



Illinois Department of Transportation

2300 South Dirksen Parkway / Springfield, Illinois / 62764

January 11, 2013

SUBJECT: FAP Route 305 (US 14)
Project HD-0305(050)
Section 29R-RS-4
McHenry County
Contract No. 60N28
Item No. 108, January 18, 2013 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 the Table of Contents to the Special Provisions
2. Revised pages 12-23 and 51-54 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,

John D. Baranzelli, 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: John Fortmann, Region 1, District 1; Dave Lippert; Mike Renner;
Estimates

MS/ks

TABLE OF CONTENTS

| | |
|--|----|
| LOCATION OF PROJECT | 1 |
| DESCRIPTION OF PROJECT | 1 |
| MAINTENANCE OF ROADWAYS | 2 |
| STATUS OF UTILITIES TO BE ADJUSTED..... | 2 |
| PUBLIC CONVENIENCE AND SAFETY (DIST 1) | 2 |
| GRADING AND SHAPING SHOULDERS..... | 3 |
| MILLED SURFACE RESTRICTION..... | 3 |
| HOT MIX ASPHALT - MIXTURE DESIGN VERIFICATION AND PRODUCTION (BMPR)..... | 3 |
| HOT MIX ASPHALT - PAY FOR PERFORMANCE USING PERCENT WITHIN LIMITS - PLANT SAMPLING (BMPR)..... | 5 |
| FINE AGGREGATE FOR HOT- MIX ASPHALT (HMA) (D-1) | 10 |
| HOT MIX ASPHALT MIXTURES, EGA MODIFIED PERFORMANCE GRADED (PG) ASPHALT BINDER..... | 11 |
| HOT MIX ASPHALT MIXTURE IL-4.75 (DIST 1) | 12 |
| RECLAIMED ASPHALT PAVEMENT AND RECLAIMED ASPHALT SHINGLES (D-1) | 14 |
| TRAFFIC CONTROL PLAN | 24 |
| TRAFFIC SIGNAL SPECIFICATIONS FOR DETECTOR REPLACEMENT AND/OR INSTALLATION ON ROADWAY GRINDING, RESURFACING, & PATCHING OPERATIONS | 24 |
| TEMPORARY INFORMATION SIGNING | 28 |
| CENTER LINE RUMBLE STRIP | 29 |
| 45 MIL HOT SPRAY THERMOPLASTIC PAVEMENT MARKING..... | 30 |
| AUTOMATED FLAGGER ASSISTANCE DEVICES (BDE)..... | 38 |
| AIR QUALITY – DIESEL RETROFIT (BDE)..... | 40 |
| DISADVANTAGED BUSINESS ENTERPRISE PARTICIPATION (BDE) | 42 |
| FRICTION SURFACE AGGREGATE (D1)..... | 51 |
| HOT-MIX ASPHALT - DENSITY TESTING OF LONGITUDINAL JOINTS (BDE)..... | 54 |
| PAVEMENT MARKING REMOVAL (BDE)..... | 55 |
| PAVEMENT PATCHING (BDE) | 55 |
| PAYMENTS TO SUBCONTRACTORS (BDE)..... | 56 |
| PLACING AND CONSOLIDATING CONCRETE (BDE)..... | 57 |
| PORTLAND CEMENT CONCRETE (BDE)..... | 60 |

| | |
|---|-----|
| QUALITY CONTROL/QUALITY ASSURANCE OF CONCRETE MIXTURES (BDE)..... | 100 |
| REMOVAL AND DISPOSAL OF REGULATED SUBSTANCES (BDE) | 114 |
| REMOVAL AND DISPOSAL OF SURPLUS MATERIALS (BDE) | 118 |
| SUBCONTRACTOR MOBILIZATION PAYMENTS (BDE) | 119 |
| TRACKING THE USE OF PESTICIDES (BDE) | 119 |
| TRAFFIC CONTROL DEFICIENCY DEDUCTION (BDE) | 119 |
| UTILITY COORDINATION AND CONFLICTS (BDE) | 120 |
| WARM MIX ASPHALT (BDE) | 125 |
| WEEKLY DBE TRUCKING REPORTS (BDE) | 131 |
| WORKING DAYS (BDE) | 131 |
| BITUMINOUS MATERIALS COST ADJUSTMENTS (BDE) (RETURN FORM WITH BID)..... | 131 |
| FUEL COST ADJUSTMENT (BDE) (RETURN FORM WITH BID) | 134 |

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HOT MIX ASPHALT MIXTURE IL-4.75 (DIST 1)

Effective: January 1, 2007

Revised: January 1, 2013

Description. This work shall consist of constructing Hot-Mix Asphalt (HMA) surface course or leveling binder with an IL-4.75 mixture. Work shall be according to Sections 406, 1030, 1031 and 1032 of the Standard Specifications except as modified herein.

Materials.

Revise Article 1030.02 of the Standard Specifications to read:

(b) Fine aggregate (Note 1 and 3)

Note 3. The gradation for IL-4.75 shall be FA 1, FA 2, FA 20 or FA 22.

(c) Reclaimed or recycled material. Only processed FRAP or RAS will be permitted in the 4.75 mm mix. Refer to D1 version for Use of Recycle Materials specification(s).

(d) Mineral Filler. Mineral filler shall conform to the requirements of Article 1011.01 of the Standard Specifications. Collected HMA baghouse dust may be used as Mineral Filler provided it meets the gradation outlined in Article 1011 of the Standard Specifications and a separate mix design is created.

(g) Asphalt Binder (AB). The AB shall be either Elvaloy or SBS/SBR with a PG 76-22 value. The AB shall meet the requirements of Article 1032.05(b) of the Standard Specifications; however the elastic recovery of the AB shall be 80 minimum.

The AB shall be shipped, maintained, and stored at the mix plant according to the manufacturer's requirements. It shall be placed in an empty tank and not blended with other asphalt cements.

Mixture Design. Add the following to Article 1030.04(b) of the Standard Specifications

“(4) IL 4.75 Mixture.

| Volumetric Parameter | Requirement |
|--------------------------------------|--------------------|
| Design Air Voids | 3.5% at Ndesign 50 |
| Voids in the Mineral Aggregate (VMA) | 18.5% minimum |
| Voids Filled with Asphalt (VFA) | 72 - 85% |
| Dust/AC Ratio | 1.0 |
| Density (% of Max Specific Gravity) | 93.0 - 97.4 |
| Maximum Drain-down | 0.3% |

The percentage of new natural sand shall not exceed 25% if FRAP or RAS is used. For designs without FRAP or RAS the sand fraction of the final blend shall be at least 50% manufacture stone sand.

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Mixture Production. Plant modifications may be required to accommodate the addition of higher percentages of mineral filler as required by the JMF.

During production, mineral filler shall not be stored in the same silo as collected dust. This may require any previously collected bag house dust in a storage silo prior to production of the IL-4.75 mixture to be wasted. Only metered bag house dust may be returned back directly to the mix. Any additional minus No. 200 (75 µm) material needed to produce the IL-4.75 shall be mineral filler.

As an option, collected bag-house dust may be used in lieu of manufactured mineral filler, provided; 1) there is enough is available for the production of the IL-4.75 mix for the entire project and 2) a mix design was prepared with collected bag-house dust.

The mixture shall be produced within the temperature range recommended by the asphalt cement producer; but not less than 325 °F (165 °C).

The amount of moisture remaining in the finished mixture (at silo discharge) shall be less than 0.3 percent based on the weight of the test sample after drying.

Mixtures contain steel slag sand or aggregate having absorptions ≥ 2.5 percent shall have a silo storage plus haul time of not less than 1.5 hours.

Placement

Revise Article 406.06 (b) (2) a. to read as follows:

The surface shall be dry for at least 12 hours, and clean, prior to placement of the mixture.

As an option, the contractor will be allowed to use a heated drier, at no additional cost to the Department, to expedite the drying of the pavement. No mix will be placed in areas of standing water or areas that show evidence of moisture or dampness. The use of a heated drier will be stopped if the pavement shows signs of damaged.

Control Charts/Limits.

Add the following to Control Limits table in Article 1030.04(d)(4) of the Standard Specifications:

| Parameter | Individual Test | Moving Average |
|------------------------|--------------------|--------------------|
| % Passing | | |
| No. 16 (1.18 mm) | ± 4% | ± 3% |
| No. 200 (75 µm) | ± 1.5% | ± 1.0% |
| Asphalt Binder Content | ± 0.3% | ± 0.2% |
| Air Voids | ± 1.2% (of design) | ± 1.0% (of design) |
| No. 200 (75 µm) | ± 1.5% | ± 1.0% |

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RECLAIMED ASPHALT PAVEMENT AND RECLAIMED ASPHALT SHINGLES (D-1)

Effective: November 1, 2012

Revise: January 1, 2013

Revise Section 1031 of the Standard Specifications to read:

“SECTION 1031. RECLAIMED ASPHALT PAVEMENT AND RECLAIMED ASPHALT SHINGLES

1031.01 Description. Reclaimed asphalt pavement and reclaimed asphalt shingles shall be according to the following.

- (a) Reclaimed Asphalt Pavement (RAP). RAP is the material resulting by cold milling or crushing an existing hot-mix asphalt (HMA) pavement. RAP will be considered processed FRAP after completion of both crushing and screening to size. The Contractor shall supply written documentation that the RAP originated from routes or airfields under federal, state, or local agency jurisdiction.
- (b) Reclaimed Asphalt Shingles (RAS). Reclaimed asphalt shingles (RAS). RAS is from the processing and grinding of preconsumer or post-consumer shingles. RAS shall be a clean and uniform material with a maximum of 0.5 percent unacceptable material, as defined in Bureau of Materials and Physical Research Policy Memorandum “Reclaimed Asphalt Shingle (RAS) Sources”, by weight of RAS. All RAS used shall come from a Bureau of Materials and Physical Research approved processing facility where it shall be ground and processed to 100 percent passing the 3/8 in. (9.5 mm) sieve and 90 percent passing the #4 (4.75 mm) sieve . RAS shall meet the testing requirements specified herein. In addition, RAS shall meet the following Type 1 or Type 2 requirements.
 - (1) Type 1. Type 1 RAS shall be processed, preconsumer asphalt shingles salvaged from the manufacture of residential asphalt roofing shingles.
 - (2) Type 2. Type 2 RAS shall be processed post-consumer shingles only, salvaged from residential, or four unit or less dwellings not subject to the National Emission Standards for Hazardous Air Pollutants (NESHAP).

1031.02 Stockpiles. RAP and RAS stockpiles shall be according to the following.

- (a) RAP Stockpiles. The Contractor shall construct individual, sealed RAP stockpiles meeting one of the following definitions. No additional RAP shall be added to the pile after the pile has been sealed. Stockpiles shall be sufficiently separated to prevent intermingling at the base. All stockpiles (including unprocessed RAP and Processed FRAP) shall be identified by signs indicating the type as listed below (i.e. “Non- Quality, FRAP -#4 or Type 2 RAS”, etc...).

Revised 1/11/2013

- (1) Fractionated RAP (FRAP). FRAP shall consist of RAP from Class I, Superpave HMA (High and Low ESAL) or equivalent mixtures. The coarse aggregate in FRAP shall be crushed aggregate and may represent more than one aggregate type and/or quality but shall be at least C quality. All FRAP shall be processed prior to testing sized into fractions with the separation occurring on or between the #4 (4.75 mm) and 1/2 in. (12.5 mm) sieves. Agglomerations shall be minimized such that 100 percent of the RAP in the coarse fraction shall pass the maximum sieve size specified for the mix the RAP will be used in.
- (2) Restricted FRAP (B quality) stockpiles shall consist of RAP from Class I, Superpave (High ESAL), or HMA (High ESAL). If approved by the Engineer, the aggregate from a maximum 3.0 inch single combined pass of surface/binder milling will be classified as B quality. All millings from this application will be processed into FRAP as described previously.
- (3) Conglomerate. Conglomerate RAP stockpiles shall consist of RAP from Class I, Superpave HMA (High and Low ESAL) or equivalent mixtures. The coarse aggregate in this RAP shall be crushed aggregate and may represent more than one aggregate type and/or quality but shall be at least C quality. This RAP may have an inconsistent gradation and/or asphalt binder content prior to processing. All conglomerate RAP shall be processed (FRAP) prior to testing. Conglomerate RAP stockpiles shall not contain steel slag or other expansive material as determined by the Department.
- (4) Conglomerate "D" Quality (DQ). Conglomerate DQ RAP stockpiles shall consist of RAP from from HMA shoulders, bituminous stabilized subbases or Superpave (Low ESAL)/HMA (Low ESAL) IL-19.0L binder mixture. The coarse aggregate in this RAP may be crushed or round but shall be at least D quality. This RAP may have an inconsistent gradation and/or asphalt binder content. Conglomerate DQ RAP stockpiles shall not contain steel slag or other expansive material as determined by the Department.
- (5) Non-Quality. RAP stockpiles that do not meet the requirements of the stockpile categories listed above shall be classified as "Non-Quality".

RAP/FRAP containing contaminants, such as earth, brick, sand, concrete, sheet asphalt, bituminous surface treatment (i.e. chip seal), pavement fabric, joint sealants, plant cleanout etc., will be unacceptable unless the contaminants are removed to the satisfaction of the Engineer. Sheet asphalt shall be stockpiled separately.

- (b) RAS Stockpiles. The Contractor shall construct individual, sealed RAS stockpiles meeting one of the following definitions. No additional RAS shall be added to the pile after the pile has been sealed. Type 1 and Type 2 RAS shall be stockpiled separately and shall be sufficiently separated to prevent intermingling at the base. Each stockpile shall be signed indicating what type of RAS is present.

However, a RAS source may submit a written request to the Department for approval to blend mechanically a specified ratio of type 1 RAS with type 2 RAS. The source will not be permitted to change the ratio of the blend without the Department prior written approval. The Engineer's written approval will be required, to mechanically blend RAS with any fine aggregate produced under the AGCS, up to an equal weight of RAS, to improve workability. The fine aggregate shall be "B Quality" or better from an approved Aggregate Gradation Control System source. The fine aggregate shall be one that is approved for use in the HMA mixture and accounted for in the mix design and during HMA production.

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Records identifying the shingle processing facility supplying the RAS, RAS type and lot number shall be maintained by project contract number and kept for a minimum of three years.

1031.03 Testing. RAP/FRAP and RAS testing shall be according to the following.

(a) RAP/FRAP Testing. When used in HMA, the RAP/FRAP shall be sampled and tested either during processing or after stockpiling.

(1) During Stockpiling. For testing during stockpiling, washed extraction samples shall be run at the minimum frequency of one sample per 500 tons (450 metric tons) for the first 2000 tons (1800 metric tons) and one sample per 2000 tons (1800 metric tons) thereafter. A minimum of five tests shall be required for stockpiles less than 4000 tons (3600 metric tons).

(2) After Stockpiling. For testing after stockpiling, the Contractor shall submit a plan for approval to the District proposing a satisfactory method of sampling and testing the RAP/FRAP pile either in-situ or by restockpiling. The sampling plan shall meet the minimum frequency required above and detail the procedure used to obtain representative samples throughout the pile for testing.

Before extraction, each field sample whether RAP or FRAP, shall be split to obtain two samples of test sample size. One of the two test samples from the final split shall be labeled and stored for Department use. The Contractor shall extract the other test sample according to Department procedure. The Engineer reserves the right to test any sample (split or Department-taken) to verify Contractor test results.

(b) RAS Testing. RAS shall be sampled and tested either during or after stockpiling.

During stockpiling, washed extraction, and testing for unacceptable materials shall be run at the minimum frequency of one sample per 200 tons (180 metric tons) for the first 1000 tons (900 metric tons) and one sample per 1000 tons (900 metric tons) thereafter. A minimum of five samples are required for stockpiles less than 1000 tons (900 metric tons). Once a ≤ 1000 ton (900 metric ton), five-sample/test stockpile has been established it shall be sealed. Additional incoming RAS shall be stockpiled in a separate working pile as designated in the Quality Control plan and only added to the sealed stockpile when the test results of the working pile are complete and are found to meet the tolerances specified herein for the original sealed RAS stockpile.

Before extraction, each field sample shall be split to obtain two samples of test sample size. One of the two test samples from the final split shall be labeled and stored for Department use. The Contractor shall extract the other test sample according to Department procedures. The Engineer reserves the right to test any sample (split or Department-taken) to verify Contractor test results.

1031.04 Evaluation of Tests. Evaluation of tests results shall be according to the following.

(a) Evaluation of RAP/FRAP Test Results. All of the extraction results shall be compiled and averaged for asphalt binder content and gradation and, when applicable (for slag) G_{mm} . Individual extraction test results, when compared to the averages, will be accepted if within the tolerances listed below.

Revised 1/11/2013

| Parameter | RAP or FRAP | Conglomerate "D" Quality RAP |
|-------------------|-----------------------|---------------------------------|
| 1 in. (25 mm) | | ± 5 % |
| 1/2 in. (12.5 mm) | ± 8 % | ± 15 % |
| No. 4 (4.75 mm) | ± 6 % | ± 13 % |
| No. 8 (2.36 mm) | ± 5 % | |
| No. 16 (1.18 mm) | | ± 15 % |
| No. 30 (600 µm) | ± 5 % | |
| No. 200 (75 µm) | ± 2.0 % | ± 4.0 % |
| Asphalt Binder | ± 0.4 % ^{1/} | ± 0.5 % |
| G _{mm} | ± 0.03 ^{2/} | |

1/ The tolerance for FRAP shall be ± 0.3 %.

2/ For slag and steel slag

If more than 20 percent of the individual sieves and/or asphalt binder content tests are out of the above tolerances, the RAP/FRAP shall not be used in HMA unless the RAP/FRAP representing the failing tests is removed from the stockpile. All test data and acceptance ranges shall be sent to the District for evaluation.

With the approval of the Engineer, the ignition oven may be substituted for extractions according to the Illinois Test Procedure, "Calibration of the Ignition Oven for the Purpose of Characterizing Reclaimed Asphalt Pavement (RAP)".

- (b) Evaluation of RAS Test Results. All of the test results, with the exception of percent unacceptable materials, shall be compiled and averaged for asphalt binder content and gradation. Individual test results, when compared to the averages, will be accepted if within the tolerances listed below.

| Parameter | RAS |
|------------------------|---------|
| No. 8 (2.36 mm) | ± 5 % |
| No. 16 (1.18 mm) | ± 5 % |
| No. 30 (600 µm) | ± 4 % |
| No. 200 (75 µm) | ± 2.0 % |
| Asphalt Binder Content | ± 1.5 % |

If more than 20 percent of the individual sieves and/or asphalt binder content tests are out of the above tolerances, the RAS shall not be used in Department projects unless the RAS, RAP or FRAP representing the failing tests is removed from the stockpile. All test data and acceptance ranges shall be sent to the District for evaluation.

1031.05 Quality Designation of Aggregate in RAP/FRAP.

- (a) RAP. The aggregate quality of the RAP for homogenous, conglomerate, and conglomerate "D" quality stockpiles shall be set by the lowest quality of coarse aggregate in the RAP stockpile and are designated as follows.

Revised 1/11/2013

- (1) RAP from Class I, Superpave (High ESAL)/HMA (High ESAL), or (Low ESAL) IL-9.5L surface mixtures are designated as containing Class B quality coarse aggregate.
 - (2) RAP from Superpave (High ESAL)/HMA (Low ESAL) IL-19.0L binder mixture is designated as Class D quality coarse aggregate.
 - (3) RAP from Class I, Superpave (High ESAL)/HMA (High ESAL) binder mixtures, bituminous base course mixtures, and bituminous base course widening mixtures are designated as containing Class C quality coarse aggregate.
 - (4) RAP from bituminous stabilized subbase and BAM shoulders are designated as containing Class D quality coarse aggregate.
- (b) FRAP. If the Engineer has documentation of the quality of the FRAP aggregate, the Contractor shall use the assigned quality provided by the Engineer.

If the quality is not known, the quality shall be determined as follows. Fractionated RAP stockpiles containing plus #4 (4.75 mm) sieve coarse aggregate shall have a maximum tonnage of 5,000 tons (4,500 metric tons). The Contractor shall obtain a representative sample witnessed by the Engineer. The sample shall be a minimum of 50 lb (25 kg). The sample shall be extracted according to Illinois Modified AASHTO T 164 by a consultant prequalified by the Department for the specified testing. The consultant shall submit the test results along with the recovered aggregate to the District Office. The cost for this testing shall be paid by the Contractor. The District will forward the sample to the BMPR Aggregate Lab for MicroDeval Testing, according to Illinois Modified AASHTO T 327. A maximum loss of 15.0 percent will be applied for all HMA applications. The fine aggregate portion of the fractionated RAP shall not be used in any HMA mixtures that require a minimum of "B" quality aggregate or better, until the coarse aggregate fraction has been determined to be acceptable thru a MicroDeval Testing.

1031.06 Use of RAS, RAP or FRAP in HMA. The use of RAS, RAP or FRAP shall be a Contractor's option when constructing HMA in all contracts.

- (a) RAP/FRAP. The use of RAP/FRAP in HMA shall be as follows.
- (1) Coarse Aggregate Size (after extraction). The coarse aggregate in all RAP shall be equal to or less than the nominal maximum size requirement for the HMA mixture to be produced.
 - (2) Steel Slag Stockpiles. RAP/FRAP stockpiles containing steel slag or other expansive material, as determined by the Department, shall be homogeneous and will be approved for use in HMA (High ESAL and Low ESAL) mixtures regardless of lift or mix type.
 - (3) Use in HMA Surface Mixtures (High and Low ESAL). RAP/FRAP stockpiles for use in HMA surface mixtures (High and Low ESAL) shall have coarse aggregate that is Class B quality or better. RAP/FRAP shall be considered equivalent to limestone for frictional considerations unless produced/screened to minus 3/8 inch.

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- (4) Use in HMA Binder Mixtures (High and Low ESAL), HMA Base Course, and HMA Base Course Widening. RAP/FRAP stockpiles for use in HMA binder mixtures (High and Low ESAL), HMA base course, and HMA base course widening shall be FRAP in which the coarse aggregate is Class C quality or better.
 - (5) Use in Shoulders and Subbase. RAP/FRAP stockpiles for use in HMA shoulders and stabilized subbase (HMA) shall be RAP, Restricted FRAP, conglomerate, or conglomerate DQ.
- (b) RAS. RAS meeting Type 1 or Type 2 requirements will be permitted in all HMA applications as specified herein.
- (c) RAP/FRAP and/or RAS Usage Limits. Type 1 or Type 2 RAS may be used alone or in conjunction with RAP or FRAP in HMA mixtures up to a maximum of 5.0% by weight of the total mix.

When the Contractor chooses the RAP option, the percentage of the percentage of virgin asphalt binder replaced by the asphalt binder from the RAP shall not exceed the percentages indicated in the table below for a given N Design:

Max Asphalt Binder Replacement RAP Only
 Table 1

| HMA Mixtures ^{1/, 2/} Ndesign | Maximum % Asphalt Binder replacement (ABR) | | |
|---|--|---------|------------------|
| | Binder/Leveling Binder | Surface | Polymer Modified |
| 30L | 25 | 15 | 10 |
| 50 | 25 | 15 | 10 |
| 70 | 15 | 10 | 10 |
| 90 | 10 | 10 | 10 |
| 105 | 10 | 10 | 10 |
| 4.75 mm N-50 | | | 15 |
| SMA N-80 | | | 10 |

1/ For HMA "All Other" (shoulder and stabilized subbase) N-30, the percent asphalt binder replacement shall not exceed 50% of the total asphalt binder in the mixture.

2/ When the asphalt binder replacement exceeds 15 percent, the high and low virgin asphalt binder grades shall each be reduced by one grade (i.e. 25 percent binder replacement would require a virgin asphalt binder grade of PG64-22 to be reduced to a PG58-28). When constructing full depth HMA and the ABR is less than 15 percent, the required virgin asphalt binder grade shall be PG64-28.

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When the Contractor chooses either the RAS or FRAP option, the percent binder replacement shall not exceed the amounts indicated in the tables below for a given N Design.

Max Asphalt Binder Replacement RAS or FRAP
 Table 2

| HMA Mixtures ^{1/, 2/} | Level 1 - Maximum % ABR | | |
|--------------------------------|-------------------------|---------|------------------------------------|
| Ndesign | Binder/Leveling Binder | Surface | Polymer ^{3/, 4/} Modified |
| 30L | 35 | 30 | 15 |
| 50 | 30 | 25 | 15 |
| 70 | 30 | 20 | 15 |
| 90 | 20 | 15 | 15 |
| 105 | 20 | 15 | 15 |
| 4.75 mm N-50 | | | 25 |
| SMA N-80 | | | 15 |

1/ For HMA "All Other" (shoulder and stabilized subbase) N-30, the percent asphalt binder replacement shall not exceed 50% of the total asphalt binder in the mixture.

2/ When the asphalt binder replacement exceeds 15 percent for all mixes, except for SMA and IL-4.75, the high and low virgin asphalt binder grades shall each be reduced by one grade (i.e. 25 percent binder replacement will require a virgin asphalt binder grade of PG64-22 to be reduced to a PG58-28). When constructing full depth HMA and the ABR is less than 15 percent, the required virgin asphalt binder grade shall be PG64-28.

3/ When the ABR for SMA is 15 percent or less, the required virgin asphalt binder grade shall be SBS PG76-22.

4/ When the ABR for IL-4.75 mix is 15 percent or less, the required virgin asphalt binder grade shall be SBS PG76-22. When the ABR for the IL-4.75 mix exceeds 15 percent, the virgin asphalt binder grade shall be SBS PG70-28.

When the Contractor chooses the RAS with FRAP combination, the percent asphalt binder replacement shall split equally between the RAS and the FRAP, and the total replacement shall not exceed the amounts indicated in the tables below for a given N Design.

Revised 1/11/2013

Max Asphalt Binder Replacement RAS and FRAP Combination
 Table 3

| HMA Mixtures ^{1/, 2/} | Level 2 - Maximum % ABR | | |
|--------------------------------|-------------------------|---------|------------------------------------|
| | Binder/Leveling Binder | Surface | Polymer Modified ^{3/, 4/} |
| Ndesign | | | |
| 30L | 50 | 40 | 30 |
| 50 | 40 | 35 | 30 |
| 70 | 40 | 30 | 30 |
| 90 | 40 | 30 | 30 |
| 105 | 40 | 30 | 30 |
| 4.75 mm N-50 | | | 40 |
| SMA N-80 | | | 30 |

1/ For HMA "All Other" (shoulder and stabilized subbase) N-30, the percent asphalt binder replacement shall not exceed 50% of the total asphalt binder in the mixture.

2/ When the binder replacement exceeds 15 percent for all mixes, except for SMA and IL-4.75, the high and low virgin asphalt binder grades shall each be reduced by one grade (i.e. 25 percent binder replacement will require a virgin asphalt binder grade of PG64-22 to be reduced to a PG58-28).

3/ When the ABR for SMA is 15 percent or less, the required virgin asphalt binder shall be SBS PG76-22. When the ABR for SMA exceeds 15%, the virgin asphalt binder grade shall be SBS PG70-28.

4/ When the ABR for IL-4.75 mix is 15 percent or less, the required virgin asphalt binder grade shall be SBS PG76-22. When the ABR for the IL-4.75 mix exceeds 15 percent, the virgin asphalt binder grade shall be SBS PG70-28.

1031.07 HMA Mix Designs. At the Contractor's option, HMA mixtures may be constructed utilizing RAP/FRAP and/or RAS material meeting the above detailed requirements.

All HMA mixtures will be required to be tested, prior to submittal for Department verification, according to Illinois Modified AASHTO T324 (Hamburg Wheel) and shall meet the following requirements:

| Asphalt Binder Grade | # Repetitions | Max Rut Depth (mm) |
|----------------------|---------------|--------------------|
| PG76-XX | 20,000 | 12.5 |
| PG70-XX | 20,000 | 12.5 |
| PG64-XX | 10,000 | 12.5 |
| PG58-XX | 10,000 | 12.5 |
| PG52-XX | 10,000 | 12.5 |
| PG46-XX | 10,000 | 12.5 |

Note: For SMA Designs (N-80) the maximum rut depth is 6.0 mm at 20,000 repetitions.
 For IL 4.75 mm Designs (N-50) the maximum rut depth is 9.0 mm at 15,000 repetitions.

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1031.08 HMA Production. All HMA mixtures shall be sampled within the first 500 tons (450 metric tons) on the first day of production or during start up with a split reserved for the Department. The mix sample shall be tested according to the Illinois Modified AASHTO T 324 and shall meet the requirements specified herein. Mix production shall not exceed 1500 tons (1350 metric tons) or one day's production, whichever comes first, until the testing is completed and the mixture is found to be in conformance. The requirement to cease mix production may be waived if the plant produced mixture demonstrates conformance prior to start of mix production for a contract.

To remove or reduce agglomerated material, a scalping screen, gator, crushing unit, or comparable sizing device approved by the Engineer shall be used in the RAS, RAP and FRAP feed system to remove or reduce oversized material. If material passing the sizing device adversely affects the mix production or quality of the mix, the sizing device shall be set at a size specified by the Engineer.

If the RAS, RAP and FRAP control tolerances or QC/QA test results require corrective action, the Contractor shall cease production of the mixture containing RAs, RAP or FRAP and either switch to the virgin aggregate design or submit a new RAS, RAP or FRAP design.

- (a) RAP/FRAP. The coarse aggregate in all RAP/FRAP used shall be equal to or less than the maximum size requirement for the HMA mixture being produced.
- (b) RAS. RAS shall be incorporated into the HMA mixture either by a separate weight depletion system or by using the RAP weigh belt. Either feed system shall be interlocked with the aggregate feed or weigh system to maintain correct proportions for all rates of production and batch sizes. The portion of RAS shall be controlled accurately to within ± 0.5 percent of the amount of RAS utilized. When using the weight depletion system, flow indicators or sensing devices shall be provided and interlocked with the plant controls such that the mixture production is halted when RAS flow is interrupted.
- (c) RAS, RAP and FRAP. HMA plants utilizing RAS, RAP and FRAP shall be capable of automatically recording and printing the following information.

(1) Dryer Drum Plants.

- a. Date, month, year, and time to the nearest minute for each print.
- b. HMA mix number assigned by the Department.
- c. Accumulated weight of dry aggregate (combined or individual) in tons (metric tons) to the nearest 0.1 ton (0.1 metric ton).
- d. Accumulated dry weight of RAS, RAP and FRAP in tons (metric tons) to the nearest 0.1 ton (0.1 metric ton).
- e. Accumulated mineral filler in revolutions, tons (metric tons), etc. to the nearest 0.1 unit.
- f. Accumulated asphalt binder in gallons (liters), tons (metric tons), etc. to the nearest 0.1 unit.

Revised 1/11/2013

- g. Residual asphalt binder in the RAS, RAP and FRAP material as a percent of the total mix to the nearest 0.1 percent.
 - h. Aggregate RAS, RAP and FRAP moisture compensators in percent as set on the control panel. (Required when accumulated or individual aggregate and RAS, RAP and FRAP are printed in wet condition.)
 - i. When producing mixtures with FRAP and/or RAS, a positive dust control system shall be utilized.
 - j. Accumulated mixture tonnage.
 - k. Dust Removed (accumulated to the nearest 0.1 ton)
- (2) Batch Plants.
- a. Date, month, year, and time to the nearest minute for each print.
 - b. HMA mix number assigned by the Department.
 - c. Individual virgin aggregate hot bin batch weights to the nearest pound (kilogram).
 - d. Mineral filler weight to the nearest pound (kilogram).
 - f. RAS, RAP and FRAP weight to the nearest pound (kilogram).
 - g. Virgin asphalt binder weight to the nearest pound (kilogram).
 - h. Residual asphalt binder in the RAS, RAP and FRAP material as a percent of the total mix to the nearest 0.1 percent.

The printouts shall be maintained in a file at the plant for a minimum of one year or as directed by the Engineer and shall be made available upon request. The printing system will be inspected by the Engineer prior to production and verified at the beginning of each construction season thereafter.

1031.09 RAP in Aggregate Surface Course and Aggregate Shoulders. The use of RAP or FRAP in aggregate surface course and aggregate shoulders shall be as follows.

- (a) Stockpiles and Testing. RAP stockpiles may be any of those listed in Article 1031.02, except "Non-Quality" and "FRAP". The testing requirements of Article 1031.03 shall not apply.
- (b) Gradation. One hundred percent of the RAP material shall pass the 1 1/2 in. (37.5mm) sieve. The RAP material shall be reasonably well graded from coarse to fine. RAP material that is gap-graded, FRAP, or single sized will not be accepted for use as Aggregate Surface Course and Aggregate Shoulders."

Revised 1/11/2013

- (g) **ENFORCEMENT.** The Department reserves the right to withhold payment to the Contractor to enforce the provisions of this Special Provision. Final payment shall not be made on the contract until such time as the Contractor submits sufficient documentation demonstrating achievement of the goal in accordance with this Special Provision or after liquidated damages have been determined and collected.
- (h) **RECONSIDERATION.** Notwithstanding any other provision of the contract, including but not limited to Article 109.09 of the Standard Specifications, the Contractor may request administrative reconsideration of a decision to deduct the amount of the goal not achieved as liquidated damages. A request to reconsider shall be delivered to the Contract Compliance Section and shall be handled and considered in the same manner as set forth in paragraph (c) of "Good Faith Effort Procedures" of this Special Provision, except a final decision that a good faith effort was not made during contract performance to achieve the goal agreed to in the Utilization Plan shall be the final administrative decision of the Department.

FRICTION SURFACE AGGREGATE (D1)

Effective: January 1, 2011
Revised: November 1, 2012

Revise Article 1004.01(a)(4) of the Standard Specifications to read:

- "(4) Crushed Stone. Crushed stone shall be the angular fragments resulting from crushing undisturbed, consolidated deposits of rock by mechanical means. Crushed stone shall be divided into the following, when specified.
- a. Carbonate Crushed Stone. Carbonate crushed stone shall be either dolomite or limestone. Dolomite shall contain 11.0 percent or more magnesium oxide (MgO). Limestone shall contain less than 11.0 percent magnesium oxide (MgO).
 - b. Crystalline Crushed Stone. Crystalline crushed stone shall be either metamorphic or igneous stone, including but is not limited to, quartzite, granite, rhyolite and diabase."

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

"1004.03 Coarse Aggregate for Hot-Mix Asphalt (HMA). The aggregate shall be according to Article 1004.01 and the following revisions.

- (a) Description. The coarse aggregate for HMA shall be according to the following table.

Revised 1/11/2013

| Use | Mixture | Aggregates Allowed |
|------------------------------|--|---|
| Class A | Seal or Cover | <u>Allowed Alone or in Combination:</u> Gravel Crushed Gravel Carbonate Crushed Stone Crystalline Crushed Stone Crushed Sandstone Crushed Slag (ACBF) Crushed Steel Slag Crushed Concrete |
| HMA All Other | Shoulders | <u>Allowed Alone or in Combination:</u> Gravel Crushed Gravel Carbonate Crushed Stone Crystalline Crushed Stone Crushed Sandstone Crushed Slag (ACBF) ^{1/} Crushed Steel Slag ^{1/} Crushed Concrete |
| HMA High ESAL Low ESAL | C Surface IL-12.5,IL-9.5, or IL-9.5L | <u>Allowed Alone or in Combination:</u> Crushed Gravel Carbonate Crushed Stone Crystalline Crushed Stone Crushed Sandstone Crushed Slag (ACBF) ^{1/} Crushed Steel Slag ^{1/} Crushed Concrete |

Revised 1/11/2013

| | | | |
|------------------|--|--|--|
| HMA High ESAL | D Surface IL-12.5 or IL-9.5 | <u>Allowed Alone or in Combination:</u> Crushed Gravel Carbonate Crushed Stone (other than Limestone) Crystalline Crushed Stone Crushed Sandstone Crushed Slag (ACBF) ^{1/} Crushed Steel Slag ^{1/} Crushed Concrete | |
| | | <u>Other Combinations Allowed:</u> | |
| | | <i>Up to...</i> | <i>With...</i> |
| | | 25% Limestone | Dolomite |
| | | 50% Limestone | Any Mixture D aggregate other than Dolomite |
| 75% Limestone | Crushed Slag (ACBF) ^{1/} or Crushed Sandstone | | |
| HMA High ESAL | F Surface IL-12.5 or IL-9.5 | <u>Allowed Alone or in Combination:</u> Crystalline Crushed Stone Crushed Sandstone Crushed Slag (ACBF) ^{1/} Crushed Steel Slag ^{1/} No Limestone or no Crushed Gravel alone. | |
| | | <u>Other Combinations Allowed:</u> | |
| | | <i>Up to...</i> | <i>With...</i> |
| | | 50% Crushed Gravel, or Dolomite | Crushed Sandstone, Crushed Slag (ACBF) ^{1/} , Crushed Steel Slag ^{1/} , or Crystalline Crushed Stone |
| | | | |

| | | |
|------------------|------------------------------|--|
| HMA High ESAL | SMA Ndesign 80 Surface | Crystalline Crushed Stone Crushed Sandstone Crushed Steel Slag ^{1/} |
|------------------|------------------------------|--|

1/ When either slag is used, the blend percentages listed shall be by volume.

HOT-MIX ASPHALT - DENSITY TESTING OF LONGITUDINAL JOINTS (BDE)

Effective: January 1, 2010

Revised: April 1, 2012

Description. This work shall consist of testing the density of longitudinal joints as part of the quality control/quality assurance (QC/QA) of hot-mix asphalt (HMA). Work shall be according to Section 1030 of the Standard Specifications except as follows.

Quality Control/Quality Assurance (QC/QA). Delete the second and third sentence of the third paragraph of Article 1030.05(d)(3) of the Standard Specifications.

Add the following paragraphs to the end of Article 1030.05(d)(3) of the Standard Specifications:

“Longitudinal joint density testing shall be performed at each random density test location. Longitudinal joint testing shall be located at a distance equal to the lift thickness or a minimum of 4 in. (100 mm), from each pavement edge. (i.e. for a 5 in. (125 mm) lift the near edge of the density gauge or core barrel shall be within 5 in. (125 mm) from the edge of pavement.) Longitudinal joint density testing shall be performed using either a correlated nuclear gauge or cores.

- a. Confined Edge. Each confined edge density shall be represented by a one-minute nuclear density reading or a core density and shall be included in the average of density readings or core densities taken across the mat which represents the Individual Test.

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