



# Illinois Department of Transportation

2300 South Dirksen Parkway / Springfield, Illinois / 62764

June 6, 2011

SUBJECT: FAI Route 55/70 (I-55/70)  
Project IM-000S (854)  
Section 60-10W, 60-10RS-1  
Madison County  
Contract No. 76E94  
Item No. 111, June 17, 2011 Letting  
Addendum A

## NOTICE TO PROSPECTIVE BIDDERS:

Attached is an addendum to the plans or proposal. This addendum involves revised and/or added material.

1. Revised page ii of the Table of Contents to the Special Provisions.
2. Revised pages 73 - 81 of the Special Provisions.

Prime contractors must utilize the enclosed material when preparing their bid and must include any Schedule of Prices changes in their bidding proposal.

Bidders using computer-generated bids are cautioned to reflect any and all Schedule of Prices changes, if involved, into their computer programs.

Very truly yours,

Scott E. Stitt, P.E.  
Acting Engineer of Design and Environment

A handwritten signature in cursive script, reading "Ted B. Walschleger P.E.".

By: Ted B. Walschleger, P. E.  
Engineer of Project Management

cc: Mary C. Lamie, Region 5, District 8; Mike Renner; Estimates

TBW:DB:jc

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The fine aggregate proportion shall be a maximum 50 percent by weight (mass) of the total aggregate used.

- (e) The slump flow range shall be  $\pm 2$  in. ( $\pm 50$  mm) of the Contractor target value, and within the overall Department range of 20 in. (510 mm) minimum to 28 in. (710 mm) maximum.
- (f) The visual stability index shall be a maximum of 1.
- (g) The J-ring value shall be a maximum of 4 in. (100 mm). The Contractor may specify a lower maximum in the mix design.
- (h) The L-box blocking ratio shall be a minimum of 60 percent. The Contractor may specify a higher minimum in the mix design.
- (i) The hardened visual stability index shall be a maximum of 1.

Mixing Portland Cement Concrete. In addition to Article 1020.11 of the Standard Specifications, the mixing time for central-mixed concrete shall not be reduced as a result of a mixer performance test. Truck-mixed or shrink-mixed concrete shall be mixed in a truck mixer for a minimum of 100 revolutions.

Wash water, if used, shall be completely discharged from the drum or container before the succeeding batch is introduced.

The batch sequence, mixing speed, and mixing time shall be appropriate to prevent cement balls and mix foaming for central-mixed, truck-mixed, and shrink-mixed concrete.

Placing and Consolidating. The maximum distance of horizontal flow from the point of deposit shall be 25 ft (7.6 m), unless approved otherwise by the Engineer.

Concrete shall be rodded with a piece of lumber, conduit, or vibrator if the material has lost its fluidity prior to placement of additional concrete. The vibrator shall be the pencil head type with a maximum diameter or width of 1 in. (25 mm). Any other method for restoring the fluidity of the concrete shall be approved by the Engineer.

Mix Design Approval. The Contractor shall obtain mix design approval according to the Department's Policy Memorandum "Quality Control/Quality Assurance Program for Precast Concrete Products".

## **STONE MATRIX ASPHALT (D-8)**

Effective: June 1, 2010

Description. This work shall consist of constructing polymer modified 1/2 in. (12.5 mm) stone matrix asphalt (SMA) surface course and binder course. Work shall be according to Sections 406, 407 and 1030 of the Standard Specifications, except as modified herein.

Materials.

Revised 06/06/2011

Add the following to the end of the first paragraph of Article 1003.03(a) of the Standard Specifications:

“Fine aggregate for SMA shall consist of stone sand, slag sand, or steel slag sand.”

Add the following to the end of the first paragraph of Article 1003.03(c) of the Standard Specifications.

“The fine aggregate gradation for SMA shall be FA/FM 20.”

Add the following to the end of Article 1004.03(a) of the Standard Specifications:

- “(1) For SMA surface course, the coarse aggregate shall be crushed aggregate meeting the friction requirement specified.
- “(2) For SMA binder course, the coarse aggregate shall be crushed aggregate. Steel slag will not be permitted in the binder course.”

Revise Article 1004.03(b) of the Standard Specifications to read:

“(b) Quality. For surface courses and binder courses when used as surface course, the coarse aggregate shall be Class B quality or better. For SMA surface and binder courses the coarse aggregate, excluding limestone, shall be Class B Quality or better. If limestone is to be blended, it shall be Class A quality. For Class A (seal or cover coat), other binder courses, and surface course IL-9.5L (Low ESAL), the coarse aggregate shall be Class C quality or better. For All Other courses, the coarse aggregate shall be Class D quality or better.”

Revise Article 1004.03(c) of the Standard Specifications to read:

“(c) Gradation. The coarse aggregate gradations shall be as listed in the following table.

Use	Size / Application	Gradation No.
Class A-1, 2, & 3	3/8 in. (10 mm) Seal	CA 16
Class A-1	1/2 in. (13 mm) Seal	CA 15
Class A-2 & 3	Cover	CA 14
HMA High ESAL	IL-25.0 IL-19.0 IL-12.5 IL-9.5	CA 7 <sup>1/</sup> or CA 8 <sup>1/</sup> CA 11 <sup>1/</sup> CA 16 and/or CA 13 CA 16
HMA Low ESAL	IL-19.0L IL-9.5L	CA 11 <sup>1/</sup> CA 16
HMA All Other	Stabilized Subbase or Shoulders	CA 6 <sup>2/</sup> , CA 10, or CA 12
SMA	1/2 in. (12.5 mm) Binder & Surface	3/

- 1/ CA 16 or CA 13 may be blended with the gradations listed.
- 2/ CA 6 will not be permitted in the top lift of shoulders.
- 3/ No individual coarse aggregate gradation is specified.

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The coarse aggregates used shall be capable of being combined with stone sand, slag sand, or steel slag sand meeting the FA/FM 20 gradation and mineral filler to meet the approved mix design and the mix requirements noted herein.”

Add the following to Article 1004.03 of the Standard Specifications:

- “(d) Flat and Elongated Particles. For SMA the coarse aggregate shall meet the criteria for Flat and Elongated Particles listed in Illinois Modified AASHTO M 325.
- (e) Absorption. For SMA the coarse aggregate shall also have water absorption  $\leq 2.5$  percent.”

Add the following to Article 1011.01 of the Standard Specifications:

- “(c) Additional requirements for SMA. Mineral filler for use in SMA shall be free from organic impurities and have a Plasticity Index  $\leq 4$ .”

Revise Article 1030.02(c) of the Standard Specifications to read:

- “(c) RAP Material (Note 4).....1031”

Revise Article 1030.02(g) of the Standard Specifications to read:

- “(g) Performance Graded Asphalt Binder (Notes 2 & 5).....1032”

Add the following to Article 1030.02 of the Standard Specifications:

- “(h) Fibers (Note 6)”

Add the following notes to Article 1030.02 of the Standard Specifications:

- Note 4. RAP will not be permitted in SMA.
- Note 5. The asphalt cement shall be an SBS PG 76-22 .
- Note 6. A stabilizing additive such as cellulose or mineral fiber shall be added to the SMA mixture according to Illinois Modified AASHTO M 325. The stabilizing additive shall meet the Fiber Quality Requirements listed in Illinois Modified AASHTO M 325. Prior to approval and use of fibers, the Contractor shall submit a notarized certification by the producer of these materials stating they meet these requirements.”

Mix Design.

Add the following below the referenced AASHTO standards in Article 1030.04 of the Standard Specifications:

- “ The SMA mixture shall be designed according to the following additional Illinois Modified AASHTO references listed below, except as modified herein.

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AASHTO M 325 Standard Specification for Designing Stone Matrix Asphalt (SMA)

AASHTO R 46 Standard Practice for Designing Stone Matrix Asphalt (SMA)

AASHTO T 305 Determination of Draindown Characteristics in Uncompacted Mixtures”

Revise Article 1030.04(a)(1) of the Standard Specifications to read:

“ (1) High ESAL Mixtures. The Job Mix Formula (JMF) shall fall within the following limits.”

"High ESAL, MIXTURE COMPOSITION (% PASSING) <sup>1/</sup>										
Sieve Size	IL - 25.0 mm		IL - 19.0 mm		IL - 12.5 mm		IL - 9.50 mm		SMA	
	min	max	min	max	min	max	min	max	min	max
1 1/2 in (37.5mm)		100								
1 in (25mm)	90	100		100						
3/4 in (19.0mm)		90	82	100		100				100
1/2 in (12.5mm)	45	75	50	85	90	100		100	85	99
3/8 in (9.5mm)						89	90	100	50	85
#4 (4.75mm)	24	42 <sup>2/</sup>	24	50 <sup>2/</sup>	28	65	28	65	20	40
#8 (2.36mm)	16	31	20	36	28	48 <sup>3/</sup>	28	48 <sup>3/</sup>	16	24 <sup>5/</sup>
#16 (1.18mm)	10	22	10	25	10	32	10	32		
#50 (300µm)	4	12	4	12	4	15	4	15		
#100 (150µm)	3	9	3	9	3	10	3	10		
#200 (75µm)	3.0	6.0	3.0	6.0	4.0	6.0	4.0	6.0	8.0	11.0 <sup>6/</sup>
Ratio Dust/Asph alt Binder		1.0		1.0		1.0		1.0		

1/ Based on percent of total aggregate weight.

2/ The mixture composition shall not exceed 40 percent passing the #4 (4.75 mm) sieve for binder courses with Ndesign ≥ 90.

3/ The mixture composition shall not exceed 40 percent passing the #8 (2.36 mm) sieve for surface courses with Ndesign ≥ 90.

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- 4/ The maximum percent passing the 20 µm sieve shall be ≤3 percent.
- 5/ When establishing the Adjusted Job Mix Formula (AJMF) the #8 (2.36 mm) sieve shall not be adjusted above 24 percent.
- 6/ Additional minus No. 200 (0.075 mm) material required by the mix design shall be mineral filler.”

Add the following to Article 1030.04(b) of the Standard Specifications:

“(4) SMA Mixtures. The mix design shall meet the SMA Mixture Specifications for SGC listed in AASHTO M 325 except as listed below:

ESAL's (million)	Ndesign	Design Air Voids Target %	Voids in the Mineral Aggregate (VMA), % min.
> 10	80 <sup>1/2</sup>	4.0	17.0

- 1/ Coarse aggregate shall be crushed gravel, diabase, granite, quartzite, sandstone, or steel slag.”
- 2/ A maximum of 25% coarse aggregate limestone may be blended by volume. Limestone shall be Class A quality as per Article 1004.01(b) of the Standard Specifications for Road and Bridge Construction.

Plant Requirements.

Add the following to Article 1102.01(a) of the Standard Specifications:

“(13) Requirements for SMA.

- a. Mineral Filler. When producing SMA, the mineral filler system shall accurately proportion the large amounts of mineral filler required for the mixture. Alteration or adjustment of the current system may be required. Mineral filler shall not be stored in the same silo as collected dust.

Only dust collected during the production of SMA may be returned to the SMA mixture. Any additional minus No. 200 (0.075 mm) material needed to produce the SMA shall be mineral filler meeting the requirements stated herein. Mineral filler shall not be collected dust.

- b. Stabilizing Additive. Adequate dry storage shall be provided for the stabilizing fiber additive. A separate feed system shall be provided to proportion the fiber into the mixture uniformly and in desired quantities.

The feed system shall be interlocked with the aggregate feed or weigh system to maintain the correct proportions for all rates of production and batch sizes. The proportion of fibers shall be controlled at all times within ± ten percent of the amount of fibers required. The fiber system shall provide in-process monitoring consisting of either a digital display of output or a printout of the feedrate, in pounds per minute.

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Flow indicators or sensing devices for the fiber system shall be provided and interlocked with plant controls so mix production shall be interrupted if fiber introduction fails, or if the output rate is not within the specified tolerances.

1. Batch Plant. Stabilizing additive shall be pneumatically added through a separate inlet directly into the weigh hopper above the pugmill. The addition of fiber shall be timed to occur during the hot aggregate charging of the hopper. Adequate mixing time will be required to ensure proper blending of the aggregate and fiber additive. Both the wet and dry mixing times shall each be increased a minimum of five seconds beyond the standard mixing time. The actual mixing time increase shall be determined by the Engineer based on individual plant characteristics. If concentrations of mastic (fiber, AC and fines) are visible behind the paver the batch size shall be reduced in ten percent increments until the problem is alleviated.
  2. Drum Mix Plant. Stabilizing additive shall be introduced using specialized equipment to mix the asphalt cement with loose fiber at the time of introduction into the drum mixer. This equipment shall be approved by the Engineer. Care shall be taken to ensure the loose fiber does not become entrained in the exhaust system of the plant. A manufacturer's representative for the fiber and fiber equipment shall be present for the fiber system calibration and mixture startup and shall be available at all times during production and lay-down of the mix.
- c. Hot-mix Storage. SMA mixtures containing steel slag coarse aggregate shall have a combined silo storage time plus haul time not less than 1 1/2 hours.
- d. Production Rate. The Bureau of Materials and Physical Research will establish the maximum production rate for SMA based items such as the plant's ability to (1) add mineral filler consistently within 0.3 percent of the target by total weight of mix and (2) thoroughly disperse the stabilizing additive."

QC/QA.

Add the following to the table in Article 1030.05(d)(2)(a) of the Standard Specifications:

Parameter	Frequency of Tests SMA Mixture	Test Method
Draindown	1 per day of production	AASHTO T 305

Revise Article 1030.05(d)(4) of the Standard Specifications to read:

- " (4) Control Limits. Target values shall be determined by applying adjustment factors to the AJMF where applicable.

The target values shall be plotted on the control charts within the following control limits.

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CONTROL LIMITS					
Parameter	High ESAL Low ESAL		SMA		All Other
	Individual Test	Moving Avg. of 4	Individual Test	Moving Avg. of 4	Individual Test
% Passing: <sup>1/</sup>					
1/2 in. (12.5 mm)	± 6 %	± 4 %	± 6 %	± 4 %	± 15 %
3/8 in. (9.5 mm)			± 4%	± 3%	
No. 4 (4.75 mm)	± 5 %	± 4 %	± 5 %	± 4 %	± 10 %
No. 8 (2.36 mm)	± 5 %	± 3 %	± 3%	± 2%	
No. 30 (600 µm)	± 4 %	± 2.5 %	± 4 %	± 2.5 %	
Total Dust Content No. 200 (75 µm)	± 1.5 %	± 1.0 %			± 2.5 %
Asphalt Binder Content	± 0.3 %	± 0.2 %	± 0.2%	± 0.1%	± 0.5 %
Voids	± 1.2 %	± 1.0 %	± 1.2%	± 1.0%	± 1.2 %
Draindown			Max 0.3 %		

1/ Based on washed ignition oven

DENSITY CONTROL LIMITS		
Mixture Composition	Parameter	Individual Test
IL-9.5, IL-12.5	Ndesign ≥ 90	92.0 – 96.0 %
IL-9.5,IL-9.5L, IL-12.5	Ndesign < 90	92.5 – 97.4 %
IL-19.0, IL-25.0	Ndesign ≥ 90	93.0 – 96.0 %
IL-19.0, IL-19.0L, IL-25.0	Ndesign < 90	93.0 – 97.4 %
SMA	Ndesign = 80	94.0 – 97.0 %
All Other	Ndesign = 30	93.0 <sup>1/</sup> - 97.4 %

1/ 92.0 percent when placed as first lift on an unimproved subgrade.”

Replace the first and second paragraphs of Article 1030.06(a) of the Standard Specifications with the following:

“ (a) High ESAL, Low ESAL and SMA Mixture.

During the mixture start-up for High or Low ESAL mixture the Contractor shall follow the QC/QA document “Hot-Mix Asphalt QC/QA Start-Up Procedures”. At the start of High or Low ESAL mixture production, QC/QA mixture start-up will be required for the following situations: at the beginning of production of a new mixture design, at the beginning of each production season, and at every plant utilized to produce mixtures, regardless of the mix.

Revise the table in Article 1030.06(a) of the Standard Specifications to read:

Parameter	Adjustment
1/2 in. (12.5 mm)	± 5.0 %
No. 4 (4.75 mm)	± 4.0 %
No. 8 (2.36 mm)	± 3.0 %
No. 30 (600 µm)	1/
No. 200 (75 µm)	1/
Asphalt Binder Content	± 0.3 % <sup>2/</sup>

1/ In no case shall the target for the amount passing be greater than the JMF.

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2/ For SMA, the asphalt binder content shall not be adjusted by more than 0.2 percent.”

Transportation.

Add the following after the first paragraph of Article 1030.08 of the Standard Specifications:

“ (d) The mixture being placed is SMA.”

Construction Requirements.

Add the following paragraph after the first paragraph of Article 406.06(b) of the Standard Specifications:

“Additional temperature requirements for SMA. SMA mixture shall be placed on a dry surface when the temperature of the roadbed is above 50 °F (10 °C). The mixture shall be placed at a minimum mixture temperature of 300 °F (149 °C) when using SBS PG76-22. The mixture temperature shall be measured immediately behind the paver screed.”

Revise the last sentence of the third paragraph of Article 406.06(e) of the Standard Specifications to read:

“In no case shall the speed of the paver exceed 50 ft (15 m) per minutes for High and Low ESAL mixes or 30 ft (9 m) per minute for SMA.”

Revise Table 1 in Article 406.07(a) of the Standard Specifications to read:

"TABLE 1 - MINIMUM ROLLER REQUIREMENTS FOR HMA				
	Breakdown Roller (one of the following)	Intermediate Roller	Final Roller (one or more of the following)	Density Requirement
Level Binder: (When the density requirements of Article 406.05(c) do not apply.)	P <sup>3/</sup>	--	VS, P <sup>3/</sup> , TB, TF, 3W	To the satisfaction of the Engineer.
Binder and Surface <sup>1/</sup>  Level Binder <sup>1/</sup> : (When the density requirements of Article 406.05(c) apply.)	VD, P <sup>3/</sup> , TB, 3W	P <sup>3/</sup>	VS, TB, TF	As specified in Articles: 1030.05(d)(3), (d)(4), and (d)(7).
SMA <sup>4/</sup>	TB <sup>5/</sup>	--	TF	
Bridge Decks <sup>2/</sup>	TB	--	TF	As specified in Articles: 582.05 and 582.06.

- 1/ If the average delivery at the job site is 85 ton/hr (75 metric ton/hr) or less, any roller combination may be used provided it includes a steel wheeled roller and the required density and smoothness is obtained.
- 2/ One T<sub>B</sub> may be used for both breakdown and final rolling on bridge decks 300 ft (90 m) or less in length, except when the air temperature is less than 60 °F (15 °C).
- 3/ A vibratory roller (V<sub>D</sub>) may be used in lieu of the pneumatic-tired roller on mixtures containing polymer modified asphalt binder.

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- 4/ Pneumatic-tired and vibratory rollers will not be allowed. Rollers shall be operated at a uniform speed not to exceed 3 mph (5 km/h) with the drive roll nearest the paver.
- 5/ The Contractor shall provide a minimum of two steel-wheeled tandem rollers for breakdown (T<sub>B</sub>). The breakdown rollers shall maintain an effective rolling distance of not more than 150 ft (45 m) behind the paver.”

Prepaving Conference. A prepaving conference shall be held a minimum of one week prior to the start of mix production. Those in attendance shall include the QC Manager, Construction Supervising Field Engineer, Resident Engineer, Mixture Control Engineer, BMPR representative, fiber supplier representative, asphalt binder supplier representative, as well as plant, paver and roller operators.

Basis of Payment. This work will be measured and paid for according to Article 406.13 and 406.14 of the Standard Specifications at the contract unit price per metric ton (ton) for POLYMERIZED HOT-MIX ASPHALT SURFACE COURSE, STONE MATRIX ASPHALT, of the N design specified; and POLYMERIZED HOT-MIX ASPHALT BINDER COURSE, STONE MATRIX ASPHALT, of the N design specified.

#### **SUBCONTRACTOR MOBILIZATION PAYMENTS (BDE)**

Effective: April 2, 2005

Revised: April 1, 2011

To account for the preparatory work and operations necessary for the movement of subcontractor personnel, equipment, supplies, and incidentals to the project site and for all other work or operations that must be performed or costs incurred when beginning work approved for subcontracting according to Article 108.01 of the Standard Specifications, the Contractor shall make a mobilization payment to each subcontractor.

This mobilization payment shall be made at least 14 days prior to the subcontractor starting work. The amount paid shall be equal to 3 percent of the amount of the subcontract reported on form BC 260A submitted for the approval of the subcontractor’s work.

The mobilization payment to the subcontractor is an advance payment of the reported amount of the subcontract and is not a payment in addition to the amount of the subcontract; therefore, the amount of the advance payment will be deducted from future progress payments.

This provision shall be incorporated directly or by reference into each subcontract approved by the Department.

#### **SURFACE TESTING OF PAVEMENTS (BDE)**

Effective: April 1, 2002

Revised: January 1, 2007

#### **Hot-Mix Asphalt (HMA) Overlays**

Revised 06/06/2011