



**MARICOPA COUNTY**  
*Department of Transportation*

**MEMORANDUM**

**Date:** January 2, 2008

**To:** MAG Specifications and Details Committee

**From:** Robert Herz, MCDOT Representative

**Subject:** 325 Asphalt - Rubber Concrete Overlay, Gap Graded

**Case 08- 03**

**PURPOSE:** Incorporate specifications from MCDOT's Supplement into the MAG specifications as requested by the MAG Standards & Details Consolidation Subcommittee.

**REVISION:** Add to Part 300: Section 325 Asphalt-Rubber Concrete Overlay, Gap Graded.

## SECTION 325

### ASPHALT-RUBBER CONCRETE OVERLAY, GAP GRADED

#### 325.1 DESCRIPTION:

Asphalt-rubber concrete consists of supplying, placing and compaction of plant mixed gap graded asphalt-rubber concrete over asphalt surfaces. The thickness shall be as shown on the plans or as specified in the special provisions.

#### 325.2 MATERIALS:

Asphalt-rubber concrete shall consist of a mixture of aggregate and asphalt-rubber binder. Tack coat, asphalt-rubber concrete mix and transportation thereof shall be as specified in Sections 710 and 321, except as modified below:

##### 325.2.1 AGGREGATE:

The aggregate shall meet the following gradation:

<u>Overlay Thickness</u> <u>Sieve Size</u>	<u>1" &amp; 1-1/2"</u> <u>Percent Passing</u>	<u>2"</u> <u>Percent Passing</u>
25 mm (1")	100	100
19 mm (3/4")	100	97-100
12.5 mm (1/2")	100	78-92
9.5 mm (3/8")	78-92	61-75
4.745 mm (#4)	28-42	30-40
2.36 mm (#8)	15-25	15-25
600 µm (#30)	5-15	5-15
75 µm (#200)	3-7	2-6
*Type II portland cement Or	1.5%	
*Hydrated Lime	1.0%	

**\*By total weight of the mineral aggregate.**

The aggregate shall conform to the requirements of MAG 701 and 710 for asphalt concrete, except as modified below:

Sand Equivalent	65 minimum
Crushed Aggregate (retained on 2.36 mm (#8) sieve, at least one crushed face, produced by crushing)	85 minimum

### 325.2.2 ASPHALT-RUBBER BINDER:

The asphalt-rubber binder shall conform to Section 717.

### 325.2.3 MIX DESIGNS:

At the Pre-Construction Meeting, the Contractor shall submit the name of the asphalt-rubber concrete supplier, a description of the materials, and the job mix design(s). The design method used shall be in accordance with the Marshall Mix procedure, 75 blows, as described in "Design Methods for Hot-Mixed Asphalt-Rubber Concrete Paving Materials" by James G. Chehovits, October 1989. The job mix designs are subject to approval by the Engineer.

#### Asphalt Rubber Binder Content:

The percent of asphalt-rubber binder in the mix(es) shall be within the following range:

Overlay Thickness	Asphalt Rubber Binder	
	High Traffic	Low Traffic
1" and 1-1/2"	8.0% to 8.4%	8.4% to 8.8%
2"	7.1% to 7.4%	N/A

The amount of asphalt-rubber binder in each mix shall be provided in the design subject to approval by the Engineer. Low traffic areas include residential streets. High traffic areas include arterial streets.

#### Air Voids:

The percent of air voids in the mix(es) shall be within the following range:

Overlay Traffic Volume	Air Voids
Low Traffic	3.0% to 5.0%
High Traffic	4.0% to 6.0%

The amount of air voids in each mix shall be provided in the design subject to approval by the Engineer.

Mix designs shall include the following information as a minimum:

1. Aggregate
  - Source and identification (for each material used)
  - Gradation (for each material used)
  - Blend percentage
  - Mixture gradation

2. Asphalt - Rubber Binder (No extender oil allowed)
  - Source and PG grade of asphalt cement
  - Source and identification of ground rubber
  - Ground rubber gradation
  - Ground rubber percentage of the asphalt - rubber binder
  - Type and amount of additive(s), if required
  - Temperature when added to aggregate
3. Recommended asphalt - rubber binder content by both weight of total mix and by weight of dry aggregate.
4. Recommendations for maximum / minimum temperatures during material production and lay down; and the allowable ambient air and existing pavement surface temperatures during lay down.

The mix design shall include sufficient test results and documentation to assure that all requirements for rubber, aggregate and the asphalt-rubber binder are fulfilled.

#### **325.2.4 Production Tolerance:**

Production requirements for asphalt-rubber concrete shall be as specified in Section 710.4.4 Volumetrics, Section 710.5.1 Quality Control, and Section 321.6 Corrective Requirements for Deficiencies. The production tolerances including compaction requirements and corrective action will be enforced for asphalt-rubber concrete.

#### **Calibration Factors**

A minimum of one week prior to the production of asphalt rubber hot mix, the Contractor shall submit to the Engineer samples of all hot mix materials that will be used on the project. The materials shall be used to determine the calibration factors using the acceptance laboratory and the Contractor supplied ignition furnaces and related quality control test equipment. Calibration factors shall be recalculated whenever a change in the asphalt rubber hot mix materials occurs and when requested by the Engineer.

#### **325.3 SURFACE PREPARATION:**

Before placing asphalt-rubber concrete on existing pavements, severely raveled areas or cracked areas that are depressed more than 3/4" from the adjoining pavement shall be cut out and patched at least 48 hours prior to the resurfacing operation. Over-asphalted (bleeding or flushing) areas or rough high spots shall be removed by burning or blading. Large shrinkage cracks shall be filled with asphalt sealing compound acceptable to the Engineer. The entire surface shall be cleaned with a power broom. Raveled areas that do not require removing shall be cleaned by hand brooming. The above surface cleaning requirements are included as part of the Asphalt-Rubber Concrete paving operations, and the cost thereof shall be included in the Asphalt-

Rubber Concrete pay item. Pavement repairs and crack sealing when required are to be compensated for by other appropriate contract pay items.

Prior to placing the asphalt-rubber concrete on milled surfaces, pot-holes left by the milling operation shall be repaired by the Contractor, as a related non-pay item and as required by the Engineer. The milled area shall be swept.

After surfaces have been prepared to the satisfaction of the Engineer, they shall receive a tack coat as specified in Section 321.

Traffic will not be permitted over surfaces which have received a tack coat. When the overlay is to extend onto a concrete surface, the concrete surface shall be thoroughly cleaned of loose dust and cement particles and shall be tack coated.

#### **325.4 CONSTRUCTION METHODS:**

Asphalt-rubber concrete shall be placed only when the surface is dry, and when the atmospheric temperature in the shade is 55° F or above. No asphalt-rubber concrete shall be placed when the weather is foggy or rainy. Asphalt-rubber concrete shall be placed only when the Engineer determines that weather conditions are suitable.

Except as otherwise noted, placing and rolling of the asphalt-rubber concrete and the smoothness of the surface shall be as specified in Section 321 for asphalt concrete. The spreading equipment shall be equipped with a mat reference ski-type control device of not less than 30 feet in length, or other method of control approved by the Engineer.

The density of the compacted mixture shall not be less than 95% of the laboratory unit weight composed of the same mixture compacted by the 75 blow method of ASTM D-1559 at 290° F ± 5° F, or at the job mix design specified compaction temperature. Pneumatic rollers shall not be used.

Placement and compaction temperature shall be specified with the submitted mix design data but in no case less than 275° F at the point of placement. The temperature of the material in the truck shall be measured by inserting a thermometer, or other approved measuring device, to a point at least 6" below the surface of material.

If asphalt-rubber concrete is placed in a windrow during paving, the windrow shall not exceed a distance greater than 150 feet in front of the paving machine.

##### **325.4.1 Lime Water:**

An application of lime water shall be applied by the Contractor to the compacted asphalt rubber concrete surface after final compaction, prior to opening the roadway to traffic, or when requested by the Engineer to cool the pavement to prevent tracking and pick-up. The lime water solution shall be applied at the rate of approximately 1/2 gallon/square

yard. The lime shall be mixed using a minimum of (1) one, 50-pound bag per 3,000 gallons of water.

#### **325.4.2 Corrective Requirements for Deficiencies:**

Corrective measures shall be as specified in Section 321.6 Corrective Requirements for Deficiencies and in Section 710.4.4 Volumetrics.

#### **325.4.3 Adjustments:**

After installation of an overlay course:

All necessary frame and cover adjustments for manholes, valves, survey monuments, sewer clean-outs, etc., shall be completed by the Contractor within the given segments being surfaced.

On roads without curb and gutter, the existing shoulder elevation shall be adjusted by the Contractor to match the elevation at the edge of new overlay and slope away from new pavement surface at a rate that the existing quantity of shoulder material will allow. Shoulder material includes the existing shoulder, millings, untreated base materials, or a granular material approved by the Engineer. Shoulder material shall be compacted to a minimum of 95% of maximum density, determined in accordance with section 301.3.

#### **325.5 MEASUREMENT:**

Asphalt-Rubber Concrete shall be measured by the ton, for the mixture actually used, which shall include the required quantities of mineral aggregates, filler material, rubberized asphalt binder and anti-strip agent.

Application of Lime Water shall be measured by the square yard. The measured area shall be the area of asphalt-rubber pavement to which the lime water is applied. The measured area shall only be counted one time regardless of the number of applications applied to the asphalt-rubber pavement section.

#### **325.6 PAYMENT:**

Payment for Asphalt Milling will be as specified in Section 317.

Payment for Tack Coat will be as specified in Section 321.

Payment for Asphalt - Rubber Concrete will be at the contract unit price, complete in place.

Application of Lime Water as approved by the Engineer will be paid at the contract unit price.