



Florida Department of Transportation

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August 11, 2015

Khoa Nguyen
Director, Office of Technical Services
Federal Highway Administration
3500 Financial Plaza, Suite 400
Tallahassee, Florida 32312

Re: State Specifications Office
Section **330**
Proposed Specification: **3300000 Hot Mix Asphalt – General Construction Requirements.**

Dear Mr. Nguyen:

We are submitting, for your approval, two copies of the above referenced Supplemental Specification.

The changes are proposed by Richard Hewitt of the State Construction Office to improve readability of the Specification, provide clarity regarding tack needs to be placed on clean, dry surfaces, allow Windrow Paving, lower density minimum to 89.5% to account for CoreDry equipment accuracy, and eliminate vertical vibratory compaction of thin lifts (1" or less).

Please review and transmit your comments, if any, within two weeks. Comments should be sent via email to daniel.scheer@dot.state.fl.us.

If you have any questions relating to this specification change, please call me at 414-4130.

Sincerely,

Signature on file

Daniel Scheer, P.E.
State Specifications Engineer

DS/ot
Attachment

cc: Florida Transportation Builders' Assoc.
State Construction Engineer

HOT MIX ASPHALT – GENERAL CONSTRUCTION REQUIREMENTS.(REV ~~5-27286-128-11~~-15)

SECTION 330 is deleted and the following substituted:

**SECTION 330
HOT MIX ASPHALT -
GENERAL CONSTRUCTION REQUIREMENTS**

330-1 Description.

This Section specifies the basic equipment and construction requirements for hot mix asphalt (including warm mix asphalt) pavements and bases. Establish and maintain a quality control system that provides assurance that all materials, products and completed construction submitted for acceptance meet Contract requirements.

330-2 Quality Control (QC) Requirements.

330-2.1 Minimum QC Requirements: Perform as a minimum, the following activities necessary to maintain process control and meet Specification requirements:

1. Pavement Density: Monitor the pavement temperature with an infrared temperature device so ~~that~~ compaction is completed before the surface temperature of the pavement drops to the extent that effective compaction may not be achieved or the rollers begin to damage the pavement. Monitor the roadway density with either 6 inch diameter roadway cores, a nuclear density gauge, or other density measuring device, at a minimum frequency of once per 1,500 feet of pavement.

2. Mix Temperature: Determine the mix temperature at the roadway for the first five loads and one out of every five loads thereafter.

3. Mix Spread Rate: Monitor the mix spread rate at the beginning of each day's production, and as needed to control the operations, at a minimum of once per 200 tons placed. When determining the spread rate, use, at a minimum, an average of five truckloads of mix.

4. Pavement Texture: Monitor the pavement texture to minimize pavement segregation. Use density gauges, infrared temperature measurement devices, or roadway cores at the beginning of each day's production, and as necessary, both at truck exchanges and during normal paving operations.

5. Reporting: Ensure the accuracy of the Quality Control Roadway Reports on the Department's approved form to reflect the actual surface area of the finished work and be in compliance with the requirements of the Contract Documents.

330-2.2 Personnel Qualifications: Provide QC Technicians in accordance with Section 105.

330-3 Limitations of Operations.

330-3.1 Weather Limitations: Do not transport asphalt mix from the plant to the roadway unless all weather conditions are suitable for the paving operations.

330-3.2 Limitations of Paving Operations:

330-3.2.1 General: Place the mixture only when the surface upon which it is to be placed has been previously prepared, is intact, firm, dry, clean, and the tack or prime coat,

with acceptable spread rate, is properly broken or cured. Do not place friction course until the adjacent shoulder area has been dressed and grassed.

330-3.2.2 Ambient Air Temperature: Place the mixture only when the air temperature in the shade and away from artificial heat meets requirements of Table 330-1. The minimum ambient temperature requirement may be reduced by 5°F when using warm mix technology, if mutually agreed to by both the Engineer and the Contractor.

Table 330-1	
Ambient Air Temperature Requirements for Paving	
Layer Thickness or Asphalt Binder Type	Minimum Temperature (°F)
≤ 1 inch	50
Any mixture > 1 inch containing a PG asphalt binder having <i>with</i> a high temperature designation ≥ 76°C	45
Any mixture > 1 inch containing a PG asphalt binder having <i>with</i> a high temperature designation < 76°C	40
FC-5 ⁽¹⁾	65

⁽¹⁾As an exception, place the mixture at temperatures no lower than 60°F, only when approved by the Engineer based on the Contractor's demonstrated ability to achieve a satisfactory surface texture and appearance of the finished surface. The minimum ambient temperature may be further reduced to 55°F when using warm mix technology, if agreed to by both the Engineer and the Contractor.

330-3.2.3 Rain and Surface Conditions: Immediately cease transportation of asphalt mixtures from the plant when rain begins at the roadway. Do not place asphalt mixtures while rain is falling, or when there is water on the surface to be covered. Once the rain has stopped, ~~and~~ standing water has been removed from the tacked surface to the satisfaction of the Engineer, and the temperature of the mixture caught in transit still meets the requirements as specified in 320-6.3, the Contractor may then place the mixture caught in transit.

For windrow paving, immediately cease dumping of asphalt material when rain begins at the roadway. Stop paving operations while rain is falling or where there is water on the surface to be covered. -Remove windrowed asphalt mixture exposed to rain. Once the rain has stopped, standing water has been removed from the tacked surface to the satisfaction of the Engineer, and the temperature of the mixture caught in transit still meets the requirements as specified in 320-6.3, the Contractor may then windrow the remaining material caught in transit.

330-3.2.4 Wind: Do not place the mixture when the wind is blowing to such an extent that proper and adequate compaction cannot be maintained or when sand, dust, etc., are being deposited on the surface being paved to the extent ~~that~~ the bond between layers will be diminished.

330-4 Surface Preparation.

330-4.1 Cleaning: ~~Prior to~~*Before* placing the mixture, clean the surface of the base or underlying pavement of all loose and deleterious material by the use of power brooms or blowers, supplemented by hand brooming where necessary.

330-4.1.1 Application over Asphalt Rubber Membrane Interlayer (ARMI): Where an asphalt mix is to be placed over a newly constructed ARMI, do not sweep or otherwise disturb the cover material ~~prior to~~*before* placing the asphalt mix, unless directed by the Engineer.

330-4.2 Tacking: Apply a tack coat on all existing pavement surfaces that are to be overlaid with an asphalt mix as specified in Section 300 and between successive layers of all asphalt mixes. *Apply tack on a clean surface.-*

-Do not place tack while rain is falling, or when there is water on the surface to be tacked. Once the rain has stopped, standing water has been removed from the surface to be tacked to the satisfaction of the Engineer, the Contractor may then apply tack.

-Apply a tack coat on freshly primed bases only when so directed by the Engineer.

330-5 Paving Equipment.

330-5.1 General Requirements: Use *mechanically-sound* equipment ~~that is mechanically-sound and~~ capable of consistently meeting *the Specification* requirements ~~of these Specifications.~~

330-5.2 Asphalt Paver:

330-5.2.1 General: Provide an *self-propelled*, asphalt paver that ~~is self-propelled~~, can be steered, and is equipped with a receiving and distribution hopper and a mechanical screed. Use a mechanical screed capable of adjustment to regulate the depth of material spread and to produce the desired cross-section.

When asphalt mix is placed in windrows, operate windrow pickup equipment so substantially all of the mixture deposited on the roadbed is picked up and loaded into the paver. -Prevent the windrow pickup equipment from contaminating the mixture.

330-5.2.2 Automatic Screed Control: For all asphalt courses placed with an asphalt paver, equip the paver with automatic longitudinal screed controls of either the skid type, traveling stringline type, or non-contact averaging ski type with a minimum length of 25 feet. On the final layer of asphalt base, overbuild, ~~and~~ structural courses, and ~~for~~ friction courses, use the joint matcher ~~instead~~ *lieu* of the skid, traveling stringline, or non-contact averaging ski on all passes after the initial pass. Equip the asphalt paver with electronic cross-slope controls.

330-5.2.3 Screed Width: Provide an asphalt paver ~~having~~ *with* a screed width greater than 8 feet when required to pave full width lanes. Do not use extendable screed strike-off devices that do not provide preliminary compaction of the mat in place of fixed screed extensions. Use a strike-off device only on irregular areas that would normally be done by hand and on shoulders 5 feet or less in width. When using the strike-off device on shoulders, ~~instead~~ *lieu* of an adjustable screed extension, demonstrate the ability to obtain ~~an~~ acceptable texture, density, and thickness.

When using an extendable screed device to extend the screed's width on the full width lane or shoulder by 24 inches or greater, the Engineer will require an auger extension, paddle, or kicker device unless written documentation from the manufacturer is provided ~~that~~ *stating* these are not necessary.

330-5.3 Rollers:

330-5.3.1 Steel-Wheeled Rollers: Provide compaction equipment capable of meeting the density requirements described in these Specifications. ~~In the event that~~ *When* density testing is not required, and the standard rolling pattern is used, provide a tandem steel-wheeled roller weighing 5 to 15 tons for breakdown rolling. For finish rolling, use a separate roller ~~with a~~ *weighting of* 5 to 15 tons. Variations from these requirements shall be approved by the Engineer.

330-5.3.2 Traffic Rollers: Provide compaction equipment capable of meeting the density requirements described in the Specifications. ~~When~~ *In the event that* density testing is not

required, and the standard rolling pattern is used, provide a self-propelled, pneumatic-tired traffic roller equipped with at least seven smooth-tread, low pressure tires, equipped with pads or scrapers on each tire. Maintain the tire pressure between 50 and 55 psi or as specified by the manufacturer. Use rollers with a minimum weight of 6 tons. Do not use wobble-wheeled rollers. Variations from these requirements shall be approved by the Engineer.

330-5.3.3 Prevention of Adhesion: Do not allow the mixture to adhere to the wheels of any rollers. Do not use fuel oil or other petroleum distillates to prevent adhesion. Do not use any method which results in water being sprinkled directly onto the mixture.

330-5.4 Coring Equipment: Furnish a suitable saw or drill for obtaining the required density cores.

330-5.5 Hand Tools: Provide the necessary hand tools such as rakes, shovels, and other similar tools, and a suitable means for keeping them clean. Do not use diesel fuel or other petroleum-based solvents contained in an open container for cleaning purposes on the paver.

330-6 Placing Mixture.

330-6.1 Requirements Applicable to All Pavement Types:

330-6.1.1 Alignment of Edges: Place all asphalt mixtures by the stringline method to obtain an accurate, uniform alignment of the pavement edge. As an exception, pavement edges adjacent to curb and gutter or other true edges do not require a stringline. Control the unsupported pavement edge to ensure ~~that it will not deviate~~ *from the stringline* more than plus or minus 1.5 inches ~~from the stringline~~.

330-6.1.2 Paving Width: If necessary due to the traffic requirements, place the mixture in strips in such a manner as to provide for the passage of traffic. As an option, where the road is closed to traffic, place the mixture to the full width with machines traveling in echelon.

330-6.1.3 Mix Temperature: Maintain the ~~mix temperature of the mix~~ at the time of paving within the master range as defined in 320-6.3. ~~The minimum frequency for taking~~ mix temperatures on the roadway *at the minimum frequency will be as* indicated in 320-6.3. Any load, or portion of a load, of asphalt mix on the roadway with a temperature outside of the master range shall be rejected for use on the project. Immediately notify the Engineer of the rejection.

Remove any windrow material not meeting the temperature requirements of 320-6.3.2. If the windrow material violates the temperature requirements of 320-6.3.2, remove the material from the area of deficient temperature and replace with new asphalt meeting the temperature requirements.

330-6.1.4 Speed of Paver: Establish the forward speed of the asphalt paver based on the rate of delivery of the mix to the roadway, but not faster than the optimum speed needed to adequately compact the pavement.

330-6.1.5 Thickness and Spread Rate of Layers: Construct each layer as defined in the following table:

Table 330-2	
Thickness and Target Spread Rate Requirements	
Mix Type	Specification Section and Article
Type SP	334-1
Type FC	337-8
Type B	234-8

ATPB	287-8
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330-6.1.5.1 Thickness Control: Ensure the spread rate is within plus or minus 5% of the target spread rate. When determining the spread rate, use, at a minimum, an average of five truckloads of mix and at a maximum, an average of 10 truckloads of mix, *- except for windrow paving, use an average of three truckloads of mix.* When the average spread rate is beyond plus or minus 5% of the target spread rate, monitor the thickness of the pavement layer closely and adjust the construction operations.

When the average spread rate for two consecutive days is beyond plus or minus 5% of the target spread rate, stop the construction operation until the issue is resolved.

330-6.1.5.2 Maximum Spread Rate Tolerances: When an individual spread rate, measured in accordance with 330-6.1.5.1, is beyond plus or minus 20% of the target spread rate, stop the construction operation until the issue is resolved. Address the unacceptable pavement in accordance with 330-9.5. The following areas are exempt from a work stoppage based solely on the calculated spread rate: median crossovers, turnouts, variable thickness overbuild courses, leveling courses, miscellaneous asphalt pavement, as well as, turn lanes and ramps less than 1,000 feet.

As an exception, the Engineer may allow the Contractor to leave areas in place if it is determined by the Engineer that the deficiency is not a significant detriment to the pavement quality. For areas of deficient thickness, a reduction to the pay item quantity will be made in accordance with 330-9.5.2.

330-6.1.6 Correcting Defects: Before starting any rolling, check the surface; correct any irregularities; remove all drippings, sand accumulations from the screed, and fat spots from any source; and replace them with satisfactory material. Do not skin patch. When correcting a depression while the mixture is hot, scarify the surface and add fresh mixture.

330-6.1.7 Hand Work: In limited areas where the use of the paver is impossible or impracticable, the Contractor may place and finish the mixture by hand.

330-7 Compacting Mixture.

330-7.1 General Requirements: When density testing for acceptance is required, select equipment, sequence, and coverage (number of times the roller passes over a given area of pavement) of rolling to meet the specified density requirement. Regardless of the rolling procedure used, complete the final rolling before the surface temperature of the pavement drops to the extent *that* effective compaction may not be achieved or the rollers begin to damage the pavement.

No vibratory compaction in the vertical direction will be allowed for layers one inch or less in thickness or, if the Engineer (or Contract Documents) limits compaction to the static mode only.- Compact these layers in the static mode only. -Other non-vertical vibratory modes of compaction will be allowed, if approved by the Engineer-,however, ~~No~~ additional compensation, cost or time, ~~shall~~ will be made.

330-7.2 Standard Rolling Procedure: When density testing for acceptance is not required, propose an alternative rolling pattern to be approved by the Engineer or use the following standard rolling procedure:

1. Breakdown rolling: Provide two static coverages with a tandem steel-wheeled roller, following as close behind the paver as possible without pick-up, undue displacement, or blistering of the ~~mix~~~~aterial~~.

2. Intermediate rolling: Provide five static coverages with a pneumatic-tired roller, following as close behind the breakdown rolling operation as the mix will permit.

3. Finish rolling: Provide one static coverage with a tandem steel-wheeled roller, after completing the breakdown rolling and intermediate rolling, but before the surface pavement temperature drops to the extent ~~that~~ effective compaction may not be achieved or the rollers begin to damage the pavement.

330-7.3 Rolling Procedures: ~~Use~~~~tilize~~ procedures that will uniformly compact the pavement layer to the desired density level, while meeting the appropriate smoothness requirements, without damaging the pavement surface, crushing aggregate or leaving excessive roller marks, roller heads, or ripples. While rolling is in progress, monitor the surface continuously, and adjust the compaction operations to comply with the surface requirements.

330-7.4 Compaction of Areas Inaccessible to Rollers: Use hand tamps or other satisfactory means to compact areas which are inaccessible to a roller, such as areas adjacent to curbs, gutters, bridges, manholes, etc.

330-7.5 Correcting Defects: Do not allow the compaction equipment to deposit contaminants onto the pavement surface. Remove and replace any areas damaged by such deposits as directed ~~by the Engineer~~ ~~by the~~ **Engineer**. Correct any depressions that develop before completing the rolling by loosening the mixture and adding new mixture to bring the depressions to a true surface. Should any depression remain after obtaining the final compaction, remove the full depth of the mixture, and replace it with ~~sufficient~~~~enough~~ new mixture to form a true and even surface. Correct all defects ~~prior to~~~~before~~ laying the subsequent course.

330-7.6 Use of Traffic Roller: Use a traffic roller on the first overbuild course. Use a traffic roller or vibratory roller (unless restricted by the Contract Documents) on the first structural layer placed on an ARMI.

330-7.7 Compaction at Bridge Structures: Compact asphalt mixtures placed over bridge decks and approach slabs using static compaction only. ~~Use~~~~tilize~~ the standard rolling procedure described in 330-7.2 or an alternative procedure approved by the Engineer.

330-8 Joints.

330-8.1 General: When laying fresh mixture against the exposed edges of joints, place it in close contact with the exposed edge to produce an even, well-compacted joint after rolling.

330-8.2 Transverse Joints: Place the mixture as continuously as possible to minimize transverse joints. When constructing permanent transverse joints, meet the surface requirements as defined in 330-9. Construct temporary transverse joints in such a manner to allow traffic to pass over it. When resuming the paving operation, construct a transverse joint by cutting back on the previously placed pavement at a location where the straightedge requirements are met. At the project limits, tie into the adjoining pavement layers as shown ~~to~~ in the Plans.

330-8.3 Longitudinal Joints: Place each layer of pavement so ~~that~~ all longitudinal construction joints are offset 6 to 12 inches laterally between successive layers. Plan offsets in advance so ~~that~~ longitudinal joints of the friction course are not in wheel path areas. The longitudinal joints for friction course layers should be within 6 inches of the lane edge or at the center of the lane. The Engineer may waive this requirement where offsetting is not feasible due to the sequence of construction.

330-8.4 Placing Asphalt Next to Concrete Pavement: When placing asphalt next to concrete pavement, construct the joint as shown ~~to~~ in the Plans.

330-9 Surface Requirements.

330-9.1 General: Construct a smooth pavement with good surface texture and the proper cross-slope.

330-9.2 Texture of the Finished Surface of Paving Layers: Produce a finished surface of uniform texture and compaction with no pulled, torn, raveled, crushed or loosened portions and free of segregation, bleeding, flushing, sand streaks, sand spots, or ripples. ~~Some~~ *Examples of some of the pavement deficiencies are displayed at the following URL:*

<http://www.dot.state.fl.us/ProgramManagement/Implemented/URLInSpecs/Pavement.shtm>.

Address any pavement not meeting the requirements of this specification in accordance with 330-9.5.

For dense-graded structural and friction course mixtures, in areas not defined ~~to be as~~ density testing exceptions per 334-5.1.2, obtain for the Engineer three 6 inch diameter roadway cores at locations visually identified by the Engineer to be segregated. The Engineer will determine the density of each core in accordance with FM 1-T 166 and calculate the percent G_{mm} of the segregated area using the average G_{mb} of the roadway cores and the QC subplot G_{mm} for the questionable material. If the average percent G_{mm} is less than ~~90.0~~ 89.5, address the segregated area in accordance with 330-9.5.

Do not use asphalt concrete mixtures containing aggregates that cause a different color appearance in the final wearing surface unless the section is greater than or equal to one mile in length and across the full width of the pavement, including shoulders and turn lanes. Exceptions to these requirements will be permitted if approved by the Engineer.

330-9.3 Cross-Slope: Construct a pavement surface with cross-slopes in compliance with the requirements of the Contract Documents. Furnish ~~an~~ *4 foot* ~~foot~~ *long* electronic level ~~with a length of 4 feet and an~~ accuracy ~~to of~~ 0.1 degree, approved by the Engineer for the control of cross-slope. Make this electronic level available at the jobsite at all times during paving operations.

330-9.3.1 QC Calibration and Comparison Requirements: Calibrate the electronic levels a minimum of once per day before paving operations begin, in accordance with manufacturer's instructions.

Compare the QC level with the Verification level before paving operations begin, and at any time as directed ~~by the Engineer~~. If the comparison between the QC and Verification levels is within ~~the comparison tolerance of~~ plus or minus 0.2%, the QC level is considered to compare favorably and can be used for measurement and acceptance of cross-slopes. If the levels do not compare favorably, perform a second comparison using another calibrated electronic level (FDOT or Contractor) for resolution. If ~~this~~ resolution level compares favorably with the QC level, the QC level is considered to be verified. If the ~~second~~ *resolution* level does not compare favorably with the QC level, discontinue the use of the QC electronic level and obtain another approved electronic level that meets the requirements of this specification. ~~Regardless of the comparison analysis outcome,~~ *The Contractor assumes all risk associated with placing the pavement at the correct cross-slope.*

330-9.3.2 Cross-Slope Measurement: Measure the cross-slope of the compacted pavement surface by placing the level at the center ~~location of~~ *the* lane and perpendicular to the roadway centerline. Record all measurements to the nearest 0.1% on ~~the Cross-Slope Measurement Data Form~~ *an approved form* and submit ~~the data~~ to the Engineer ~~for~~.

documentation.

330-9.3.2.1 Cross-Slope Measurement Frequency:

1. Tangent Sections: Measure the cross-slope at a minimum frequency of one measurement every 100 feet per lane. ~~Calculate the absolute deviation of each cross-slope measurement and then average the absolute deviations of ten consecutive cross-slope measurements. (The absolute deviation is the positive value of a deviation)~~ When the average absolute deviation ~~cross-slope~~ is consistently within the acceptance tolerance ~~as shown~~ in Table 330-4, ~~and~~ upon the approval of the Engineer, the ~~frequency of~~ cross slope measurements ~~can~~ *may* be reduced to one measurement every 200 feet ~~during paving operations~~.

2. Superelevated Sections: Measure the cross-slope every 100 feet per lane within the length of the full superelevation. ~~Calculate the absolute deviation of each measurement and then average the absolute deviations of ten consecutive cross-slope measurements.~~ *For curves where the length of full superelevation is less than 250 feet, measure the cross-slope at the beginning point, midpoint, and ending point of the fully superelevated section.* ~~For the transition sections, measure the cross-slope at control points identified in the Plans, or if not shown in the Plans, at a control point at the location of 0.0% cross-slope. and calculate the absolute deviation. For curves where the length of full superelevation is less than 250 feet, measure the cross-slope at the beginning point, midpoint and ending point of the fully superelevated sections, calculate the absolute deviation, and average. When the number of measurements is less than ten and the length of full superelevation is greater than 250 feet, average the absolute deviation of all measurements.~~

330-9.3.2.2 Cross-Slope Deviations and Corrections: ~~Calculate the absolute deviation of each cross-slope measurement and the average of the absolute deviations of ten consecutive cross-slope measurements. (The absolute deviation is the positive value of a deviation).~~ *In superelevated sections, when the number of measurements is less than ten, average the absolute deviation of all measurements.*

If the average absolute deviation of ~~the any~~ cross-slope measurements falls outside the acceptance tolerance, ~~as~~ shown in Table 330-4, stop the paving operation and make adjustments until the problem is resolved to the satisfaction of the Engineer. ~~If an~~

Address, in accordance with 330-9.5, all individual cross-slope deviations ~~individual cross-slope deviation falls outside the acceptance tolerances as shown in Table 330-4, in accordance with 330-9.5. make corrections at no cost to the Department in accordance with 330-9.5 to address the deficient area of the structural course.~~ Complete all corrections before placement of the final pavement surface layer. ~~unless stated otherwise in the Plans, or as determined by the Engineer.~~ For pavement with multiple layers, the deficient areas for the structural course may be left in place, ~~upon the if~~ *approved by* the Engineer. For friction course layers, make corrections in accordance with 330-9.5.

The limits of deficient areas requiring correction may be verified and adjusted with more accurate measurement methods, including survey instruments, upon approval ~~by~~ of the Engineer *and* at no cost to the Department.

Should the Contractor wish to have any *required* corrections waived, submit a request to the Engineer for approval. The Engineer may waive the corrections at no reduction in payment if the deficiencies are sufficiently separated so as not to affect the

pavement's overall traffic safety, surface drainage, ~~and~~ ride quality, *or surface texture characteristics of the pavement and the corrective action would unnecessarily mar the appearance of the finished pavement.*

For intersections, tapers, crossovers, transitions at the beginning and end of the project, bridge approaches and similar areas, adjust the cross-slope to match the actual site conditions, or as directed by the Engineer.

Table 330-4 Cross-Slope <i>Cross-Slope</i> Acceptance Tolerance		
Roadway Feature	Individual Absolute Deviation	Average Absolute Deviation
Tangent section (including turn lanes)	0.4%	0.2%
Superelevated curve	0.4%	0.2%
Shoulder	0.5%	0.5%

In the event ~~that~~ the distance between two edges of deficient areas is less than 100 feet, the correction work shall include the area between the deficient ~~section~~*areas*.

330-9.3.23 Verification: The Engineer will verify the Contractor's cross-slope measurements by randomly taking a minimum of ten cross-slope measurements per lane per mile in tangent sections, *at* control points in transition sections, and a minimum of three cross-slope measurements ~~in~~ fully superelevated sections ~~over a day's production~~.

The Engineer will measure the cross-slope of the compacted pavement surface by placing the level at the center ~~location of~~ *at* the lane and perpendicular to the roadway centerline.

330-9.3.3.1 Cross-Slope Deviations and Corrections: If the average absolute deviation or an individual cross-slope deviation falls outside of the acceptance tolerance ~~as shown~~ in Table 330-4, immediately make a comparison check at the QC test locations to verify the QC measurements in the section. If the comparisons are beyond the acceptable comparison tolerance in accordance with 330-9.3.1, stop the paving operations until the issue is resolved to the satisfaction of the Engineer. Correct any cross slope not meeting the individual deviation acceptance tolerance in accordance with 330-9.5 at no cost to the Department. The Engineer reserves the right to check the pavement cross-slope at any time by taking cross-slope measurements at any location.

330-9.4 Pavement Smoothness: Construct a smooth pavement meeting the requirements of this Specification.

330-9.4.1 General: Furnish a 15 foot manual and a 15 foot rolling straightedge meeting the requirements of FM 5-509. Obtain a smooth surface on all pavement courses placed, and then straightedge all layers as required by this Specification.

330-9.4.2 Test Method: Perform all straightedge testing in accordance with FM 5-509 in the outside wheel path of each lane. The Engineer may require additional testing at other locations within the lane.

330-9.4.3 Traffic Control: Provide traffic control in accordance with Section 102 and the Design Standards Index Nos. 607 or 619 during all testing. When traffic control cannot be provided in accordance with Index Nos. 607 or 619, submit an alternative Traffic Control Plan as specified in 102-4. Include the cost of this traffic control in the Contract bid prices for the asphalt items.

330-9.4.4 Process Control Testing: Assume full responsibility for controlling all paving operations and processes such that the requirements of these Specifications are met at all times.

330-9.4.5 QC Testing:

330-9.4.5.1 General: Straightedge the final Type SP structural layer and friction course layer in accordance with 330-9.4.2, with the exception that if the method of acceptance is by laser profiler, then straightedging of the friction course layer is not required *unless otherwise stated in the Specifications*. Test all pavement lanes and ramps where the width is constant and document all deficiencies in excess of 3/16 inch on a form approved by the Engineer.

330-9.4.5.2 Straightedge Exceptions: Straightedge testing will not be required in the following areas: shoulders, intersections, tapers, crossovers, sidewalks, shared use paths, parking lots and similar areas, or in the following areas when they are less than 250 feet in length: turn lanes, acceleration/deceleration lanes and side streets. The limits of the intersection will be from stop bar to stop bar for both the mainline and side streets.

As an exception, in the event the Engineer identifies an *objectionable* surface irregularity in the above areas ~~that is determined to be objectionable~~, straightedge and address all deficiencies in excess of 3/8 inch in accordance with 330-9.5.

The Engineer may waive straightedge requirements for transverse joints at the beginning and end of the project, at the beginning and end of bridge structures, at manholes, and at utility structures if the deficiencies are caused by factors beyond the control of the Contractor, as determined by the Engineer. In addition, the Engineer may also waive the straightedging requirements on ramps and superelevated sections where the geometrical orientation of the pavement results in an inaccurate measurement with the rolling straightedge.

330-9.4.5.3 Intermediate Layers and Temporary Pavement: When the design speed is 55 mph or greater and the intermediate Type SP layer or temporary pavement is to be opened to traffic, if the Engineer identifies an *objectionable* surface irregularity ~~that is determined to be objectionable~~, straightedge and address all deficiencies in excess of 3/8 inch within 72 hours of placement in accordance with 330-9.5.

330-9.4.5.4 Final Type SP Structural Layer: Straightedge the final Type SP structural layer in accordance with 330-9.4.2, either behind the final roller of the paving train or as a separate operation. Notify the Engineer of the location and time of straightedge testing a minimum of 48 hours before beginning testing. The Engineer will verify the straightedge testing by observing the QC straight edging operations. Address all deficiencies in excess of 3/16 inch in accordance with 330-9.5.

When the final structural course is to be opened to traffic and the design speed is 55 mph or greater, if any defect is 3/8 inch or greater, the Engineer may require deficiencies to be corrected within 72 hours after opening to traffic.

330-9.4.5.5 Friction Course Layer: Where required per 330-9.4.5.1, straightedge the friction course layer in accordance with 330-9.4.2, either behind the final roller of the paving train or as a separate operation upon completion of all paving operations. Notify the Engineer of the location and time of straightedge testing a minimum of 48 hours before beginning testing. The Engineer will verify the straightedge testing by observing the QC straightedging operations. Address all deficiencies in excess of 3/16 inch in accordance with 330-9.5.

330-9.4.6 Acceptance:

330-9.4.6.1 Straightedge Acceptance: For areas of roadways where the design speed is less than 55 miles per hour, acceptance for pavement smoothness of the friction course will be based on verified QC measurements using the straightedge as required by 330-9.4.5. The Engineer will verify the straightedge testing by observing the QC straightedging operations.

330-9.4.6.2 Laser Acceptance: For areas of high speed roadways where the design speed is equal to or greater than 55 miles per hour, acceptance testing for pavement smoothness of the friction course (for mainline traffic lanes only) will be based on the Laser Profiler. Ramps, acceleration and deceleration lanes, and other areas not suitable for testing with the Laser Profiler will be tested and accepted with the straightedge in accordance with 330-9.4.5.5 and 330-9.4.6.1.

The pavement smoothness of each lane will be determined by a Laser Profiler furnished and operated by the Department in accordance with FM 5-549 and a report issued with the Ride Number (RN) reported to one decimal place. If corrections are made, as required following Laser Acceptance, the pavement will not be retested for smoothness using the Laser Profiler.

For this testing, the pavement will be divided into 0.1 mile segments. Partial segments equal to or greater than 0.01 mile will be considered as a 0.1 mile segment. The pavement will be accepted as follows:

1). For segments with a RN greater than or equal to 4.0, the pavement will be accepted at full pay.

2). For segments with a RN less than 4.0, the Engineer will further evaluate the data in 0.01 mile intervals for both wheel paths.

If the RN is 3.5 or above for all 0.01 mile intervals in both wheel paths, the segment will be accepted at full payment.

If the RN is less than 3.5 for one or more 0.01 mile intervals, the segment will be tested with the rolling straightedge in both wheel paths in accordance with FM 5-509. If approved by the Engineer, this straightedging may be completed (in both wheel paths) as part of the QC straightedging operations described in 330-9.4.5.5, ~~prior to~~ before testing with the laser profiler. Notify the Engineer of the location and time of straightedge testing a minimum of 48 hours before beginning testing. The Engineer will verify the straightedge testing by observing the QC straightedging operations. Address all deficiencies in excess of 3/16 inch in accordance with 330-9.5.

Test and accept areas at the beginning and ending of the project, bridge approaches and departures, and areas where the segment is less than 0.01 mile, with the straightedge in accordance with 330-9.4.5.5 and 330-9.4.6.1.

330-9.5 Unacceptable Pavement:

330-9.5.1 Corrections: Address all areas of unacceptable pavement at no cost to the Department. Retest all corrected areas and assure the requirements of these Specifications are met.

330-9.5.1.1 Structural Layers: Correct all deficiencies, as defined in these Specifications, in the Type SP structural layers by removing and replacing the full depth of the layer, extending a minimum of 50 feet on both sides (where possible) of the defective area for the full width of the paving lane.

As an option, for high straightedge deficiencies only, mill the pavement surface the full lane width to a depth and length ~~that is~~ adequate to remove the deficiency. This option only applies if the structural layer is not the final surface layer.

330-9.5.1.2 Friction Course: Correct deficiencies in the friction course or final surface layer by removing and replacing the full depth of the layer, extending a minimum of 50 feet on both sides (where possible) of the defective area for the full width of the paving lane. As an exception, the Engineer may allow the Contractor to leave these areas in place if it is determined by the Engineer that the deficiency is not a significant detriment to the pavement quality. A reduction to the pay item quantity will be made in accordance with 330-9.5.2.

330-9.5.2 Reduction in Pay Item Quantity: When the Engineer elects to waive corrections, the Department will reduce the pay quantity for the pay item in question by the amount of material ~~that~~ the Contractor would have removed and replaced had the correction been made. When the pay quantity is in tons, the Department will base the reduction on the volume of material ~~that~~ the Contractor would have removed (the length by the lane width by layer thickness) multiplied by the maximum specific gravity of the mix as determined through the following equation:

$$\text{Quantity (tons)} = L \times W \times t \times G_{mm} \times 0.0024$$

Where: L = Lane length (ft.)

W = Lane width (ft.)

t = Layer thickness (in.)

G_{mm} = Maximum specific gravity from verified mix design

For FC-5 open-graded friction course, the Department will base the reduction on the area ~~that~~ the Contractor would have removed (the length by lane width) multiplied by a spread rate of 80 lb/yd² as determined through the following equation:

$$\text{Quantity (tons)} = L \times W \times 0.0044$$

Where: L = Lane length (ft.)

W = Lane width (ft.)

330-10 Protection of Finished Surface.

Keep sections of newly compacted asphalt concrete, which are to be covered by additional courses, clean until the successive course is laid.

Do not dump embankment or base material directly on the pavement. Dress shoulders before placing the friction course on adjacent pavement.

Equip blade graders operating adjacent to the pavement during shoulder construction with a 2 inch by 8 inch or larger board, or other attachment providing essentially the same results, attached to their blades ~~in such manner that~~ so it extends below the blade edge ~~in order to~~ and protects the pavement surface from damage by the grader blade.

To prevent rutting or other distortion, protect sections of newly finished dense-graded friction course and the last structural layer ~~prior to~~ before the friction course from traffic until the surface temperature has cooled below 160°F.

The Contractor may use artificial methods to cool the pavement to expedite paving operations. The Department may direct the Contractor to use artificial cooling methods when maintenance of traffic requires opening the pavement to traffic at the earliest possible time.

**HOT MIX ASPHALT – GENERAL CONSTRUCTION REQUIREMENTS.
(REV 8-11-15)**

SECTION 330 is deleted and the following substituted:

**SECTION 330
HOT MIX ASPHALT -
GENERAL CONSTRUCTION REQUIREMENTS**

330-1 Description.

This Section specifies the basic equipment and construction requirements for hot mix asphalt (including warm mix asphalt) pavements and bases. Establish and maintain a quality control system that provides assurance that all materials, products and completed construction submitted for acceptance meet Contract requirements.

330-2 Quality Control (QC) Requirements.

330-2.1 Minimum QC Requirements: Perform as a minimum, the following activities necessary to maintain process control and meet Specification requirements:

1. Pavement Density: Monitor the pavement temperature with an infrared temperature device so compaction is completed before the surface temperature of the pavement drops to the extent that effective compaction may not be achieved or the rollers begin to damage the pavement. Monitor the roadway density with either 6 inch diameter roadway cores, a nuclear density gauge, or other density measuring device, at a minimum frequency of once per 1,500 feet of pavement.

2. Mix Temperature: Determine the mix temperature at the roadway for the first five loads and one out of every five loads thereafter.

3. Mix Spread Rate: Monitor the mix spread rate at the beginning of each day's production, and as needed to control the operations, at a minimum of once per 200 tons placed. When determining the spread rate, use, at a minimum, an average of five truckloads of mix.

4. Pavement Texture: Monitor the pavement texture to minimize pavement segregation. Use density gauges, infrared temperature measurement devices, or roadway cores at the beginning of each day's production, and as necessary, both at truck exchanges and during normal paving operations.

5. Reporting: Ensure the accuracy of the Quality Control Roadway Reports on the Department's approved form to reflect the actual surface area of the finished work and be in compliance with the requirements of the Contract Documents.

330-2.2 Personnel Qualifications: Provide QC Technicians in accordance with Section 105.

330-3 Limitations of Operations.

330-3.1 Weather Limitations: Do not transport asphalt mix from the plant to the roadway unless all weather conditions are suitable for the paving operations.

330-3.2 Limitations of Paving Operations:

330-3.2.1 General: Place the mixture only when the surface upon which it is to be placed has been previously prepared, is intact, firm, dry, clean, and the tack or prime coat,

with acceptable spread rate, is properly broken or cured. Do not place friction course until the adjacent shoulder area has been dressed and grassed.

330-3.2.2 Ambient Air Temperature: Place the mixture only when the air temperature in the shade and away from artificial heat meets requirements of Table 330-1. The minimum ambient temperature requirement may be reduced by 5°F when using warm mix technology, if mutually agreed to by both the Engineer and the Contractor.

Table 330-1	
Ambient Air Temperature Requirements for Paving	
Layer Thickness or Asphalt Binder Type	Minimum Temperature (°F)
≤ 1 inch	50
Any mixture > 1 inch containing a PG asphalt binder with a high temperature designation ≥ 76°C	45
Any mixture > 1 inch containing a PG asphalt binder with a high temperature designation < 76°C	40
FC-5 ⁽¹⁾	65

⁽¹⁾As an exception, place the mixture at temperatures no lower than 60°F, only when approved by the Engineer based on the Contractor's demonstrated ability to achieve a satisfactory surface texture and appearance of the finished surface. The minimum ambient temperature may be further reduced to 55°F when using warm mix technology, if agreed to by both the Engineer and the Contractor.

330-3.2.3 Rain and Surface Conditions: Immediately cease transportation of asphalt mixtures from the plant when rain begins at the roadway. Do not place asphalt mixtures while rain is falling, or when there is water on the surface to be covered. Once the rain has stopped, standing water has been removed from the tacked surface to the satisfaction of the Engineer, and the temperature of the mixture caught in transit still meets the requirements as specified in 320-6.3, the Contractor may then place the mixture caught in transit.

For windrow paving, immediately cease dumping of asphalt material when rain begins at the roadway. Stop paving operations while rain is falling or where there is water on the surface to be covered. Remove windrowed asphalt mixture exposed to rain. Once the rain has stopped, standing water has been removed from the tacked surface to the satisfaction of the Engineer, and the temperature of the mixture caught in transit still meets the requirements as specified in 320-6.3, the Contractor may then windrow the remaining material caught in transit.

330-3.2.4 Wind: Do not place the mixture when the wind is blowing to such an extent that proper and adequate compaction cannot be maintained or when sand, dust, etc., are being deposited on the surface being paved to the extent the bond between layers will be diminished.

330-4 Surface Preparation.

330-4.1 Cleaning: Before placing the mixture, clean the surface of the base or underlying pavement of all loose and deleterious material by the use of power brooms or blowers, supplemented by hand brooming where necessary.

330-4.1.1 Application over Asphalt Rubber Membrane Interlayer (ARMI): Where an asphalt mix is to be placed over a newly constructed ARMI, do not sweep or otherwise disturb the cover material before placing the asphalt mix, unless directed by the Engineer.

330-4.2 Tacking: Apply a tack coat on all existing pavement surfaces that are to be overlaid with an asphalt mix as specified in Section 300 and between successive layers of all asphalt mixes. Apply tack on a clean surface.

Do not place tack while rain is falling or when there is water on the surface to be tacked. Once the rain has stopped, standing water has been removed from the surface to be tacked to the satisfaction of the Engineer, the Contractor may then apply tack.

Apply a tack coat on freshly primed bases only when directed by the Engineer.

330-5 Paving Equipment.

330-5.1 General Requirements: Use mechanically-sound equipment capable of consistently meeting Specification requirements.

330-5.2 Asphalt Paver:

330-5.2.1 General: Provide a self-propelled, asphalt paver that can be steered, and is equipped with a receiving and distribution hopper and a mechanical screed. Use a mechanical screed capable of adjustment to regulate the depth of material spread and to produce the desired cross-section.

When asphalt mix is placed in windrows, operate windrow pickup equipment so substantially all of the mixture deposited on the roadbed is picked up and loaded into the paver. Prevent the windrow pickup equipment from contaminating the mixture.

330-5.2.2 Automatic Screed Control: For all asphalt courses placed with an asphalt paver, equip the paver with automatic longitudinal screed controls of either the skid type, traveling stringline type, or non-contact averaging ski type with a minimum length of 25 feet. On the final layer of asphalt base, overbuild, structural courses, and friction courses, use the joint matcher instead of the skid, traveling stringline, or non-contact averaging ski on all passes after the initial pass. Equip the asphalt paver with electronic cross-slope controls.

330-5.2.3 Screed Width: Provide an asphalt paver with a screed width greater than 8 feet when required to pave full width lanes. Do not use extendable screed strike-off devices that do not provide preliminary compaction of the mat in place of fixed screed extensions. Use a strike-off device only on irregular areas that would normally be done by hand and on shoulders 5 feet or less in width. When using the strike-off device on shoulders, instead of an adjustable screed extension, demonstrate the ability to obtain acceptable texture, density, and thickness.

When using an extendable screed device to extend the screed's width on the full width lane or shoulder by 24 inches or greater, the Engineer will require an auger extension, paddle, or kicker device unless written documentation from the manufacturer is provided stating these are not necessary.

330-5.3 Rollers:

330-5.3.1 Steel-Wheeled Rollers: Provide compaction equipment capable of meeting the density requirements described in these Specifications. When density testing is not required, and the standard rolling pattern is used, provide a tandem steel-wheeled roller weighing 5 to 15 tons for breakdown rolling. For finish rolling, use a separate roller weighing 5 to 15 tons. Variations from these requirements shall be approved by the Engineer.

330-5.3.2 Traffic Rollers: Provide compaction equipment capable of meeting the density requirements described in the Specifications. When density testing is not required, and the standard rolling pattern is used, provide a self-propelled, pneumatic-tired traffic roller equipped with at least seven smooth-tread, low pressure tires, equipped with pads or scrapers on each tire. Maintain the tire pressure between 50 and 55 psi or as specified by the manufacturer.

Use rollers with a minimum weight of 6 tons. Do not use wobble-wheeled rollers. Variations from these requirements shall be approved by the Engineer.

330-5.3.3 Prevention of Adhesion: Do not allow the mixture to adhere to the wheels of any rollers. Do not use fuel oil or other petroleum distillates to prevent adhesion. Do not use any method which results in water being sprinkled directly onto the mixture.

330-5.4 Coring Equipment: Furnish a suitable saw or drill for obtaining the required density cores.

330-5.5 Hand Tools: Provide the necessary hand tools such as rakes, shovels, and other similar tools, and a suitable means for keeping them clean. Do not use diesel fuel or other petroleum-based solvents contained in an open container for cleaning purposes on the paver.

330-6 Placing Mixture.

330-6.1 Requirements Applicable to All Pavement Types:

330-6.1.1 Alignment of Edges: Place all asphalt mixtures by the stringline method to obtain an accurate, uniform alignment of the pavement edge. As an exception, pavement edges adjacent to curb and gutter or other true edges do not require a stringline. Control the unsupported pavement edge to ensure it will not deviate from the stringline more than plus or minus 1.5 inches.

330-6.1.2 Paving Width: If necessary due to the traffic requirements, place the mixture in strips in such a manner as to provide for the passage of traffic. As an option, where the road is closed to traffic, place the mixture to the full width with machines traveling in echelon.

330-6.1.3 Mix Temperature: Maintain the mix temperature at the time of paving within the master range as defined in 320-6.3. Take mix temperatures on the roadway at the minimum frequency indicated in 320-6.3. Any load, or portion of a load, of asphalt mix on the roadway with a temperature outside of the master range shall be rejected for use on the project. Immediately notify the Engineer of the rejection.

Remove any windrow material not meeting the temperature requirements of 320-6.3.2 from the area of deficient temperature and replace with new asphalt meeting the temperature requirements.

330-6.1.4 Speed of Paver: Establish the forward speed of the asphalt paver based on the rate of delivery of the mix to the roadway, but not faster than the optimum speed needed to adequately compact the pavement.

330-6.1.5 Thickness and Spread Rate of Layers: Construct each layer as defined in the following table:

Table 330-2	
Thickness and Target Spread Rate Requirements	
Mix Type	Specification Section and Article
Type SP	334-1
Type FC	337-8
Type B	234-8
ATPB	287-8

330-6.1.5.1 Thickness Control: Ensure the spread rate is within plus or minus 5% of the target spread rate. When determining the spread rate, use, at a minimum, an

average of five truckloads of mix and at a maximum, an average of 10 truckloads of mix, except for windrow paving, use an average of three truckloads of mix. When the average spread rate is beyond plus or minus 5% of the target spread rate, monitor the thickness of the pavement layer closely and adjust the construction operations.

When the average spread rate for two consecutive days is beyond plus or minus 5% of the target spread rate, stop the construction operation until the issue is resolved.

330-6.1.5.2 Maximum Spread Rate Tolerances: When an individual spread rate, measured in accordance with 330-6.1.5.1, is beyond plus or minus 20% of the target spread rate, stop the construction operation until the issue is resolved. Address the unacceptable pavement in accordance with 330-9.5. The following areas are exempt from a work stoppage based solely on the calculated spread rate: median crossovers, turnouts, variable thickness overbuild courses, leveling courses, miscellaneous asphalt pavement, as well as, turn lanes and ramps less than 1,000 feet.

As an exception, the Engineer may allow the Contractor to leave areas in place if it is determined by the Engineer that the deficiency is not a significant detriment to the pavement quality. For areas of deficient thickness, a reduction to the pay item quantity will be made in accordance with 330-9.5.2.

330-6.1.6 Correcting Defects: Before starting any rolling, check the surface; correct any irregularities; remove all drippings, sand accumulations from the screed, and fat spots from any source; and replace them with satisfactory material. Do not skin patch. When correcting a depression while the mixture is hot, scarify the surface and add fresh mixture.

330-6.1.7 Hand Work: In limited areas where the use of the paver is impossible or impracticable, the Contractor may place and finish the mixture by hand.

330-7 Compacting Mixture.

330-7.1 General Requirements: When density testing for acceptance is required, select equipment, sequence, and coverage (number of times the roller passes over a given area of pavement) of rolling to meet the specified density requirement. Regardless of the rolling procedure used, complete the final rolling before the surface temperature of the pavement drops to the extent effective compaction may not be achieved or the rollers begin to damage the pavement.

No vibratory compaction in the vertical direction will be allowed for layers one inch or less in thickness or, if the Engineer or Contract Documents limit compaction to the static mode only. Compact these layers in the static mode only. Other non-vertical vibratory modes of compaction will be allowed, if approved by the Engineer, however, no additional compensation, cost or time, will be made.

330-7.2 Standard Rolling Procedure: When density testing for acceptance is not required, propose an alternative rolling pattern to be approved by the Engineer or use the following standard rolling procedure:

1. Breakdown rolling: Provide two static coverages with a tandem steel-wheeled roller, following as close behind the paver as possible without pick-up, undue displacement, or blistering of the mix.

2. Intermediate rolling: Provide five static coverages with a pneumatic-tire roller, following as close behind the breakdown rolling operation as the mix will permit.

3. Finish rolling: Provide one static coverage with a tandem steel-wheeled roller, after completing the breakdown rolling and intermediate rolling, but before the surface pavement

temperature drops to the extent effective compaction may not be achieved or the rollers begin to damage the pavement.

330-7.3 Rolling Procedures: Use procedures that will uniformly compact the pavement layer to the desired density level, while meeting the appropriate smoothness requirements, without damaging the pavement surface, crushing aggregate or leaving excessive roller marks, roller heads, or ripples. While rolling is in progress, monitor the surface continuously, and adjust the compaction operations to comply with the surface requirements.

330-7.4 Compaction of Areas Inaccessible to Rollers: Use hand tamps or other satisfactory means to compact areas which are inaccessible to a roller, such as areas adjacent to curbs, gutters, bridges, manholes, etc.

330-7.5 Correcting Defects: Do not allow the compaction equipment to deposit contaminants onto the pavement surface. Remove and replace any areas damaged by such deposits as directed by the Engineer. Correct any depressions that develop before completing the rolling by loosening the mixture and adding new mixture to bring the depressions to a true surface. Should any depression remain after obtaining the final compaction, remove the full depth of the mixture, and replace it with enough new mixture to form a true and even surface. Correct all defects before laying the subsequent course.

330-7.6 Use of Traffic Roller: Use a traffic roller on the first overbuild course. Use a traffic roller or vibratory roller (unless restricted by the Contract Documents) on the first structural layer placed on an ARMI.

330-7.7 Compaction at Bridge Structures: Compact asphalt mixtures placed over bridge decks and approach slabs using static compaction only. Use the standard rolling procedure described in 330-7.2 or an alternative procedure approved by the Engineer.

330-8 Joints.

330-8.1 General: When laying fresh mixture against the exposed edges of joints, place it in close contact with the exposed edge to produce an even, well-compacted joint after rolling.

330-8.2 Transverse Joints: Place the mixture as continuously as possible to minimize transverse joints. When constructing permanent transverse joints, meet the surface requirements as defined in 330-9. Construct temporary transverse joints in such a manner to allow traffic to pass over it. When resuming the paving operation, construct a transverse joint by cutting back on the previously placed pavement at a location where the straightedge requirements are met. At the project limits, tie into the adjoining pavement layers as shown in the Plans.

330-8.3 Longitudinal Joints: Place each layer of pavement so all longitudinal construction joints are offset 6 to 12 inches laterally between successive layers. Plan offsets in advance so the longitudinal joints of the friction course are not in wheel path areas. The longitudinal joints for friction course layers should be within 6 inches of the lane edge or at the center of the lane. The Engineer may waive this requirement where offsetting is not feasible due to the sequence of construction.

330-8.4 Placing Asphalt Next to Concrete Pavement: When placing asphalt next to concrete pavement, construct the joint as shown in the Plans.

330-9 Surface Requirements.

330-9.1 General: Construct a smooth pavement with good surface texture and the proper cross-slope.

330-9.2 Texture of the Finished Surface of Paving Layers: Produce a finished surface of uniform texture and compaction with no pulled, torn, raveled, crushed or loosened portions

and free of segregation, bleeding, flushing, sand streaks, sand spots, or ripples. Some examples of pavement deficiencies are displayed at the following URL:

<http://www.dot.state.fl.us/ProgramManagement/Implemented/URLinSpecs/Pavement.shtm>.

Address any pavement not meeting the requirements of this specification in accordance with 330-9.5.

For dense-graded structural and friction course mixtures, in areas not defined as density testing exceptions per 334-5.1.2, obtain for the Engineer three 6 inch diameter roadway cores at locations visually identified by the Engineer to be segregated. The Engineer will determine the density of each core in accordance with FM 1-T 166 and calculate the percent G_{mm} of the segregated area using the average G_{mb} of the roadway cores and the QC subplot G_{mm} for the questionable material. If the average percent G_{mm} is less than 89.5, address the segregated area in accordance with 330-9.5.

Do not use asphalt concrete mixtures containing aggregates that cause a different color appearance in the final wearing surface unless the section is greater than or equal to one mile in length and across the full width of the pavement, including shoulders and turn lanes. Exceptions to these requirements will be permitted if approved by the Engineer.

330-9.3 Cross-Slope: Construct a pavement surface with cross-slopes in compliance with the requirements of the Contract Documents. Furnish a 4 foot long electronic level accurate to 0.1 degree, approved by the Engineer for the control of cross-slope. Make this electronic level available at the jobsite at all times during paving operations.

330-9.3.1 QC Calibration and Comparison: Calibrate the electronic levels a minimum of once per day before paving operations begin, in accordance with manufacturer's instructions.

Compare the QC level with the Verification level before paving operations begin, and at any time as directed. If the comparison between the QC and Verification levels is within plus or minus 0.2%, the QC level is considered to compare favorably and can be used for measurement and acceptance of cross-slopes. If the levels do not compare favorably, perform a second comparison using another calibrated electronic level (FDOT or Contractor) for resolution. If the resolution level compares favorably with the QC level, the QC level is considered to be verified. If the resolution level does not compare favorably with the QC level, discontinue the use of the QC electronic level and obtain another approved electronic level that meets the requirements of this specification. The Contractor assumes all risk associated with placing the pavement at the correct cross-slope.

330-9.3.2 Cross-Slope Measurement: Measure the cross-slope of the compacted pavement surface by placing the level at the center of the lane and perpendicular to the roadway centerline. Record all measurements to the nearest 0.1% on an approved form and submit the data to the Engineer.

330-9.3.2.1 Cross-Slope Measurement Frequency:

1. Tangent Sections: Measure the cross-slope at a minimum frequency of one measurement every 100 feet per lane. When the average absolute deviation is consistently within the acceptance tolerance in Table 330-4, upon the approval of the Engineer, the cross slope measurements may be reduced to one measurement every 200 feet.

2. Superelevated Sections: Measure the cross-slope every 100 feet per lane within the length of the full superelevation. For curves where the length of full superelevation is less than 250 feet, measure the cross-slope at the beginning point, midpoint, and ending point of the fully superelevated section. For transition sections, measure the cross-

slope at control points identified in the Plans, or if not shown in the Plans, at a control point at the location of 0.0% cross-slope.

330-9.3.2.2 Cross-Slope Deviations and Corrections: Calculate the absolute deviation of each cross-slope measurement and the average of the absolute deviations of ten consecutive cross-slope measurements. The absolute deviation is the positive value of a deviation. In superelevated sections, when the number of measurements is less than ten, average the absolute deviation of all measurements.

If the average absolute deviation of any cross-slope measurement falls outside the acceptance tolerance shown in Table 330-4, stop the paving operation and make adjustments until the problem is resolved to the satisfaction of the Engineer.

Address, in accordance with 330-9.5, all individual cross-slope deviations outside the acceptance tolerances shown in Table 330-4. Complete all corrections before placement of the final pavement surface layer. For pavement with multiple layers, the deficient areas for the structural course may be left in place, if approved by the Engineer. For friction course layers, make corrections in accordance with 330-9.5.

The limits of deficient areas requiring correction may be verified and adjusted with more accurate measurement methods, including survey instruments, upon approval of the Engineer and at no cost to the Department.

Should the Contractor wish to have any required corrections waived, submit a request to the Engineer for approval. The Engineer may waive the corrections at no reduction in payment if the deficiencies are sufficiently separated so as not to affect the pavement's overall traffic safety, surface drainage, ride quality, or surface texture.

For intersections, tapers, crossovers, transitions at the beginning and end of the project, bridge approaches and similar areas, adjust the cross-slope to match the actual site conditions or as directed by the Engineer.

Table 330-4 Cross-Slope Acceptance Tolerance		
Roadway Feature	Individual Absolute Deviation	Average Absolute Deviation
Tangent section (including turn lanes)	0.4%	0.2%
Superelevated curve	0.4%	0.2%
Shoulder	0.5%	0.5%

In the event the distance between two edges of deficient areas is less than 100 feet, the correction work shall include the area between the deficient areas.

330-9.3.3 Verification: The Engineer will verify the Contractor's cross-slope measurements by randomly taking a minimum of ten cross-slope measurements per lane per mile in tangent sections, at control points in transition sections, and a minimum of three cross-slope measurements in fully superelevated sections.

The Engineer will measure the cross-slope of the compacted pavement surface by placing the level at the center of the lane and perpendicular to the roadway centerline.

330-9.3.3.1 Cross-Slope Deviations and Corrections: If the average absolute deviation or an individual cross-slope deviation falls outside of the acceptance tolerance in Table 330-4, immediately make a comparison check at the QC test locations to verify the QC

measurements in the section. If the comparisons are beyond the acceptable comparison tolerance in accordance with 330-9.3.1, stop the paving operations until the issue is resolved to the satisfaction of the Engineer. Correct any cross slope not meeting the individual deviation acceptance tolerance in accordance with 330-9.5 at no cost to the Department. The Engineer reserves the right to check the pavement cross-slope at any time by taking cross-slope measurements at any location.

330-9.4 Pavement Smoothness: Construct a smooth pavement meeting the requirements of this Specification.

330-9.4.1 General: Furnish a 15 foot manual and a 15 foot rolling straightedge meeting the requirements of FM 5-509. Obtain a smooth surface on all pavement courses placed, and then straightedge all layers as required by this Specification.

330-9.4.2 Test Method: Perform all straightedge testing in accordance with FM 5-509 in the outside wheel path of each lane. The Engineer may require additional testing at other locations within the lane.

330-9.4.3 Traffic Control: Provide traffic control in accordance with Section 102 and the Design Standards Index Nos. 607 or 619 during all testing. When traffic control cannot be provided in accordance with Index Nos. 607 or 619, submit an alternative Traffic Control Plan as specified in 102-4. Include the cost of this traffic control in the Contract bid prices for the asphalt items.

330-9.4.4 Process Control Testing: Assume full responsibility for controlling all paving operations and processes such that the requirements of these Specifications are met at all times.

330-9.4.5 QC Testing:

330-9.4.5.1 General: Straightedge the final Type SP structural layer and friction course layer in accordance with 330-9.4.2, with the exception that if the method of acceptance is by laser profiler, then straightedging of the friction course layer is not required unless otherwise stated in the Specifications. Test all pavement lanes and ramps where the width is constant and document all deficiencies in excess of 3/16 inch on a form approved by the Engineer.

330-9.4.5.2 Straightedge Exceptions: Straightedge testing will not be required in the following areas: shoulders, intersections, tapers, crossovers, sidewalks, shared use paths, parking lots and similar areas, or in the following areas when they are less than 250 feet in length: turn lanes, acceleration/deceleration lanes and side streets. The limits of the intersection will be from stop bar to stop bar for both the mainline and side streets.

As an exception, in the event the Engineer identifies an objectionable surface irregularity in the above areas, straightedge and address all deficiencies in excess of 3/8 inch in accordance with 330-9.5.

The Engineer may waive straightedge requirements for transverse joints at the beginning and end of the project, at the beginning and end of bridge structures, at manholes, and at utility structures if the deficiencies are caused by factors beyond the control of the Contractor, as determined by the Engineer. In addition, the Engineer may also waive the straightedging requirements on ramps and superelevated sections where the geometrical orientation of the pavement results in an inaccurate measurement with the rolling straightedge.

330-9.4.5.3 Intermediate Layers and Temporary Pavement: When the design speed is 55 mph or greater and the intermediate Type SP layer or temporary pavement is to be opened to traffic, if the Engineer identifies an objectionable surface irregularity,

straightedge and address all deficiencies in excess of 3/8 inch within 72 hours of placement in accordance with 330-9.5.

330-9.4.5.4 Final Type SP Structural Layer: Straightedge the final Type SP structural layer in accordance with 330-9.4.2, either behind the final roller of the paving train or as a separate operation. Notify the Engineer of the location and time of straightedge testing a minimum of 48 hours before beginning testing. The Engineer will verify the straightedge testing by observing the QC straight edging operations. Address all deficiencies in excess of 3/16 inch in accordance with 330-9.5.

When the final structural course is to be opened to traffic and the design speed is 55 mph or greater, if any defect is 3/8 inch or greater, the Engineer may require deficiencies to be corrected within 72 hours after opening to traffic.

330-9.4.5.5 Friction Course Layer: Where required per 330-9.4.5.1, straightedge the friction course layer in accordance with 330-9.4.2, either behind the final roller of the paving train or as a separate operation upon completion of all paving operations. Notify the Engineer of the location and time of straightedge testing a minimum of 48 hours before beginning testing. The Engineer will verify the straightedge testing by observing the QC straightedging operations. Address all deficiencies in excess of 3/16 inch in accordance with 330-9.5.

330-9.4.6 Acceptance:

330-9.4.6.1 Straightedge Acceptance: For areas of roadways where the design speed is less than 55 miles per hour, acceptance for pavement smoothness of the friction course will be based on verified QC measurements using the straightedge as required by 330-9.4.5. The Engineer will verify the straightedge testing by observing the QC straightedging operations.

330-9.4.6.2 Laser Acceptance: For areas of high speed roadways where the design speed is equal to or greater than 55 miles per hour, acceptance testing for pavement smoothness of the friction course (for mainline traffic lanes only) will be based on the Laser Profiler. Ramps, acceleration and deceleration lanes, and other areas not suitable for testing with the Laser Profiler will be tested and accepted with the straightedge in accordance with 330-9.4.5.5 and 330-9.4.6.1.

The pavement smoothness of each lane will be determined by a Laser Profiler furnished and operated by the Department in accordance with FM 5-549 and a report issued with the Ride Number (RN) reported to one decimal place. If corrections are made, as required following Laser Acceptance, the pavement will not be retested for smoothness using the Laser Profiler.

For this testing, the pavement will be divided into 0.1 mile segments. Partial segments equal to or greater than 0.01 mile will be considered as a 0.1 mile segment. The pavement will be accepted as follows:

1. For segments with a RN greater than or equal to 4.0, the pavement will be accepted at full pay.
2. For segments with a RN less than 4.0, the Engineer will further evaluate the data in 0.01 mile intervals for both wheel paths.

If the RN is 3.5 or above for all 0.01 mile intervals in both wheel paths, the segment will be accepted at full payment.

If the RN is less than 3.5 for one or more 0.01 mile intervals, the segment will be tested with the rolling straightedge in both wheel paths in

accordance with FM 5-509. If approved by the Engineer, this straightedging may be completed (in both wheel paths) as part of the QC straightedging operations described in 330-9.4.5.5, before testing with the laser profiler. Notify the Engineer of the location and time of straightedge testing a minimum of 48 hours before beginning testing. The Engineer will verify the straightedge testing by observing the QC straightedging operations. Address all deficiencies in excess of 3/16 inch in accordance with 330-9.5.

Test and accept areas at the beginning and ending of the project, bridge approaches and departures, and areas where the segment is less than 0.01 mile, with the straightedge in accordance with 330-9.4.5.5 and 330-9.4.6.1.

330-9.5 Unacceptable Pavement:

330-9.5.1 Corrections: Address all areas of unacceptable pavement at no cost to the Department. Retest all corrected areas and assure the requirements of these Specifications are met.

330-9.5.1.1 Structural Layers: Correct all deficiencies, as defined in these Specifications, in the Type SP structural layers by removing and replacing the full depth of the layer, extending a minimum of 50 feet on both sides (where possible) of the defective area for the full width of the paving lane.

As an option, for high straightedge deficiencies only, mill the pavement surface the full lane width to a depth and length adequate to remove the deficiency. This option only applies if the structural layer is not the final surface layer.

330-9.5.1.2 Friction Course: Correct deficiencies in the friction course or final surface layer by removing and replacing the full depth of the layer, extending a minimum of 50 feet on both sides (where possible) of the defective area for the full width of the paving lane. As an exception, the Engineer may allow the Contractor to leave these areas in place if it is determined by the Engineer that the deficiency is not a significant detriment to the pavement quality. A reduction to the pay item quantity will be made in accordance with 330-9.5.2.

330-9.5.2 Reduction in Pay Item Quantity: When the Engineer elects to waive corrections, the Department will reduce the pay quantity for the pay item in question by the amount of material the Contractor would have removed and replaced had the correction been made. When the pay quantity is in tons, the Department will base the reduction on the volume of material the Contractor would have removed (the length by the lane width by layer thickness) multiplied by the maximum specific gravity of the mix as determined through the following equation:

$$\text{Quantity (tons)} = L \times W \times t \times G_{mm} \times 0.0024$$

Where: L = Lane length (ft.)

W = Lane width (ft.)

t = Layer thickness (in.)

G_{mm} = Maximum specific gravity from verified mix design

For FC-5 open-graded friction course, the Department will base the reduction on the area the Contractor would have removed (the length by lane width) multiplied by a spread rate of 80 lb/yd² as determined through the following equation:

$$\text{Quantity (tons)} = L \times W \times 0.0044$$

Where: L = Lane length (ft.)

W = Lane width (ft.)

330-10 Protection of Finished Surface.

Keep sections of newly compacted asphalt concrete, which are to be covered by additional courses, clean until the successive course is laid.

Do not dump embankment or base material directly on the pavement. Dress shoulders before placing the friction course on adjacent pavement.

Equip blade graders operating adjacent to the pavement during shoulder construction with a 2 inch by 8 inch or larger board, or other attachment providing essentially the same results, attached to their blades so it extends below the blade edge and protects the pavement surface from damage by the grader blade.

To prevent rutting or other distortion, protect sections of newly finished dense-graded friction course and the last structural layer before friction course from traffic until the surface temperature has cooled below 160°F.

The Contractor may use artificial methods to cool the pavement to expedite paving operations. The Department may direct the Contractor to use artificial cooling methods when maintenance of traffic requires opening the pavement to traffic at the earliest possible time.