



Wisconsin Department of Transportation

January 12, 2015

**Division of Transportation Systems
Development**

Bureau of Project Development
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NOTICE TO ALL CONTRACTORS:

**Proposal #06: 1100-20-60
Zoo Freeway
Burleigh Street to Good Hope Road
USH 45
Milwaukee County**

Letting of January 13, 2015

This is Addendum No. 2, which provides for the following:

Special Provisions

Revised Special Provisions	
Article No.	Description
64	High Friction Surface Treatment Asphalt, Item SPV.0180.01.

The responsibility for notifying potential subcontractors and suppliers of these changes remains with the prime contractor.

Sincerely,

Mike Coleman

Proposal Development Specialist
Proposal Management Section

ADDENDUM NO. 2

1100-20-60

January 12, 2015

Special Provisions

64. High Friction Surface Treatment Asphalt, Item SPV.0180.01.

Remove entire article language and replace with the following:

A Description

This special provision describes providing a high friction surface treatment (HFST) composed of aggregate in a resin binder on HMA or concrete pavements.

B Materials

B.1 Resin Binder

Supply a two-part thermosetting resin binder which is compatible with the pavement type, bonds to the pavement surface, holds the aggregate firmly in place in a broad range of climates including below-freezing temperatures, and meets the requirements specified in Table 1. Supply a primer if recommended by the resin binder manufacturer.

Table 1. Resin Binder Properties

Property	Requirements	Test Method*
Viscosity	7 – 30 poises	ASTM D2556 1-pint specimen
Gel Time	10-minute minimum	ASTM C881 60g mass
Ultimate Tensile Strength	2,000 – 5,000 psi @ 7 days	ASTM D638 Type 1 specimen
Elongation at Break	30% - 70% @ 7 days	ASTM D638 Type 1 specimen
Compressive Strength	≥ 1000 psi @ 3 hrs & ≥ 5000 psi @ 24 hours	ASTM D695**
Water Absorption	≤ 1.0 % @ 24-hr	ASTM D570 24-hr immersion
Shore D Hardness	60 – 80 @ 7 days	ASTM D2240*** Type 1 precision, Type D method
Cure Rate	≤ 3 hours (Dry Through Time)	ASTM D1640 50-55 wet mil thickness***
Adhesive Strength	250 psi @ 24 hours or 100% substrate failure	ASTM C1583***

* Prepare samples per manufacturer's recommendations; cure all specimens at 73 ± 2° F and at 50 ± 2° F; and test all specimens at 73 ± 2° F

** 2" x 2" cubes made of 2.75 parts of 20-30 mesh sand to 1 part mixed resin binder; use plastic inserts in oversized molds to produce 2" cubes

*** Conduct testing on applicable pavement type

B.2 Aggregate

Furnish natural or synthetic aggregate that has a proven record of performance in applications of this type. Industrial by-products shall conform to category 1 or 2 under NR 538.08 of the Wisconsin Administrative Code. If using steel slag, the CaO and MgO contents shall be less than 0.6 percent.

Furnish aggregate that is fractured or angular in shape; resistant to polishing and crushing; clean and free of surface moisture; free from silt, clay, asphalt, or other organic materials; compatible with the resin binder; and meet the properties and gradation requirements in Tables 2 and 3. Check with resin binder manufacturer for any compatibility requirements or concerns.

Table 2. Aggregate Properties

Property	Requirements	Test Method
Moisture Content	≤ 0.2%	AASHTO T 255
Fine Aggregate Angularity	≥ 45%	AASHTO T 304, Method A
Micro-Deval	≤ 15% loss	ASTM D7428
LA Wear	≤ 10% loss @ 100 revolutions and ≤ 25% loss @ 500 revolutions	AASHTO T 96
Freeze-Thaw Soundness	≤ 9% loss @ 50, 16, or 25 cycles using Procedure A, B, or C, respectively	AASHTO T 103

Table 3. Aggregate Gradation (AASHTO T27)

Sieve Size	% Passing by Weight
No. 4	100
No. 6	95 - 100
No. 16	0-5
No. 30	0-1

B.3 Approval of High Friction Surface Treatment

A minimum of 20 working days before applying HFST, submit product data sheets and specifications from the manufacturer, and a certified test report from an independent laboratory verifying that the resin binder and the aggregate meet all the requirements specified in Tables 1, 2 and 3. Documents must be dated within three years.

If resin binder has not been previously used in Wisconsin, also submit a list of at least five reference projects where the resin binder has been used for similar applications and in locations that have similar climatic conditions as Wisconsin. Supply a description of the projects along with contact information of the facility owner.

If the engineer requests, provide samples of the resin binder and the aggregate for department testing before applying HFST.

If using industrial by-products as aggregate, submit a certificate of compliance certifying which category the material conforms to under NR 538.08 of the Wisconsin Administrative Code. If using steel slag as aggregate, also provide documentation verifying that the CaO and MgO contents are less than 0.6 percent.

C Construction

C.1 General

The contractor will provide documentation showing HFST application experience from at least three previous projects completed for WisDOT or other agencies.

Conduct a meeting with the resin binder manufacturer representative before applying HFST to establish procedures for maintaining optimum working conditions and coordination of the work. Submit recommended application procedures, including quality control practices, to the engineer for approval. Ensure that a resin binder manufacturer representative is on site to provide technical assistance and quality assurance during surface preparation and for application of HFST.

Ensure that the resin binder components maintain their original properties during storage and handling. Store all aggregate in a dry environment and protect from contaminants on the job site.

C.2 Pavement Surface Preparation

C.2.1. Pavement Surface Repair

Remove visibly unsound or disintegrated areas of the pavement surface as the plans show or the engineer directs.

Check with resin binder manufacturer to ensure that products used for pavement repairs or patches are compatible with the HFST materials. Ensure that any new concrete or repairs are fully cured before placing the HFST.

C.2.2 Surface Preparation

Cover and protect utilities, drainage structures, expansion joints on bridge decks, and other structures within or adjacent to the application location to prevent materials from adhering to or entering those structures.

Remove pavement markings that are within the treatment area. Cover existing pavement markings adjacent to the application if they are to remain in place.

Seal all joints and cracks, or any portion of cracks, that are greater than 1/4 inch wide, with a joint sealant conforming to ASTM D6690. Apply sealant flush with, or just below, the pavement surface. Do not overfill and ensure excess joint sealant is not visible on the pavement surface.

After all pavement repairs or patches have completely cured, and no more than 24 hours before HFST application, prepare a concrete pavement surface by shot blasting to roughen the surface texture. Ensure the pavement surface has no grease, oil, curing compound, loosely bonded mortar, pavement marking, or other foreign matter resting on the pavement surface.

Completely remove any grease, oil, pavement marking, or other foreign matter resting on an HMA pavement surface that could prevent proper bonding of the resin binder by shot blasting. Shot blast entire HMA pavement surfaces that are less than 30 days old prior to cleaning and installing HFST.

Sufficiently clean HMA and concrete pavement surfaces by vacuum-sweeping and blowing, with oil-free compressed air, just before applying HFST. Compressors must be equipped with functioning oil/water separators. Cleaning must be done the same day that HFST will be applied. Ensure the surface is clean, completely dry, and free of all dust, oil, debris and other material that might interfere with the bond between the resin binder and the existing pavement surface.

If the engineer requires additional verification of adequate surface preparation of the pavement, test the bond strength according to ASTM C1583. The surface is acceptable if the tensile bond strength is greater than or equal to 250 psi, or failure is in the substrate. Repeat shot blasting, cleaning, and testing, if needed, until passing test results are obtained or the surface is acceptable to the engineer.

Keep vehicles and unnecessary equipment off the cleaned surface; only allow HFST application equipment on the clean surface. Apply HFST as soon as possible after pavement surface preparations are completed.

Abide by the established quality control practices and adhere to any additional manufacturer recommendations for surface preparation. Request that the engineer inspect and approve the pavement surface immediately prior to placing the HFST.

C.3 Application of the HFST

Do not apply the HFST if any of the following exists:

- Pavement surface is wet, damp, or has received rainfall in the previous 24 hours.
- Pavement surface is not sufficiently clean.
- Ambient air or pavement surface temperature is below 50⁰ F or below the manufacturer's recommendations
- If the anticipated weather conditions would prevent adequate curing of the HFST.
- Rain is predicted before HFST completion or proper cure is achieved.
- Pavement preparation is inadequate or didn't pass pull-off test.

Close treatment areas to traffic until HFST is completely cured and pavement surface has been vacuum-swept.

Construct HFST to the full width of the existing pavement surface, or as the plans show or engineer directs. Extend the HFST application 2'-3' into the shoulders if application site is on a curve, Apply as a single layer 1/8 inch to 1/4 inch thick.

Apply a primer to the pavement surface if recommended by the resin binder manufacturer, and according to their application recommendations. Abide by the established quality control practices and adhere to any additional manufacturer or engineer recommendations for HFST application.

Blend and mix the resin binder components at the manufacturer's specified ratio using equipment capable of providing the desired results.

Apply the resin binder uniformly over the pavement surface manually or with automated equipment at a uniform minimum thickness of 50-65 mils (25-32 ft²/gal). Use enough resin to cover the pavement surface and sufficiently embed half the thickness of the aggregate; do not apply so much that it covers the aggregate and creates a slick surface. Adjust application rate, as needed, based on the pavement surface type, profile, and condition.

If using automated equipment, ensure that the equipment features positive displacement, volumetric metering, and is capable of storing, mixing, heating, monitoring, and distributing the binder components at the proper mix ratio and a uniform thickness. Adjust the pressure and the speed of the equipment to achieve the proper application thickness. If applying the binder by hand, use a serrated edged squeegee to spread the resin binder and provide uniform coverage at the proper thickness.

Do not contaminate the wet binder or allow the binder material to separate or cure, and impair bonding of the aggregate.

Immediately after applying the resin binder, distribute a sufficient quantity of dry aggregate to completely cover the resin binder by hand broadcasting or by using a standard chip spreader or equivalent machine. Ensure aggregate is placed within five minutes of the resin binder placement, before it begins to cure. When broadcasting, sprinkle or drop the aggregate onto the resin binder vertically. Do not distribute aggregate in a way that will cause it to roll in the resin binder before coming to a rest; do not push the aggregate into position with a broom or any other hand tool. If using a chip spreader, the machine shall follow closely behind the crew or equipment applying the resin binder. Immediately cover any visible wet or bare spots, or areas with excessive binder, with additional aggregate before the binder begins to set.

Allow the HFST to properly cure, adhering to manufacturer recommendations for minimum cure times at applicable temperatures.

After the HFST is fully cured, remove excess loose surface aggregate by sweeping, blowing, or vacuuming. Do not tear or otherwise damage the surface. Excess aggregate that is recovered by a vacuum sweeper can be reused if clean, uncontaminated and dry. Remove and replace damaged areas or areas with excess or insufficient aggregate coverage. Clean expansion joints, utilities, and drainage structures of all debris before opening to traffic.

Additionally, within 3 to 7 days after opening to traffic, vacuum sweep the pavement surface to remove loosened aggregate from the friction surface area, the shoulders, and any other areas within and immediately adjacent to the HFST site.

D Measurement

The department will measure High Friction Surface Treatment Asphalt by the square yard acceptably completed.

E Payment

The department will pay for measured quantities at the contract unit price under the following bid item:

ITEM NUMBER	DESCRIPTION	UNIT
SPV.0180.01	High Friction Surface Treatment Asphalt	SY

Payment for High Friction Surface Treatment Asphalt is full compensation for testing materials; for preparing the pavement surface; for providing the HFST; for cleanup; and for vacuum sweeping and disposing of excess material after the completion and again 3 to 7 days after completion.

The department will pay for pavement repairs, joint and crack sealing, and traffic control separately under other contract bid items or, absent the appropriate bid items, as extra work.

END OF ADDENDUM