Regional Engineers

 Jack A. Elston

 Special Provision for Hot-Mix Asphalt – Mixture Design Verification and Production (Modified for I-FIT)

 April 16, 2021

This special provision was developed to require use of the Illinois Flexibility Index Test (I-FIT) to identify the cracking resistance properties of hot-mix asphalt (HMA) by using the flexibility index (FI) parameter. It has been revised to increase the number of days the contractor has to submit Low ESAL production samples to the District for verification testing.

This special provision should be inserted into all HMA contracts.

The districts should include the BDE Check Sheet marked with the applicable special provisions for the July 30, 2021 and subsequent lettings. The Project Coordination and Implementation Section will include a copy in the contract.

This special provision will be available on the transfer directory April 16, 2021.

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# hot-mix asphalt – MIXTURE DESIGN VERIFICATION AND PRODUCTION (MODIFIED FOR I-FIT) (bde)

Effective: January 1, 2019

Revised: July 1, 2021

Description. This special provision requires the Illinois Flexibility Index Test (I-FIT) be used during mixture design verification and production testing for all hot-mix asphalt (HMA) mixtures.

Mixture Design. Add the following to the list of referenced standards in Article 1030.04 of the Standard Specifications:

“Illinois Modified AASHTO TP 124 Determining the Fracture Potential of Asphalt Mixtures Using the Illinois Flexibility Index Test (I-FIT)”

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

“ (d) Verification Testing. During mixture design, prepared samples shall be submitted to the District laboratory for verification testing. The required testing, and number and size of prepared samples submitted, shall be according to the following tables.

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| High ESAL – Required Samples for Verification Testing |
| Mixture | Hamburg Wheel and I-FIT Testing 1/ 2/ | Tensile Strength Testing |
| Binder | total of 3 - 160 mm tall bricks | 6 - 95 mm tall bricks |
| Surface | total of 4 - 160 mm tall bricks 3/ | 6 - 95 mm tall bricks |

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| Low ESAL – Required Samples for Verification Testing |
| Mixture | I-FIT Testing 1/ 2/ | Tensile Strength Testing |
| Binder | 1 - 160 mm tall brick | 6 - 95 mm tall bricks |
| Surface | 2 - 160 mm tall bricks 3/ | 6 - 95 mm tall bricks |

1/ The compacted gyratory bricks for Hamburg wheel and I-FIT testing shall be 7.5 ± 0.5 percent air voids.

2/ If the Contractor does not possess the equipment to prepare the 160 mm tall brick(s), twice as many 115 mm tall compacted gyratory bricks will be acceptable.

3/ The additional surface mixture brick tested for I-FIT long term aging will be for the Department’s informational purposes only.

New and renewal mix designs shall meet the following requirements for verification testing.

(1) Hamburg Wheel Test. The maximum allowable rut depth shall be 0.5 in. (12.5 mm). The minimum number of wheel passes at the 0.5 in. (12.5 mm) rut depth criteria shall be based on the high temperature binder grade of the mix as specified in the mix requirements table of the plans.

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| Illinois Modified AASHTO T 324 Requirements 1/ |
| PG Grade | Minimum Number of Wheel Passes |
| PG 58-xx (or lower) | 5,000 |
| PG 64-xx | 7,500 |
| PG 70-xx |  15,000 2/ |
| PG 76-xx (or higher) |  20,000 2/ |

1/ When produced at temperatures of 275 ± 5 °F (135 ± 3 °C) or below, loose warm mix asphalt shall be oven aged at 270 ± 5 °F (132 ± 3 °C) for two hours prior to gyratory compaction of Hamburg wheel specimens.

2/ For IL-4.75 binder course, the minimum number of wheel passes shall be reduced by 5,000.

(2) Tensile Strength. Tensile strength testing shall be according to the Illinois Modified AASHTO T 283 procedure. The minimum allowable conditioned tensile strength shall be 60 psi (415 kPa) for non-polymer modified performance graded (PG) asphalt binder and 80 psi (550 kPa) for polymer modified PG asphalt binder, except polymer modified PG XX-28 or lower asphalt binders which shall have a minimum tensile strength of 70 psi (483 kPa). The maximum allowable unconditioned tensile strength shall be 200 psi (1380 kPa).

(3) I-FIT Flexibility Index (FI). The minimum FI shall be as follows.

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| Illinois Modified AASHTO TP 124 |
| Mixture | Short Term Aging,Minimum FI |
|  HMA 1/ | 8.0 |
| SMA | 16.0 |
| IL-4.75 | 12.0 |

1/ All mix designs, except for SMA and IL-4.75 mixtures.

If a mix fails the Department’s verification testing, the Contractor shall make necessary changes to the mix and provide passing Hamburg wheel, tensile strength, and I-FIT test results from a private lab. The Department will verify the passing results.”

Start of HMA Production and Job Mix Formula (JMF) Adjustments. Revise Article 1030.06(a) of the Standard Specifications to read:

“ (a) High ESAL Mixtures. A test strip will be required at the beginning of HMA production for each mixture according to the Manual of Test Procedures for Materials “Hot Mix Asphalt Test Strip Procedures”. A test strip will not be required for HMA mixtures or shoulder applications with a quantity less than 3000 tons (2750 metric tons); however, such mixtures shall still be sampled on the first day of production for the Hamburg wheel and I-FIT testing.

Before start-up, target values shall be determined by applying gradation correction factors to the JMF when applicable. These correction factors shall be determined from previous experience. The target values, when approved by the Engineer, shall be used to control HMA production. Plant settings and control charts shall be set according to target values.

Before constructing the test strip, target values shall be determined by applying gradation correction factors to the JMF when applicable. After any JMF adjustment, the JMF shall become the Adjusted Job Mix Formula (AJMF). Upon completion of the first acceptable test strip, the JMF shall become the AJMF regardless of whether or not the JMF has been adjusted. If an adjustment/plant change is made, the Engineer may require a new test strip to be constructed. If the HMA placed during the initial test strip is determined to be unacceptable to remain in place by the Engineer, it shall be removed and replaced.

The limitations between the JMF and AJMF are as follows.

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| 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) | \* |
| No. 200 (75 µm) | \* |
| Asphalt Binder Content | ± 0.3 % |

\* In no case shall the target for the amount passing be greater than the JMF.

Adjustments outside the above limitations will require a new mix design.

Mixture sampled to represent the test strip shall include approximately 60 lb (27 kg) of additional material for the Department to conduct Hamburg wheel testing and approximately 80 lb (36 kg) of additional material for the Department to conduct I-FIT testing. Within two working days after sampling, the Contractor shall deliver prepared samples to the District laboratory for verification testing. The required number and size of prepared samples submitted for the Hamburg wheel and I-FIT testing shall be according to the “High ESAL - Required Samples for Verification Testing” table in Article 1030.04(d) above.

Mixture sampled during production for Hamburg wheel and I-FIT will be tested by the Department. The Hamburg wheel and I-FIT results shall meet the requirements specified in Article 1030.04(d) above.

Upon notification by the Engineer of a failing Hamburg wheel or I-FIT test and prior to restarting production, the Contractor shall make necessary adjustments approved by the Engineer to the mixture production and submit another mixture sample for the Department to conduct Hamburg wheel and I-FIT testing. Prior produced material may be paved out provided all other mixture criteria is being met. Upon consecutive failing Hamburg wheel and I-FIT tests, no additional mixture shall be produced until the Engineer receives passing Hamburg wheel and I-FIT test results.

The Department may conduct additional Hamburg wheel and I-FIT testing on production material as determined by the Engineer.”

Add the following to the end of Article 1030.06(b) of the Standard Specifications:

“I-FIT testing will be performed for Low ESAL mixtures (excluding Class D patches, pavement patching and incidental HMA) during mixture production. Within two working days after sampling, the Contractor shall deliver prepared samples to the District laboratory for verification testing. The required number and size of prepared samples submitted for the I-FIT testing shall be according to the “Low ESAL - Required Samples for Verification Testing” table in Article 1030.04(d) above.”

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