The Engineer may perform tests at any time during production, when the Contractor blends Class A and B aggregates to meet a Class A requirement, to ensure that at least 50% by weight, or volume if required, of the material retained on the No. 8 sieve comes from the Class A aggregate source. The Engineer will use the Department's mix design template, when electing to verify conformance, to calculate the percent of Class A aggregate retained on the No. 8 sieve by inputting the bin percentages shown from readouts in the control room at the time of production and stockpile gradations measured at the time of production. The Engineer may determine the gradations based on either washed or dry sieve analysis from samples obtained from individual aggregate cold feed bins or aggregate stockpiles. The Engineer may perform spot checks using the gradations supplied by the Contractor on the mixture design report as an input for the template; however, a failing spot check will require confirmation with a stockpile gradation determined by the Engineer.

- 2.1.1.2. **Micro-Deval Abrasion.** The Engineer will perform a minimum of one Micro-Deval abrasion test in accordance with [Tex-461-A](#) for each coarse aggregate source used in the mixture design that has a Rated Source Soundness Magnesium (RSSM) loss value greater than 15 as listed in the BRSQC, unless otherwise directed. The Engineer will perform testing before the start of production and may perform additional testing at any time during production. The Engineer may obtain the coarse aggregate samples from each coarse aggregate source or may require the Contractor to obtain the samples. The Engineer may waive all Micro-Deval testing based on a satisfactory test history of the same aggregate source.

The Engineer will estimate the magnesium sulfate soundness loss for each coarse aggregate source, when tested, using the following formula:

$$Mg_{est.} = (RSSM)(MD_{act.}/RSMD)$$

where:

Mg_{est} = magnesium sulfate soundness loss
 RSSM = Rated Source Soundness Magnesium
 MD_{act} = actual Micro-Deval percent loss
 RSMD = Rated Source Micro-Deval

When the estimated magnesium sulfate soundness loss is greater than the maximum magnesium sulfate soundness loss specified, the coarse aggregate source will not be allowed for use unless otherwise approved. The Engineer will consult the Soils and Aggregates Section of the Materials and Tests Division, and additional testing may be required before granting approval.

- 2.1.2. **Intermediate Aggregate.** Aggregates not meeting the definition of coarse or fine aggregate will be defined as intermediate aggregate. Supply intermediate aggregates, when used that are free from organic impurities. The Engineer may test the intermediate aggregate in accordance with [Tex-408-A](#) to verify the material is free from organic impurities. Supply intermediate aggregate from coarse aggregate sources, when used that meet the requirements in accordance with Table 1 unless otherwise approved.

If 10% or more of the stockpile is retained on the No. 4 sieve, verify that it meets the requirements in accordance with Table 1 for crushed face count ([Tex-460-A](#)) and flat and elongated particles ([Tex-280-F](#)).

- 2.1.3. **Fine Aggregate.** Fine aggregates consist of manufactured sands and screenings. Natural sands are not allowed in any mixture. Fine aggregate stockpiles must meet the fine aggregate properties in accordance with Table 1 and the gradation requirements in accordance with Table 2. Supply fine aggregates that are free from organic impurities. The Engineer may test the fine aggregate in accordance with [Tex-408-A](#) to verify the material is free from organic impurities. Use fine aggregate from coarse aggregate sources that meet the requirements in accordance with Table 1 unless otherwise approved.

If 10% or more of the stockpile is retained on the No. 4 sieve, verify that it meets the requirements in accordance with Table 1 for crushed face count ([Tex-460-A](#)) and flat and elongated particles ([Tex-280-F](#)).

Table 1
Aggregate Quality Requirements

Property	Test Method	Requirement
Coarse Aggregate		
SAC	Tex-499-A	A ¹
Deleterious material, %, Max	Tex-217-F , Part I	1.5
Decantation, %, Max	Tex-217-F , Part II	1.5
Micro-Deval abrasion, %	Tex-461-A	Note ^f
Los Angeles abrasion, %, Max	Tex-410-A	30
Magnesium sulfate soundness, 5 cycles, %, Max	Tex-411-A	20
Crushed face count, ³ %, Min	Tex-460-A , Part I	95
Flat and elongated particles @ 5:1, %, Max	Tex-280-F	10
Fine Aggregate		
Linear shrinkage, %, Max	Tex-107-E	3
Sand equivalent, %, Min	Tex-203-F	45

1. Surface Aggregate Classification of "A" is required unless otherwise shown on the plans.
2. Used to estimate the magnesium sulfate soundness loss in accordance with Section 3081.2.1.1.2., "Micro-Deval Abrasion."
3. Only applies to crushed gravel.

Table 2
Gradation Requirements for Fine Aggregate

Sieve Size	% Passing by Weight or Volume
3/8"	100
#8	70-100
#200	0-30

- 2.2. **Mineral Filler.** Mineral filler consists of finely divided mineral matter such as agricultural lime, crusher fines, or hydrated lime. Mineral filler is allowed unless otherwise shown on the plans. Fly ash is not permitted unless otherwise shown on the plans. Use no more than 2% hydrated lime unless otherwise shown on the plans. Test all mineral fillers except hydrated lime and fly ash in accordance with [Tex-107-E](#) to ensure specification compliance. The plans may require or disallow specific mineral fillers. Provide mineral filler, when used, that:
- is sufficiently dry, free-flowing, and free from clumps and foreign matter as determined by the Engineer;
 - does not exceed 3% linear shrinkage when tested in accordance with [Tex-107-E](#); and
 - meets the gradation requirements in Table 3, unless otherwise shown on the plans.

Table 3
Gradation Requirements for Mineral Filler

Sieve Size	% Passing by Weight or Volume
#8	100
#200	55-100

- 2.3. **Baghouse Fines.** Fines collected by the baghouse or other dust-collecting equipment may be reintroduced into the mixing drum.
- 2.4. **Asphalt Binder.** Furnish performance-graded (PG) asphalt binder with a high temperature grade of PG 76 unless otherwise shown in the plans and a low temperature grade as shown on the plans, in accordance with Section 300.2.10., "Performance-Graded Binders."
- 2.5. **Tack Coat.** Furnish CSS-1H, SS-1H, EBL, or a PG binder with a minimum high-temperature grade of PG 58 for tack coat binder in accordance with Item 300, "Asphalts, Oils, and Emulsions." Specialized tack coat materials listed on the Department's Tracking Resistant Asphalt Interlayer (TRAIL) MPL may be allowed or required when shown on the plans. Do not dilute emulsified asphalts at the terminal, in the field, or at any other location before use.

- 2.6. **Additives.** Provide the Engineer with documentation such as the bill of lading showing the quantity of additives used in the project unless otherwise directed.
- 2.6.1. **Lime and Liquid Antistripping Agent.** When lime or a liquid antistripping agent is used, add in accordance with Item 301, "Asphalt Antistripping Agents." Use no more than 1% hydrated lime when using crushed gravel. Do not add lime directly into the mixing drum of any plant where lime is removed through the exhaust stream unless the plant has a baghouse or dust collection system that reintroduces the lime into the drum.
- 2.6.2. **Compaction Aid.** Compaction Aid is defined as a department-approved chemical warm mix additive denoted as "chemical additive" on the Department's materials producer list (MPL) that is used to facilitate mixing and compaction of HMA.
- Compaction Aid is allowed for use on all projects. Compaction aid is required when shown on the plans or as required in Section 3081.4.7.1., "Weather Conditions."
- Warm mix foaming processes, denoted as "foaming process" on the Department-approved MPL, may be used to facilitate mixing and compaction of HMA; however warm mix foaming processes are not defined as a Compaction Aid.
- 2.7. **Recycled Materials.** Recycled materials are not allowed for use.

3. EQUIPMENT

Provide required or necessary equipment in accordance with Item 320, "Equipment for Asphalt Concrete Pavement."

4. CONSTRUCTION

Produce, haul, place, and compact the specified paving mixture. In addition to tests required by the specification, Contractors may perform other QC tests as deemed necessary. At any time during the project, the Engineer may perform production and placement tests as deemed necessary in accordance with Item 5, "Control of the Work." Schedule and participate in a mandatory pre-paving meeting with the Engineer on or before the first day of paving unless otherwise shown on the plans.

- 4.1. **Certification.** Personnel certified by the Department-approved hot-mix asphalt certification program must conduct all mixture designs, sampling, and testing in accordance with Table 4. Supply the Engineer with a list of certified personnel and copies of their current certificates before beginning production and when personnel changes are made. Provide a mixture design developed and signed by a Level 2 certified specialist. Provide Level 1A certified specialists at the plant during production operations. Provide Level 1B certified specialists to conduct placement tests. Provide AGG101 certified specialists for aggregate testing.

Table 4
Test Methods, Test Responsibility, and Minimum Certification Levels

Test Description	Test Method	Contractor	Engineer	Level ¹
1. Aggregate Testing				
Sampling	Tex-221-F	✓	✓	1A/AGG101
Dry sieve	Tex-200-F , Part I	✓	✓	1A/AGG101
Washed sieve	Tex-200-F , Part II	✓	✓	1A/AGG101
Deleterious material	Tex-217-F , Part I	✓	✓	AGG101
Decantation	Tex-217-F , Part II	✓	✓	AGG101
Los Angeles abrasion	Tex-410-A		✓	Department
Magnesium sulfate soundness	Tex-411-A		✓	Department
Micro-Deval abrasion	Tex-461-A		✓	AGG101
Crushed face count	Tex-460-A	✓	✓	AGG101
Flat and elongated particles	Tex-280-F	✓	✓	AGG101
Sand equivalent	Tex-203-F	✓	✓	AGG101
Organic impurities	Tex-408-A	✓	✓	AGG101
Methylene blue test	Tex-252-F		✓	Department
2. Asphalt Binder & Tack Coat Sampling				
Asphalt binder sampling	Tex-500-C , Part II	✓	✓	1A/1B
Tack coat sampling	Tex-500-C , Part III	✓	✓	1A/1B
3. Mix Design & Verification				
Design and JMF changes	Tex-204-F	✓	✓	2
Mixing	Tex-205-F	✓	✓	2
Molding (TGC)	Tex-206-F	✓	✓	1A
Molding (SGC)	Tex-241-F	✓	✓	1A
Laboratory-molded density	Tex-207-F , Parts I & VI	✓	✓	1A
Rice gravity	Tex-227-F , Part II	✓	✓	1A
Drain-down	Tex-235-F	✓	✓	1A
Ignition oven correction factors ²	Tex-236-F , Part II	✓	✓	2
Indirect tensile strength	Tex-226-F	✓	✓	1A
Overlay test	Tex-248-F		✓	Department
Hamburg Wheel test	Tex-242-F	✓	✓	1A
Boil test ⁴	Tex-530-C	✓	✓	1A
4. Production Testing				
Selecting production random numbers	Tex-225-F , Part I		✓	1A
Mixture sampling	Tex-222-F	✓	✓	1A/1B
Molding (TGC)	Tex-206-F	✓	✓	1A
Molding (SGC)	Tex-241-F	✓	✓	1A
Laboratory-molded density	Tex-207-F , Parts I & VI	✓	✓	1A
Rice gravity	Tex-227-F , Part II	✓	✓	1A
Gradation & asphalt binder content ²	Tex-236-F , Part I	✓	✓	1A
Drain-down	Tex-235-F	✓	✓	1A
Control charts	Tex-233-F	✓	✓	1A
Moisture content	Tex-212-F , Part II	✓	✓	1A/AGG101
Hamburg Wheel test	Tex-242-F	✓	✓	1A
Overlay test	Tex-248-F	✓	✓	Department
Micro-Deval abrasion	Tex-461-A		✓	AGG101
Boil test ⁴	Tex-530-C	✓	✓	1A
Abson recovery	Tex-211-F		✓	Department
5. Placement Testing				
Establish rolling pattern	Tex-207-F , Part IV	✓		1B
In-place density (nuclear method)	Tex-207-F , Part III	✓		1B
Control charts	Tex-233-F	✓	✓	1A
Ride quality measurement	Tex-1001-S	✓	✓	Note 3
Thermal profile	Tex-244-F	✓	✓	1B
Water flow test	Tex-246-F	✓	✓	1B

- Level 1A, 1B, AGG101, and 2 are certification levels provided by the Hot Mix Asphalt Center certification program.
- Refer to Section 3081.4.9.2.3., "Production Testing," for exceptions to using an ignition oven.
- Profiler and operator are required to be certified at the Texas A&M Transportation Institute facility when Surface Test Type B is specified.
- When shown on the plans.

4.2.

Reporting and Responsibilities. Use Department-provided templates to record and calculate all test data, including mixture design, production and placement QC/QA, control charts, and thermal profiles. Obtain the current version of the templates at <https://www.txdot.gov/inside-txdot/forms-publications/consultants-contractors/forms/site-manager.html> or from the Engineer. The Engineer and the Contractor will provide any available test results to the other party when requested. The maximum allowable time for the Contractor and Engineer to exchange test data is as given in Table 5 unless otherwise approved. The Engineer and the Contractor will immediately report to the other party any test result that requires suspension of production or placement or that fails to meet the specification requirements. Record and electronically submit all test results and pertinent information on Department-provided templates.

Subsequent sublots placed after test results are available to the Contractor, which require suspension of operations, may be considered unauthorized work. Unauthorized work will be accepted or rejected at the discretion of the Engineer in accordance with Section 5.3., "Conformity with Plans, Specifications, and Special Provisions."

Table 5
Reporting Schedule

Description	Reported By	Reported To	To Be Reported Within
Production Quality Control			
Gradation ¹	Contractor	Engineer	1 working day of completion of the subplot
Asphalt binder content ¹			
Laboratory-molded density ²			
Moisture content ³			
Boil test ⁵			
Production Quality Assurance			
Gradation ³	Engineer	Contractor	1 working day of completion of the subplot
Asphalt binder content ³			
Laboratory-molded density ¹			
Hamburg Wheel test ⁴			
Overlay test ⁴			
Boil test ⁵			
Binder tests ⁴			
Placement Quality Control			
Thermal profile ¹	Contractor	Engineer	1 working day of completion of the lot
Water flow ¹			
Placement Quality Assurance			
Thermal profile ³	Engineer	Contractor	1 working day of completion of the lot
Aging ratio ⁴			
Water flow			

1. These tests are required on every subplot.
2. Optional test. When performed on split samples, report the results as soon as they become available.
3. To be performed at the frequency specified and in accordance with Table 13 or as shown on the plans.
4. To be reported as soon as the results become available.
5. When shown on the plans.

Use the procedures described in [Tex-233-E](#) to plot the results of all quality control (QC) and quality assurance (QA) testing. Update the control charts as soon as test results for each subplot become available. Make the control charts readily accessible at the field laboratory. The Engineer may suspend production for failure to update control charts.

4.3.

Quality Control Plan (QCP). Develop and follow the QCP in detail. Obtain approval for changes to the QCP made during the project. The Engineer may suspend operations if the Contractor fails to comply with the QCP.

Submit a written QCP before the mandatory pre-paving meeting. Receive approval of the QCP before pre-paving meeting. Include the following items in the QCP:

- 4.3.1. **Project Personnel.** For project personnel, include:
- a list of individuals responsible for QC with authority to take corrective action;
 - current contact information for each individual listed; and
 - current copies of certification documents for individuals performing specified QC functions.
- 4.3.2. **Material Delivery and Storage.** For material delivery and storage, include:
- the sequence of material processing, delivery, and minimum quantities to assure continuous plant operations;
 - aggregate stockpiling procedures to avoid contamination and segregation;
 - frequency, type, and timing of aggregate stockpile testing to assure conformance of material requirements before mixture production; and
 - procedure for monitoring the quality and variability of asphalt binder.
- 4.3.3. **Production.** For production, include:
- loader operation procedures to avoid contamination in cold bins;
 - procedures for calibrating and controlling cold feeds;
 - procedures to eliminate debris or oversized material;
 - procedures for adding and verifying rates of each applicable mixture component (e.g., aggregate, asphalt binder, lime, liquid antistripping, compaction aid, foaming process);
 - procedures for reporting job control test results; and
 - procedures to avoid segregation and drain-down in the silo.
- 4.3.4. **Loading and Transporting.** For loading and transporting, include:
- type and application method for release agents; and
 - truck loading procedures to avoid segregation.
- 4.3.5. **Placement and Compaction.** For placement and compaction, include:
- proposed agenda for mandatory pre-paving meeting, including date and location;
 - proposed paving plan (e.g., production rate, paving widths, joint offsets, and lift thicknesses);
 - type and application method for release agents in the paver and on rollers, shovels, lutes, and other utensils;
 - procedures for the transfer of mixture into the paver, while avoiding physical and thermal segregation and preventing material spillage;
 - process to balance production, delivery, paving, and compaction to achieve continuous placement operations and good ride quality;
 - paver operations (e.g., speed, operation of wings, height of mixture in auger chamber) to avoid physical and thermal segregation and other surface irregularities; and
 - procedures to construct quality longitudinal and transverse joints.
- 4.4. **Mixture Design.**
- 4.4.1. **Design Requirements.** The Contractor may design the mixture using a Texas Gyrotory Compactor (TGC) or a Superpave Gyrotory Compactor (SGC) unless otherwise shown on the plans. Use the typical weight design example given in [Tex-204-F](#), Part I, when using a TGC. Use the Superpave mixture design procedure provided in [Tex-204-F](#), Part IV, when using a SGC. Design the mixture to meet the requirements in accordance with Tables 1, 2, 3, 6, and 7.
- 4.4.1.1. **Target Laboratory-Molded Density When the TGC Is Used.** Design the mixture at a 97.5% target laboratory-molded density or in accordance with Table 7.

4.4.1.2.

Design Number of Gyration (N_{design}) When the SGC Is Used. Design the mixture at 50 gyrations (N_{design}). Use a target laboratory-molded density of 96.0% to design the mixture; however, adjustments can be made to the N_{design} value as noted in Table 7. The N_{design} level may be reduced to no less than 35 gyrations at the Contractor's discretion.

Use an approved laboratory from the Department's MPL to perform the Hamburg Wheel test, and the Department will perform the Overlay test and provide results with the mixture design, or provide the laboratory mixture and request that the Department perform the Hamburg Wheel test and Overlay test. The Engineer will be allowed 10 working days to provide the Contractor with Hamburg Wheel test and Overlay test results on the laboratory mixture design.

The Engineer will provide the mixture design when shown on the plans. The Contractor may submit a new mixture design at any time during the project. The Engineer will verify and approve all mixture designs (JMF 1) before the Contractor can begin production.

Provide the Engineer with a mixture design report using the Department-provided template. Include the following items in the report:

- the combined aggregate gradation, source, specific gravity, and percent of each material used;
- the target laboratory-molded density (or N_{design} level when using the SGC);
- results of all applicable tests;
- the mixing and molding temperatures;
- the signature of the Level 2 person or persons that performed the design;
- the date the mixture design was performed; and
- a unique identification number for the mixture design.

Table 6
Master Gradation Limits (% Passing by Weight or Volume) and Volumetric Requirements

Sieve Size	Coarse (TOM-C)	Fine (TOM-F)
1/2"	100.0 ¹	100.0 ¹
3/8"	95.0–100.0	98.0–100.0
#4	40.0–60.0	70.0–95.0
#8	17.0–27.0	40.0–65.0
#16	5.0–27.0	20.0–45.0
#30	5.0–27.0	10.0–35.0
#50	5.0–27.0	10.0–20.0
#200	5.0–9.0	2.0–12.0
Asphalt Binder Content,² % Min		
-	6.0	6.5
Design VMA,³ % Min		
-	16.0	16.5
Production (Plant-Produced) VMA,³ % Min		
-	15.5	16.0

1. Defined as maximum sieve size. No tolerance allowed.
2. Unless otherwise shown on the plans or approved by the Engineer.
3. Voids in Mineral Aggregates (VMA).

Table 7
Mixture Design Properties

Mixture Property	Test Method	Requirement
Target laboratory-molded density, % (TGC)	Tex-207-F	97.5 ¹
Design gyrations (N _{design} for SGC)	Tex-241-F	50 ²
Hamburg Wheel test, passes at 12.5 mm rut depth for PG 76 mixtures	Tex-242-F	20,000 Min
Overlay test, Critical Fracture Energy, lb.-in/sq. in	Tex-248-F	1.5 Min
Overlay test, Crack Progression Rate	Tex-248-F	0.40 Max
Drain-down, %	Tex-235-F	0.20 Max

1. Unless otherwise shown on the plans or approved by the Engineer. Laboratory-molded density requirement using the TGC may be waived when approved by the Engineer.

2. May be adjusted within the range of 35–100 gyrations when shown on the plans or specification or when mutually agreed between the Engineer and Contractor. Laboratory-molded density requirement using the SGC may be waived when approved by the Engineer.

- 4.4.1 **Job-Mix Formula Approval.** The job-mix formula (JMF) is the combined aggregate gradation, target laboratory-molded density (or Ndesign level), and target asphalt percentage used to establish target values for hot-mix production. JMF1 is the original laboratory mixture design used to produce the trial batch. When a compaction aid or foaming process is used, JMF1 may be designed and submitted to the Engineer without including the compaction aid or foaming process. When a compaction aid or foaming process is used, document the compaction aid or foaming process used and recommended rate on the JMF1 submittal. The Engineer and the Contractor will verify JMF1 based on plant-produced mixture from the trial batch unless otherwise approved. The Engineer may accept an existing mixture design previously used on a Department project and may waive the trial batch to verify JMF1. The Department may require the Contractor to reimburse the Department for verification tests if more than two trial batches per design are required.
- 4.4.2.1. **Contractor's Responsibilities.**
- 4.4.2.1.1. **Providing Gyrotory Compactor.** Use a TGC calibrated in accordance with [Tex-914-K](#) when electing or required to design the mixture in accordance with [Tex-204-E](#), Part I, for molding production samples. Furnish an SGC calibrated in accordance with [Tex-241-F](#) when electing or required to design the mixture in accordance with [Tex-204-F](#), Part IV, for molding production samples. Locate the SGC if used, at the Engineer's field laboratory or make the SGC available to the Engineer for use in molding production samples.
- 4.4.2.1.2. **Gyrotory Compactor Correlation Factors.** Use [Tex-206-F](#), Part II, to perform a gyrotory compactor correlation when the Engineer uses a different gyrotory compactor. Apply the correlation factor to all subsequent production test results.
- 4.4.2.1.3. **Submitting JMF1.** Furnish a mix design report (JMF1) with representative samples of all component materials and request approval to produce the trial batch. Provide approximately 25 lb. of the design mixture if opting to have the Department perform the Hamburg Wheel test on the laboratory mixture, and request that the Department perform the test. Provide approximately 60 lb. of the design mixture to perform the Overlay test.
- 4.4.2.1.4. **Supplying Aggregates.** Provide approximately 40 lb. of each aggregate stockpile unless otherwise directed.
- 4.4.2.1.5. **Supplying Asphalt.** Provide at least 1 gal. of the asphalt material and enough quantities of any additives proposed for use.
- 4.4.2.1.6. **Ignition Oven Correction Factors.** Determine the aggregate and asphalt correction factors from the ignition oven in accordance with [Tex-236-F](#), Part II. Provide correction factors that are not more than 12 mo. old. Provide the Engineer with split samples of the mixtures before the trial batch production, including all additives (except water), and blank samples used to determine the correction factors for the ignition oven used for QA testing during production. Correction factors established from a previously approved mixture design may be used for the current mixture design if the mixture design and ignition oven are the same as previously used and the correction factors are not more than 12 mo. old, unless otherwise directed.
- 4.4.2.1.7. **Boil Test.** When shown on the plans, perform the test and retain the tested sample from [Tex-530-C](#) until completion of the project or as directed. Use this sample for comparison purposes during production.
- 4.4.2.1.8. **Trial Batch Production.** Provide a plant-produced trial batch upon receiving conditional approval of JMF1 and authorization to produce a trial batch, including the compaction aid or foaming process, if applicable, for verification testing of JMF1 and development of JMF2. Produce a trial batch mixture that meets the requirements in accordance with Table 8. The Engineer may accept test results from recent production of the same mixture instead of a new trial batch.

- 4.4.2.1.9. **Trial Batch Production Equipment.** Use only equipment and materials proposed for use on the project to produce the trial batch.
- 4.4.2.1.10. **Trial Batch Quantity.** Produce enough quantity of the trial batch to ensure that the mixture meets the specification requirements.
- 4.4.2.1.11. **Number of Trial Batches.** Produce trial batches as necessary to obtain a mixture that meets the specification requirements.
- 4.4.2.1.12. **Trial Batch Sampling.** Obtain a representative sample of the trial batch and split it into three equal portions in accordance with [Tex-222-F](#). Label these portions as “Contractor,” “Engineer,” and “Referee.” Deliver samples to the appropriate laboratory as directed.
- 4.4.2.1.13. **Trial Batch Testing.** Test the trial batch to ensure the mixture produced using the proposed JMF1 meets the mixture requirements in accordance with Table 8. Ensure the trial batch mixture is also in compliance with the requirements in accordance with Tables 6 and 7. Use a Department-approved laboratory listed on the MPL to perform the Hamburg Wheel test on the trial batch mixture or request that the Department perform the Hamburg Wheel test. Provide approximately 25 lb. of the trial batch mixture if opting to have the Department perform the Hamburg Wheel test, and request that the Department perform the test. Obtain and provide approximately 60 lb. of trial batch mixture in sealed containers, boxes, or bags labeled with the CSJ, mixture type, lot, and subplot number in accordance with [Tex-222-F](#) for the Overlay test. The Engineer will be allowed 10 working days to provide the Contractor with Hamburg Wheel test and Overlay test results on the trial batch. Provide the Engineer with a copy of the trial batch test results.
- 4.4.2.1.14. **Development of JMF2.** Evaluate the trial batch test results after the Engineer grants full approval of JMF 1 based on results from the trial batch, determine the optimum mixture proportions, and submit as JMF 2. Adjust the asphalt binder content or gradation to achieve the specified target laboratory-molded density. The mixture produced using JMF2 must meet the requirements in accordance with Tables 6 and 7. Verify that JMF2 meets the operation tolerances of JMF 1 in accordance with Table 8.
- 4.4.2.1.15. **Mixture Production.** Use JMF2 to produce Lot 1 after receiving approval for JMF2 and a passing result from the Department’s or a Department-approved laboratory’s Hamburg Wheel test and the Department’s Overlay test on the trial batch. If desired, proceed to Lot 1 production, once JMF2 is approved, at the Contractor’s risk without receiving the results from either the Department’s Hamburg Wheel test or Overlay test on the trial batch.
- Notify the Engineer if electing to proceed without Hamburg Wheel test and Overlay test results from the trial batch. Note that the Engineer may require up to the entire subplot of any mixture failing the Hamburg Wheel test or Overlay test to be removed and replaced at the Contractor’s expense.
- 4.4.2.1.16. **Development of JMF3.** Evaluate the test results from Lot 1, determine the optimum mixture proportions, and submit as JMF3 for use in Lot 2.
- 4.4.2.1.17. **JMF Adjustments.** If JMF adjustments are necessary to achieve the specified requirements, make the adjustments before beginning a new lot. The adjusted JMF must:
- be provided to the Engineer in writing before the start of a new lot;
 - be numbered in sequence to the previous JMF;
 - meet the master gradation limits in accordance with Table 6; and
 - be within the operational tolerances of JMF2 in accordance with Table 8.
- 4.4.2.1.18. **Requesting Referee Testing.** Use referee testing, if needed, in accordance with Section 3081.4.9.1., “Referee Testing,” to resolve testing differences with the Engineer.

Table 8
Operational Tolerances

Description	Test Method	Allowable Difference between JMF2 and JMF1 Target ¹	Allowable Difference from Current JMF and JMF2 ²	Allowable Difference between Contractor and Engineer ³
Individual % retained for #8 sieve and larger	Tex-200-F or Tex-236-F	Must be Within Master Grading Limits in accordance with Table 6	±3.0 ^{4,5}	±5.0
Individual % retained for sieves smaller than #8 and larger than #200			±3.0 ^{4,5}	±3.0
% passing the #200 sieve			±2.0 ^{4,5}	±1.6
Asphalt binder content, % ⁶	Tex-236-F	±0.3	±0.3 ⁵	±0.3
Laboratory-molded density, %	Tex-207-F	±1.0	±1.0	±1.0
Laboratory-molded bulk specific gravity		N/A	N/A	±0.020
VMA, % Min	Tex-204-F	Note 7	Note 7	N/A
Theoretical Max specific (Rice) gravity	Tex-227-F	N/A	N/A	±0.020
Drain-down, %	Tex-235-F	Note 8	Note 8	N/A

- JMF1 is the approved laboratory mixture design used for producing the trial batch. JMF2 is the approved mixture design developed from the trial batch used to produce Lot 1.
- Current JMF is JMF3 or higher. JMF3 is the approved mix design used to produce Lot 2.
- Contractor may request referee testing only when values exceed these tolerances.
- When within these tolerances, mixture production gradations may fall outside the master grading limits; however, the % passing the #200 will be considered out of tolerance when outside the master grading limits.
- Only applies to mixture produced for Lot 1 and higher.
- Binder content is not allowed to be outside the limits in accordance with Table 6. May be obtained from asphalt meter readouts as determined by the Engineer.
- Verify that Table 6 requirements are met.
- Verify that Table 7 requirements are met.

4.4.2.2. **Engineer's Responsibilities.**

4.4.2.2.1. **Gyrotory Compactor.** For mixtures designed in accordance with [Tex-204-F](#), Part I, the Engineer will use a Department TGC, calibrated in accordance with [Tex-914-K](#), to mold samples for trial batch and production testing.

For mixtures designed in accordance with [Tex-204-F](#), Part IV, the Engineer will use a Department SGC, calibrated in accordance with [Tex-241-F](#), to mold samples for laboratory mixture design verification. For molding trial batch and production specimens, the Engineer will use the Contractor-provided SGC at the field laboratory or provide and use a Department SGC at an alternate location.

4.4.2.2.2. **Conditional Approval of JMF1 and Authorizing Trial Batch.** The Engineer will review and verify conformance of the following information within two working days of receipt

- the Contractor's mix design report (JMF1);
- the Department-provided Overlay test results;
- the Contractor-provided Hamburg Wheel test results;
- all required materials including aggregates, asphalt, and additives; and
- the mixture specifications.

The Engineer will grant the Contractor conditional approval of JMF1 if the information provided on the paper copy of JMF1 indicates that the Contractor's mixture design meets the specifications. When the Contractor does not provide Hamburg Wheel test and department provided Overlay test results with laboratory mixture design, 10 working days are allowed for conditional approval of JMF1. The Engineer will base full approval of JMF1 on test results on mixture from the trial batch.

Unless waived, the Engineer will determine the Micro-Deval abrasion loss in accordance with

Section 3081.2.1.1., "Micro-Deval Abrasion." If the Engineer's test results are pending after two working days, conditional approval of JMF1 will still be granted within two working days of receiving JMF1. When the Engineer's test results become available, they will be used for specification compliance.

The Contractor is authorized to produce a trial batch after the Engineer grants conditional approval of JMF1.

4.4.2.2.3. **Hamburg Wheel and Overlay Testing of JMF1.** If the Contractor requests the option to have the Department perform the Hamburg Wheel test on the laboratory mixture, the Engineer will mold samples in accordance with [Tex-242-F](#) to verify compliance with the Hamburg Wheel test requirement in Table 7. The Engineer will perform the Overlay test and mold samples in accordance with [Tex-248-F](#) to verify compliance with the Overlay test requirements in Table 7. The Engineer will be allowed 10 working days to provide the Contractor with Hamburg Wheel and Overlay test results on the laboratory mixture design.

4.4.2.2.4. **Ignition Oven Correction Factors.** The Engineer will use the split samples provided by the Contractor to determine the aggregate and asphalt correction factors for the ignition oven used for QA testing during production in accordance with [Tex-236-F](#), Part II. Provide correction factors that are not more than 12 mo. old.

4.4.2.2.5. **Testing the Trial Batch.** Within one full working day, the Engineer will sample and test the trial batch to ensure that the mixture meets the requirements in accordance with Table 8. The Engineer will mold samples in accordance with [Tex-242-F](#) if the Contractor requests the option to have the Department perform the Hamburg Wheel test on the trial batch mixture to verify compliance with Hamburg Wheel test requirements in Table 7. The Engineer will mold samples for the Overlay test in accordance with [Tex-248-F](#) to verify compliance with the Overlay test requirement in Table 7.

The Engineer will have the option to perform [Tex-530-C](#) on the trial batch when shown on the plans. These results may be retained and used for comparison purposes during production.

4.4.2.2.6. **Full Approval of JMF1.** The Engineer will grant full approval of JMF1 and authorize the Contractor to proceed with developing JMF2 if the Engineer's results for the trial batch meet the requirements in accordance with Tables 6 and 7. The Engineer will notify the Contractor that an additional trial batch is required if the trial batch does not meet these requirements.

4.4.2.2.7. **Approval of JMF2.** The Engineer will approve JMF2 within one working day if the mixture meets the requirements in accordance with Table 6, 7, and 8.

4.4.2.2.8. **Approval of Lot 1 Production.** The Engineer will authorize the Contractor to proceed with Lot 1 production (using JMF2) as soon as a passing result is achieved from the Department's or a Department-approved laboratory's Hamburg Wheel test and the Department's Overlay test on the trial batch. The Contractor may proceed at its own risk with Lot 1 production without the results from the Hamburg Wheel test or Overlay test on the trial batch.

If the Department's or Department-approved laboratory's sample from the trial batch fails the Hamburg Wheel test or Overlay test, the Engineer will suspend production until further Hamburg Wheel tests or Overlay tests meet the specified values. The Engineer may require up to the entire subplot of any mixture failing the Hamburg Wheel test or Overlay test to be removed and replaced at the Contractor's expense.

4.4.2.2.9. **Approval of JMF3 and Subsequent JMF Changes.** JMF3 and subsequent JMF changes are approved if they meet the master grading limits and asphalt binder content shown in Table 6 and are within the operational tolerances of JMF2 shown in accordance with Table 8.

4.5. **Production Operations.** Perform a new trial batch when the plant or plant location is changed. Take corrective action and receive approval to proceed after any production suspension for noncompliance to the specification.

4.5.1. **Storage and Heating of Materials.** Do not heat the asphalt binder above the temperatures specified in Item 300, "Asphalts, Oils, and Emulsions," or outside the manufacturer's recommended values. Provide the Engineer with daily records of asphalt binder and hot-mix asphalt discharge temperatures (in legible and discernible increments) in accordance with Item 320, "Equipment for Asphalt Concrete Pavement," unless otherwise directed. Do not store mixture for a period long enough to affect the quality of the mixture, nor in any case longer than 12 hr. unless otherwise approved.

4.5.2. **Mixing and Discharge of Materials.** Notify the Engineer of the target discharge temperature and produce the mixture within 25°F of the target. Monitor the temperature of the material in the truck before shipping to ensure that it does not exceed the maximum production temperatures in accordance with Table 9. The Department will not pay for or allow placement of any mixture produced above the maximum production temperatures listed in Table 9.

**Table 9
Maximum Production Temperature**

High-Temperature Binder Grade ¹	Max Production Temperature
PG 76	345°F

1. The high-temperature binder grade refers to the high-temperature grade of the virgin asphalt binder used to produce the mixture.

Control the mixing time and temperature so that substantially all moisture is removed from the mixture before discharging from the plant. Determine the moisture content, if requested, by oven-drying in accordance with [Tex-212-F](#), Part II, and verify that the mixture contains no more than 0.2% of moisture by weight. Obtain the sample immediately after discharging the mixture into the truck and perform the test promptly.

4.6. **Hauling Operations.** Clean all truck beds before use to ensure that mixture is not contaminated. Use a release agent shown on the Department's MPL to coat the inside bed of the truck when necessary. Do not use diesel or any release agent not shown on the Department's MPL.

Use equipment for hauling as defined in Section 3081.4.7.3.3., "Hauling Equipment." Use other hauling equipment only when allowed.

4.7. **Placement Operations.** Collect haul tickets from each load of mixture delivered to the project and provide the Department's copy to the Engineer approximately every hour, or as directed. Use a hand-held thermal camera or infrared thermometer, when a thermal imaging system is not used, to measure and record the internal temperature of the mixture as discharged from the truck or Material Transfer Device (MTD) before or as the mix enters the paver and an approximate station number or GPS coordinates on each ticket. Calculate the daily yield and cumulative yield for the specified lift and provide to the Engineer at the end of paving operations for each day unless otherwise directed. The Engineer may suspend production if the Contractor fails to produce and provide haul tickets and yield calculations by the end of paving operations for each day.

Prepare the surface by removing raised pavement markers and objectionable material such as moisture, dirt, sand, leaves, and other loose impediments from the surface before placing mixture. Remove vegetation from pavement edges. Place the mixture to meet the typical section requirements and produce a smooth, finished surface with a uniform appearance and texture. Place mixture so that longitudinal joints on the surface course coincide within 6-in. of lane lines and are not placed in the wheel path, or as directed, and offset longitudinal joints of successive courses of hot-mix by at least 6-in. Ensure that all finished surfaces will drain properly. Place the mixture at the rate or thickness shown on the plans. The Engineer will use the guidelines in Table 10 to determine the compacted lift thickness. The thickness determined is based on the rate of 110–115 lb. per square inch. for each inch of pavement unless otherwise shown on the plans.

Table 10
Compacted Lift Thickness

Mixture Type	Compacted Lift Thickness ¹	
	Min (in.)	Max (in.)
TOM-C	0.75	1.25
TOM-F	0.5	1.00

1. Compacted target lift thickness will be specified on the plans.

4.7.1. **Weather Conditions.**

4.7.1.1. **When Using a Thermal Imaging System.** The Contractor may pave any time the roadway is dry and the roadway surface temperature is at least 60°F unless otherwise approved or as shown on the plans; however, the Engineer may restrict the Contractor from paving surface mixtures if the ambient temperature is likely to drop below 32°F within 12 hr. of paving. Place mixtures only when weather conditions and moisture conditions of the roadway surface are suitable as determined by the Engineer. Provide output data from the thermal imaging system to demonstrate to the Engineer that no recurring severe thermal segregation exists in accordance with Section 3081.4.7.3.1.2., "Thermal Imaging System."

Produce mixture with a target discharge temperature higher than 300°F and with a compaction aid to facilitate compaction when the air temperature is 70°F and falling

4.7.1.2. **When Not Using a Thermal Imaging System.** When using a thermal camera instead the thermal imaging system, place mixture when the roadway surface temperature is at or above 70°F unless otherwise approved or as shown on the plans. Measure the roadway surface temperature with a hand-held thermal camera or infrared thermometer. Place mixtures only when weather conditions and moisture conditions of the roadway surface are suitable as determined by the Engineer. The Engineer may restrict the Contractor from paving if the air temperature is 70°F and falling.

Produce mixture with a target discharge temperature higher than 300°F and with a compaction aid to facilitate compaction when the air temperature is 70°F and falling.

4.7.2. **Tack Coat.**

4.7.2.1. **Application.** Clean the surface before placing the tack coat. The Engineer will set the rate between 0.04 and 0.10 gal. of residual asphalt per square yard of surface area, unless otherwise specified on the plans. Apply a uniform tack coat at the specified rate unless otherwise directed. Apply the tack coat in a uniform manner to avoid streaks and other irregular patterns. Apply the tack coat to all surfaces that will come in contact with the subsequent HMA placement unless otherwise directed. Apply adequate overlap of the tack coat in the longitudinal direction during placement of the mat to ensure bond of adjacent mats, unless otherwise directed. Allow adequate time for emulsion to break completely before placing any material. Prevent splattering of tack coat when placed adjacent to curb, gutter, and structures. The Engineer may suspend paving operations until there is adequate coverage. Do not dilute emulsified asphalts at the terminal, in the field, or at any other location before use.

4.7.2.2. **Sampling.** The Engineer will obtain at least one sample of the tack coat binder per project in accordance with [Tex-500-C](#), Part III, and test it to verify compliance with Item 300, "Asphalts, Oils, and Emulsions." The Engineer will notify the Contractor when the sampling will occur and will witness the collection of the sample from the asphalt distributor immediately before use. Label the can with the corresponding lot and subplot numbers, producer, producer facility, grade, district, date sampled, and project information including highway and CSJ. For emulsions, the Engineer may test as often as necessary to ensure the residual of the emulsion is greater than or equal to the specification requirement in Item 300, "Asphalts, Oils, and Emulsions."

4.7.3. **Lay-Down Operations.** Use the placement temperatures in accordance with Table 11 to establish the minimum placement temperature of mixture delivered to the paving operation.

Table 11
Minimum Mixture Placement Temperature

High-Temperature Binder Grade ¹	Min Placement Temperature (Before Entering Paving Operation) ^{2,3}
PG 76	280°F

1. The high-temperature binder grade refers to the high-temperature grade of the virgin asphalt binder used to produce the mixture.
2. The mixture temperature must be measured using a hand-held thermal camera or infrared thermometer nearest to the point of entry of the paving operation.
3. Minimum placement temperatures may be reduced 10°F if using a compaction aid.

4.7.3.1. **Thermal Profile.** Use a hand-held thermal camera or a thermal imaging system to obtain a continuous thermal profile in accordance with [Tex-244-F](#).

4.7.3.1.1. **Thermal Segregation.**

4.7.3.1.1.1. **Moderate.** Any areas that have a temperature differential greater than 25°F, but not exceeding 50°F.

4.7.3.1.1.2. **Severe.** Any areas that have a temperature differential greater than 50°F.

4.7.3.1.2. **Thermal Imaging System.** Review the output results when a thermal imaging system is used, and provide the report described in accordance with [Tex-244-F](#) to the Engineer daily. Modify the paving process as necessary to eliminate any recurring (moderate or severe) thermal segregation identified by the thermal imaging system.

The Engineer may suspend subsequent paving operations if the Contractor cannot successfully modify the paving process to eliminate recurring severe or moderate thermal segregation.

Provide the Engineer with electronic copies of all daily data files that can be used with the thermal imaging system software to generate temperature profile plots daily or as requested by the Engineer.

4.7.3.1.3. **Thermal Camera.** When using a thermal camera instead of the thermal imaging system, take immediate corrective action to eliminate recurring moderate thermal segregation when a hand-held thermal camera is used. Evaluate areas with moderate thermal segregation by performing water flow testing in accordance with [Tex-246-F](#) and verify the water flow is greater than 120 sec. Provide the Engineer with the thermal profile of every subplot within one working day of the completion of each lot. When requested by the Engineer, provide the electronic files generated using the thermal camera. Report the results of each thermal profile in accordance with Section 3081.4.2., "Reporting and Responsibilities." The Engineer will use a hand-held thermal camera to obtain a thermal profile at least once per project, unless the thermal imaging system is used. Suspend operations and take immediate corrective action to eliminate severe thermal segregation unless otherwise directed. Resume operations when the Engineer determines that subsequent production will meet the requirements of this Section. Evaluate areas with severe thermal segregation by performing water flow testing in accordance with [Tex-246-F](#) and verify the water flow is greater than 120 sec. Remove and replace the material in any areas that have both severe thermal segregation and a failing result for water flow test unless otherwise directed.

4.7.3.2. **Windrow Operations.** Operate windrow pickup equipment so that when hot-mix is placed in windrows, substantially all the mixture deposited on the roadbed is picked up and loaded into the paver.

4.7.3.3. **Hauling Equipment.** Use belly dumps, live bottom, or end dump trucks to haul and transfer mixture. End dump trucks are only allowed when used in conjunction with an MTD with remixing capability unless otherwise allowed.

4.7.3.4. **Screed Heaters.** Turn off screed heaters to prevent overheating of the mat if the paver stops for more than 5 min. The Engineer may evaluate the suspect area in accordance with Section 3081.4.9.3.1.1., "Recovered Asphalt Dynamic Shear Rheometer (DSR)," if the screed heater remains on for more than 5 min. while the paver is stopped.

4.8.

Compaction. Roll the freshly placed mixture with as many steel-wheeled rollers as necessary to ensure adequate compaction without excessive breakage of the aggregate and to provide a smooth surface and uniform texture. Operate each roller in static mode for TOM-F mixtures only. Do not use pneumatic-tire rollers. Use the control strip method given in accordance with [Tex-207-F](#), Part IV, to establish the rolling pattern. Thoroughly moisten the roller drums with a soap and water solution to prevent adhesion. Use only water or an approved release agent on rollers, tamps, and other compaction equipment unless otherwise directed.

Use tamps to thoroughly compact the edges of the pavement along curbs, headers, and similar structures and in locations that will not allow thorough compaction with rollers. The Engineer may require rolling with a trench roller on widened areas, in trenches, and in other limited areas.

Use [Tex-246-F](#) to measure water flow to verify the mixture is adequately compacted. Measure the water flow once per subplot at locations directed by the Engineer. Take additional water flow measurements when the minimum temperature of the uncompacted mat is below the temperature requirements in accordance with Table 12.

Table 12
Minimum Uncompacted Mat Temperature Requiring Additional Water Flow Measurements

High-Temperature Binder Grade ¹	Min Temperature of the Uncompacted Mat Allowed Before Initial Break Down Rolling ^{2,3}
PG 76	<270°F

1. The high-temperature binder grade refers to the high-temperature grade of the virgin asphalt binder used to produce the mixture.
2. The surface of the uncompacted mat must be measured using a hand-held thermometer or infrared thermometer.
3. Minimum uncompacted mat temperature requiring a water flow measurement may be reduced 10°F if using a compaction aid.

Use [Tex-246-F](#) to measure water flow to verify the mixture is adequately compacted at confined longitudinal joints as directed by the Engineer.

The water flow rate should be greater than 120 sec. Investigate the cause of the water flow rate test failures and take corrective actions during production and placement to ensure the water flow rate is greater than 120 sec. Suspend production if two consecutive water flow rate tests fail unless otherwise approved. Resume production after the Engineer approves changes to production or placement methods.

Complete all compaction operations before the pavement temperature drops below 180°F unless otherwise allowed. The Engineer may allow compaction with a light finish roller operated in static mode for pavement temperatures below 180°F when approved.

Allow the compacted pavement to cool to 160°F or lower before opening to traffic unless otherwise directed. Sprinkle the finished mat with water or limewater, when directed, to expedite opening the roadway to traffic.

4.9.

Acceptance Plan. Sample and test the hot-mix asphalt on a lot and subplot basis.

4.9.1.

Referee Testing. The Materials and Tests Division is the referee laboratory. The Contractor may request referee testing if the differences between Contractor and Engineer test results exceed the maximum allowable difference in accordance with Table 8 and the differences cannot be resolved. The Contractor may also request referee testing if the Engineer's test results require suspension of production and the Contractor's test results are within specification limits. Make the request within five working days after receiving test results from the Engineer. Referee tests will be performed only on the subplot in question and only for the particular tests in question. Allow 10 working days from the time the referee laboratory receives the samples for test results to be reported. The Department may require the Contractor to reimburse the Department for referee tests if more than three referee tests per project are required and the Engineer's test results are closer to the referee test results than the Contractor's test results.

The Materials and Tests Division will determine the laboratory-molded density based on the molded specific gravity and the maximum theoretical specific gravity of the referee sample.

4.9.2. **Production Acceptance.**

4.9.2.1. **Production Lot.** A production lot consists of four equal sublots. The default quantity for Lot 1 is 500 ton; however, when requested by the Contractor, the Engineer may increase the quantity for Lot 1 to no more than 2,000 ton. The Engineer will select subsequent lot sizes based on the anticipated daily production such that approximately three to four sublots are produced each day. The lot size will be between 500 ton and 2,000 ton. The Engineer may change the lot size before the Contractor begins any lot.

4.9.2.1.1. **Incomplete Production Lots.** If a lot is begun but cannot be completed, such as on the last day of production or in other circumstances deemed appropriate, the Engineer may close the lot. Close all lots within five working days unless otherwise allowed.

4.9.2.2. **Production Sampling.**

4.9.2.2.1. **Mixture Sampling.** Obtain hot-mix samples from trucks at the plant in accordance with [Tex-222-F](#). The sampler will split each sample into three equal portions in accordance with [Tex-200-F](#) and label these portions as "Contractor," "Engineer," and "Referee." The Engineer will perform or witness the sample splitting and take immediate possession of the samples labeled "Engineer" and "Referee." The Engineer will maintain the custody of the samples labeled "Engineer" and "Referee" until the Department's testing is completed.

4.9.2.2.1.1. **Random Sample.** At the beginning of the project, the Engineer will select random numbers for all production sublots. Determine sample locations in accordance with [Tex-225-F](#). Take one sample for each subplot at the randomly selected location. The Engineer will perform or witness the sampling of production sublots.

4.9.2.2.1.2. **Blind Sample.** For one subplot per lot, the Engineer will obtain and test a "blind" sample instead of the random sample collected by the Contractor. Test either the "blind" or the random sample; however, referee testing (if applicable) will be based on a comparison of results from the "blind" sample. The location of the Engineer's "blind" sample will not be disclosed to the Contractor. The Engineer's "blind" sample may be randomly selected in accordance with [Tex-225-F](#) for any subplot or selected at the discretion of the Engineer. The Engineer will use the Contractor's split sample for sublots not sampled by the Engineer.

4.9.2.2.2. **Informational Methylene Blue Testing.** During the project and at random, obtain and provide the Engineer with approximately 50 lb. of each fine aggregate and approximately 20 lb. of all mineral fillers used to produce the mixture. Label the samples with the Control Section Job (CSJ), mixture type, and approximate lot and subplot number corresponding to when the sample was taken. The Engineer will ship the samples to the Materials and Tests Division for Methylene Blue testing in accordance with [Tex-252-F](#). Results from these tests will not be used for specification compliance.

4.9.2.2.3. **Asphalt Binder Sampling.** Obtain a 1-qt. sample of the asphalt binder witnessed by the Engineer for each lot of mixture produced. The Contractor will notify the Engineer when the sampling will occur. Obtain the sample at approximately the same time the mixture random sample is obtained. Sample from a port located immediately upstream from the mixing drum or pug mill and upstream from the introduction of any additives in accordance with [Tex-500-C](#), Part II. Label the can with the corresponding lot and subplot numbers, producer, producer facility location, grade, district, date sampled, and project information including highway and CSJ. The Engineer will retain these samples for one year. The Engineer may also obtain independent samples. If obtaining an independent asphalt binder sample and upon request of the Contractor, the Engineer will split a sample of the asphalt binder with the Contractor.

At least once per project, the Engineer will collect split samples of each binder grade and source used. The Engineer will submit one split sample to the Materials and Tests Division to verify compliance with Item 300, "Asphalts, Oils, and Emulsions," and will retain the other split sample for 1 yr.

4.9.2.3. **Production Testing.** The Contractor and Engineer must perform production tests in accordance with Table 13. The Contractor has the option to verify the Engineer's test results on split samples provided by the Engineer. Determine compliance with operational tolerances listed in accordance with Table 8 for all sublots. Take immediate corrective action if the Engineer's laboratory-molded density on any subplot is less than 95.0% or greater than 98.0% when using the SGC or less than 96.5% or greater than 98.5% when using the TGC, to bring

the mixture within these tolerances. The Engineer may suspend operations if the Contractor's corrective actions do not produce acceptable results. The Engineer will allow production to resume when the proposed corrective action is likely to yield acceptable results.

The Engineer may allow alternate methods for determining the asphalt binder content and aggregate gradation if the aggregate mineralogy is such that [Tex-236-F](#), Part I does not yield reliable results. Provide evidence that results from [Tex-236-F](#), Part I are not reliable before requesting permission to use an alternate method unless otherwise directed. Use the applicable test procedure as directed if an alternate test method is allowed.

Table 13
Production and Placement Testing Frequency

Description	Test Method	Min Contractor Testing	Min Engineer Testing
Individual % retained for #8 sieve and larger	Tex-200-F or Tex-236-F	1 per subplot	1 per 12 sublots ¹
Individual % retained for sieves smaller than #8 and larger than #200			
% passing the #200 sieve			
Laboratory-molded density	Tex-207-F	N/A	1 per subplot ¹
Laboratory-molded bulk specific gravity			
VMA			
Moisture content	Tex-212-F , Part II	When directed	
Theoretical maximum specific (Rice) gravity	Tex-227-F , Part II	N/A	1 per subplot ¹
Asphalt binder content ²	Tex-236-F , Part I	1 per subplot	1 per lot ¹
Overlay test ³	Tex-248-F	N/A	1 per project
Hamburg Wheel test	Tex-242-F	N/A	1 per project
Thermal profile	Tex-244-F	1 per subplot ^{4,5,6}	1 per project ⁵
Asphalt binder sampling and testing	Tex-500-C , Part II	1 per lot (sample only) ⁷	1 per project
Tack coat sampling and testing	Tex-500-C , Part III	N/A	1 per project
Boil test ⁸	Tex-530-C	1 per subplot ⁹	1 per project
Water flow	Tex-246-F		
Methylene blue test ¹⁰	Tex-252-F	1 per project (sample only)	1 per project

1. For production defined in Section 3081.4.9.4., "Exempt Production," the Engineer will test one per day if 100 ton or more are produced. For Exempt Production, no testing is required with less than 100 ton are produced.
2. May be obtained from asphalt flow meter readout as determined by the Engineer.
3. Testing performed by the Materials and Tests Division on sample obtained from Lot 2 or higher.
4. To be performed in the presence of the Engineer when a thermal camera is used, unless otherwise approved.
5. Not required when a thermal imaging system is used.
6. When using the thermal imaging system, the test report must include the temperature measurements taken in accordance with [Tex-244-F](#).
7. Obtain samples witnessed by the Engineer. The Engineer will retain these samples for 1 yr.
8. When shown on the plans.
9. To be performed in the presence of the Engineer, unless otherwise directed.
10. Testing performed by the Materials and Tests Division for informational purposes only.

4.9.2.4. **Operational Tolerances.** Control the production process within the operational tolerances in accordance with Table 8. When production is suspended, the Engineer will allow production to resume when test results or other information indicates the next mixture produced will be within the operational tolerances.

4.9.2.4.1. **Gradation.** Suspend operation and take corrective action if any aggregate is retained on the maximum sieve size in accordance with Table 6. A subplot is defined as out of tolerance if either the Engineer's or the Contractor's test results are out of operational tolerance. Suspend production when test results for gradation exceed the operational tolerances in accordance with Table 8 for three consecutive sublots on the same sieve or four consecutive sublots on any sieve unless otherwise directed. The consecutive sublots may be from more than one lot.

4.9.2.4.2. **Asphalt Binder Content.** A subplot is defined as out of operational tolerance if either the Engineer's or the Contractor's test results exceed the values in accordance with Table 8. Suspend production when two or

more sublots within a lot are out of operational tolerance or below the minimum asphalt binder content specified in accordance with Table 6 unless otherwise directed. Suspend production and shipment of mixture if the Engineer's or Contractor's asphalt binder content deviates from the current JMF by more than 0.5% for any subplot or is less than the minimum asphalt content allowed in accordance with Table 6.

- 4.9.2.4.3. **Voids in Mineral Aggregates (VMA).** The Engineer will determine the VMA for every subplot. For sublots when the Engineer does not determine asphalt binder content, the Engineer will use the asphalt binder content results from QC testing performed by the Contractor to determine VMA.

Take immediate corrective action if the VMA value for any subplot is less than the minimum VMA requirement for production in accordance with Table 6. Suspend production and shipment of the mixture if the Engineer's VMA results on two consecutive sublots are below the minimum VMA requirement for production in accordance with Table 6.

Suspend production and shipment of the mixture if the Engineer's VMA result is more than 0.5% below the minimum VMA requirement for production in accordance with Table 6. In addition to suspending production, the Engineer may require removal and replacement or may allow the subplot to be left in place without payment.

- 4.9.2.4.4. **Hamburg Wheel.** The Engineer may perform a Hamburg Wheel on plant produced mixture at any time during production. In addition to testing production samples, the Engineer may obtain cores and perform the Hamburg Wheel test on any area of the roadway where rutting is observed. Suspend production until further Hamburg Wheel meet the specified values when the production or core samples fail to meet the Hamburg Wheel criteria in accordance with Table 7. Core samples, if taken, will be obtained from the center of the finished mat or other areas excluding the vehicle wheel paths. The Engineer may require up to the entire subplot of any mixture failing the Hamburg Wheel to be removed and replaced at the Contractor's expense.

If the Department's or Department-approved laboratory's Hamburg Wheel test results in a "remove and replace" condition, the Contractor may request that the Department confirm the results by re-testing the failing material. The Materials and Tests Division will perform the Hamburg Wheel and determine the final disposition of the material in question based on the Department's test results.

- 4.9.2.5. **Individual Loads of Hot-Mix.** The Engineer can reject individual truckloads of hot-mix. When a load of hot-mix is rejected for reasons other than temperature, contamination, or excessive uncoated particles, the Contractor may request that the rejected load be tested. Make this request within 4 hr. of rejection. The Engineer will sample and test the mixture. If test results are within the operational tolerances in accordance with Table 8, payment will be made for the load. If test results are not within operational tolerances, no payment will be made for the load.

- 4.9.3. **Placement Acceptance.**

- 4.9.3.1. **Placement Lot.** A placement lot consists of four placement sublots. A placement subplot consists of the area placed during a production subplot.

- 4.9.3.1.1. **Recovered Asphalt Dynamic Shear Rheometer (DSR).** The Engineer may take production samples or cores from suspect areas of the project to determine recovered asphalt properties. Asphalt binders with an aging ratio greater than 3.5 do not meet the requirements for recovered asphalt properties and may be deemed defective when tested and evaluated by the Materials and Tests Division. The aging ratio is the DSR value of the extracted binder divided by the DSR value of the original unaged binder. Obtain DSR values in accordance with AASHTO T 315 at the specified high temperature performance grade of the asphalt. The Engineer may require removal and replacement of the defective material at the Contractor's expense. The asphalt binder will be recovered for testing from production samples or cores in accordance with [Tex-211-F](#).

- 4.9.3.1.2. **Irregularities.** Identify and correct irregularities including segregation, rutting, raveling, flushing, fat spots, mat slippage, irregular color, irregular texture, roller marks, tears, gouges, streaks, uncoated aggregate particles, or broken aggregate particles. The Engineer may also identify irregularities, and in such cases, the Engineer will promptly notify the Contractor. The Engineer may require the Contractor to remove and replace (at the

Contractor's expense) areas of the pavement that contain irregularities if the Engineer determines that the irregularity will adversely affect pavement performance. The Engineer may also require the Contractor to remove and replace (at the Contractor's expense) areas where the mixture does not bond to the existing pavement.

The Engineer may require the Contractor to immediately suspend operations if irregularities are detected or may allow the Contractor to continue operations for no more than one day while the Contractor is taking appropriate corrective action.

4.9.4. **Exempt Production.** When the anticipated daily production is less than 100 ton, all QC and QA sampling and testing are waived. The Engineer may deem the mixture as exempt production for the following conditions:

- anticipated daily production is more than 100 ton but less than 250 ton;
- total production for the project is less than 2,500 ton;
- when mutually agreed between the Engineer and the Contractor; or
- when shown on the plans.

For exempt production, the Contractor is relieved of all production and placement sampling and testing requirements. All other specification requirements apply, and the Engineer will perform acceptance tests for production and placement in accordance with Table 13.

For exempt production:

- produce, haul, place, and compact the mixture as directed by the Engineer; and
- control mixture production to yield a laboratory-molded density that is within $\pm 1.0\%$ of the target density as tested by the Engineer.

4.9.5. **Ride Quality.** Measure ride quality in accordance with Item 585, "Ride Quality for Pavement Surfaces," unless otherwise shown on the plans.

5. MEASUREMENT

5.1. **TOM Hot-Mix Asphalt.** TOM hot-mix will be measured by the ton of composite mixture, which includes asphalt, aggregate, and additives. Measure the weight on scales in accordance with Item 520, "Weighing and Measuring Equipment."

5.2. **Tack Coat.** Tack coat will be measured at the applied temperature by strapping the tank before and after road application and determining the net volume in gallons from the calibrated distributor. The Engineer will witness all strapping operations for volume determination. All tack, including emulsions, will be measured by the gallon applied.

The Engineer may allow the use of a metering device to determine asphalt volume used and application rate if the device is accurate within 1.5% of the strapped volume.

6. PAYMENT

The work performed and materials furnished in accordance with this Item and measured as provided under Section 3081.5.1., "TOM Hot-Mix Asphalt," will be paid for at the unit bid price for "Thin Overlay Mixture" of the mixture type, SAC, and binder specified. These prices are full compensation for surface preparation, removing pavement marking and markers, materials, placement, equipment, labor, tools, and incidentals.

The work performed and materials furnished in accordance with this Item and measured as provided under Section 3081.5.2., "Tack Coat," will be paid for at the unit bid price for "Tack Coat" of the tack coat provided. These prices are full compensation for materials, placement, equipment, labor, tools, and incidentals.

Trial batches will not be paid for unless they are included in pavement work approved by the Department.

Payment adjustment for ride quality will be determined in accordance with Item 585, "Ride Quality for Pavement Surfaces."