

TRANSPORT FOR NSW (TfNSW)

QA SPECIFICATION R117

LIGHT DUTY DENSE GRADED ASPHALT

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REVISION REGISTER

| Ed/Rev Number | Clause Number | Description of Revision | Authorised By | Date |
|---------------|---------------|---|---------------|----------|
| Ed 1/Rev 0 | | First issued. | GM, IC | 11.06.13 |
| Ed 1/Rev 1 | 2.2.1 | Retitled "Proportions of Constituent Materials". | GM, IC | 15.07.13 |
| | 2.2.1(g) | Maximum proportion of additive in warm mix asphalt specified in Table 4 instead of in text. Subsequent tables renumbered. | | |
| | 2.3 | Heading inserted to form new Clause 2.3.1. Subsequent Clauses renumbered. | | |
| | 2.3.2 | Retitled "Submission of Nominated Mix Design". | | |
| | 3.3 | Retitled "Method of Placement". | | |
| | 3.9 | Requirement for tackcoat to be intact at commencement of asphalt placement added. | | |
| | 4.4.2 | Maximum deviation from straightedge of surface shape 12 months after completion specified in Table 10 instead of in Clause 1.1. | | |
| Ed 1/Rev 2 | 2.1.3.2 | Requirement for granulated glass aggregate to be washed added. | MCQ | 24.05.19 |
| | 2.2.1 | Proportion of granulated glass aggregate in asphalt clarified. | | |
| Ed 1/Rev 3 | Global | References to "Roads and Maritime Services" or "RMS" changed to "Transport for NSW" or "TfNSW" respectively. | DCS | 22.06.20 |
| Ed 1/Rev 4 | Annex L | Table L.3 – frequency of testing for filler in asphalt changed. | MCQ | 25.08.20 |
| Ed 1/Rev 5 | Annex L | Table L.3 – Frequency of testing stated clarified to be for total filler used in asphalt production. | MCQ | 10.09.20 |

| Ed/Rev Number | Clause Number | Description of Revision | Authorised By | Date |
|---------------|---------------|--|---------------|----------|
| Ed 2/Rev 0 | Global | <p>Clauses rearranged and reworded to improve clarity.</p> <p>AAPA's new name AfPA added.</p> | DCIE | 11.08.22 |
| | Guide Notes | <p>New guide note, cross referring to CQTD 2013/001, on problem caused by tackcoat.</p> | | |
| | 1.1 | <p>Previous Clauses 1.1 and 1.2 consolidated under Clause 1.1. Subsequent Clauses renumbered.</p> | | |
| | | <p>Requirements for asphalt performance after 24 months, moved to Clause 5.1.</p> | | |
| | 1.2.4 | <p>Previously Clause 1.3.4. Submission of RAP Management Plan moved to Clause 2.1.4.</p> | | |
| | 1.2.5 | <p>Standard Clause on frequency of testing added, combining previous Clauses 1.3.6 and 5.3.1.</p> <p>Previous Clause 1.3.5 deleted as it is superfluous.</p> | | |
| | 1.2.7 | <p>New Clause on guide documents, which was previously part of Clause 1.3.4. AfPA (AAPA) Guide IG-3 moved here from previous Clause 5.4.</p> | | |
| | 1.3 | <p>Previously Clause 1.4. Some definitions moved here from elsewhere in R117.</p> | | |
| | 2.1 | <p>Heading added to form new Clause 2.1.1. Subsequent Clauses renumbered.</p> | | |
| | 2.1.2 | <p>Statement added that rhyolite aggregates must comply with Annex E1.</p> | | |
| | 2.1.4 (a) | <p>Previously Clause 2.1.3.1 on RAP, incorporating part of previous Clause 1.3.4.</p> | | |
| | 2.1.5 | <p>Previous listed requirements for filler, viz voids in dry compacted filler and MBV, tabulated under new Table 1 and clarified to be on total (combined) filler. Subsequent tables renumbered.</p> | | |
| | 2.1.7 (b) | <p>Use of warm mix asphalt additive clarified.</p> | | |
| | 2.1.9 | <p>New Clause on sampling and testing of constituent materials, cross referred to Annex L.</p> | | |
| | 2.2 | <p>Heading title changed.</p> | | |
| | 2.2.1 (b) | <p>Table 3 (previously Table 2) – table notes changed to main text. Requirement to demonstrate that volumetric proportions are consistent with intent, deleted.</p> | | |

| Ed/Rev Number | Clause Number | Description of Revision | Authorised By | Date |
|------------------------|-------------------|--|---------------|------|
| Ed 2/Rev 0 (cont'd) | 2.2.1 (c) | Table 4 (previously Table 3) reformatted. | | |
| | 2.2.1 (g) | Table 5 – maximum proportion of water additive changed to 2% by mass of total binder. | | |
| | 2.2.2 | Previous listed requirements for volumetric properties tabulated under new Table 6. Subsequent tables renumbered. | | |
| | 2.2.2, Annex L | Test methods T660 and T662 replaced by AS 2891.10 and AS 2891.2.2 respectively. | | |
| | 2.2.3 | New Clause stating that design of mixes containing rhyolite must comply with Annex E2. | | |
| | 2.3.1 | Requirement that submitted nominated mix design is contract specific deleted. | | |
| | 2.3.2 | New Clause on production trial, incorporating previous Clause 2.3.2 (c). | | |
| | 2.3.3 | Previously Clause 2.3.2. Individual Clauses reshuffled. | | |
| | 2.3.3 (b) | Combined aggregate density, including calculations, added to list of items to be submitted. | | |
| | 2.3.3 (c) | Production trial requirements moved elsewhere, as this Clause item covers mix design submission details; replaced by test results from production trial. | | |
| | 2.3.4 | Previously Clause 2.3.2 on test report validity periods. | | |
| | 2.3.5 | New Clause for Hold Point. Hold Point release validity period increased to 24 months. | | |
| | 2.4.1 | Consolidating previous Clauses 2.4.1 and 2.4.2.1. | | |
| | 2.4.2 | Incorporating previous Clause 2.4.2.2. | | |
| | 2.4.6 | New Clause stating that production of mixes containing rhyolite aggregates must comply with Annex E3. | | |
| | 2.4.7 | Previously Clause 2.4.6 on sampling and testing during production, incorporating part of Clause 5. | | |
| | 3.1.1 | Previously 1 st para of Clause 3.4, on provision for traffic. | | |
| | 3.1.2 | Previously Clause 3.2 on surface preparation. | | |
| | 3.1.3 | Previously Clause 3.5 on protection of road and services fixtures. | | |

| Ed/Rev Number | Clause Number | Description of Revision | Authorised By | Date |
|------------------------|---------------|---|---------------|------|
| Ed 2/Rev 0 (cont'd) | 3.2 | Previously Clause 3.9 on tackcoat. Headings added to form new Clauses 3.2.1 to 3.2.5. Statement on determination of required volume of tackcoat moved here from under Pay Item P1. | | |
| | 3.3 | Previously Clause 3.7 on temperature and weather conditions. Headings added to form new Clauses 3.3.1 and 3.3.2. | | |
| | 3.3.2 | Minimum temperature for paving using ordinary bitumen lowered to 8°C; minimum temperature using PMB correspondingly reduced. | | |
| | 3.4.1 | Incorporating 1 st para of previous Clause 3.1 and Clause 4.1.1. | | |
| | 3.4.2 | New Clause incorporating part of previous Clause 3.3, on equipment and method of placement. | | |
| | 3.4.3 | New Clause incorporating part of previous Clause 3.3, on MTV requirements. Storage and remixing requirements of MTV amended. | | |
| | 3.4.4 | New Clause incorporating part of previous Clause 3.3, on echelon paving. Paving run layout requirements clarified. | | |
| | 3.5 | Previously Clause 3.8 on paving and compaction temperatures. Headings added to form new Clauses 3.5.1 to 3.5.3. | | |
| | 3.5.2 | Requirement to carry out daily verification of infrared thermometer accuracy deleted. | | |
| | 3.6 | Difference between “course” and “layer” moved to Clause 1.3. | | |
| | 3.6.1 | New Clause on course thickness incorporating part of previous Clause 4.2.1 and 1 st para of item (b) of same Clause. | | |
| | 3.6.2 | Combining previous Clauses 3.6 and 3.6.1. | | |
| | 3.6.3 | Previously Clause 3.6.2; heading title changed to “nonconforming layer thicknesses”. | | |
| | 3.7 | Combining previous Clauses 3.10 and 3.12 to form new Clause on joints. | | |
| | 3.7.1 | New Clause on joint locations, incorporating part of previous Clause 3.10. | | |
| | 3.7.2 | New Clause on procedure for joint construction, incorporating part of previous Clause 3.10. | | |

| Ed/Rev Number | Clause Number | Description of Revision | Authorised By | Date |
|------------------------|---------------|--|---------------|------|
| Ed 2/Rev 0 (cont'd) | 3.7.3 | New Clause on temporary ramps at joints, incorporating part of previous Clause 3.12. | | |
| | 3.7.4 | New Clause on tie-ins to existing pavements, incorporating part of previous Clause 3.12. | | |
| | 3.8 | Previously Clause 3.11 on trial section, retitled. Headings added to form new Clauses 3.8.1 to 3.8.6. | | |
| | 3.9 | Combining 2 nd para of previous Clauses 3.4 and 3.1 on protection of work. | | |
| | 4 | New Clause on sampling and testing of placed asphalt, incorporating parts of previous Clauses 4 and 5. | | |
| | 4.1.1 | New Clause on sampling and testing frequency, incorporating previous Clause 5.2. | | |
| | 4.1.2 | New Clause on Lots and sub-Lots, incorporating 1 st para of previous Clause 4.1.2, previous Clause 5.3.2 and 2 nd para of previous Clause 5.2. Division of nonconforming Lot into sub-Lots clarified. | | |
| | 4.1.3 | New Clause on samples for Principal, incorporating last 2 para of previous Clause 5.2. | | |
| | 4.2 | Previously Clause 4.1 on determination of insitu air voids. Placing requirements moved to Clause 3.4.1. Conformity criteria moved to Clause 5.3. | | |
| | 4.2.2 | Mention of “reference density” omitted. Density offset determination requirements added. | | |
| | 4.3 | Previously Clause 4.2 on determination of course thickness. Placing requirements moved to Clause 3.6.1. Conformity criteria moved to Clause 5.4. | | |
| | 4.3.1 | Determination of course thickness required only where specified in Annex A. | | |
| | 4.3.2 | New Clause on determination of course thickness from cores. | | |
| | 4.3.3 | New Clause on determination of course thickness by survey. Survey for product conformity requirements cross referred to spec G71. | | |

| Ed/Rev Number | Clause Number | Description of Revision | Authorised By | Date |
|------------------------|---------------|--|---------------|------|
| Ed 2/Rev 0 (cont'd) | 4.4 | Previously Clause 4.3 on determination of course position. Conformity criteria moved to Clause 5.5. | | |
| | 4.5 | Previously Clause 4.4 on determination of surface shape. Conformity criteria moved to Clause 5.6. | | |
| | 4.6 | Previously Clause 4.5 on determination of ride quality. Conformity criteria moved to Clause 5.7. | | |
| | 4.7 | Previously Clause 5.3.3, on time for submission of test results. | | |
| | 4.8 | New Clause on restoration of core holes. | | |
| | 5 | New Clause on conformity. | | |
| | 5.1 | New Clause incorporating part of previous Clause 1.1. | | |
| | 5.2 | Incorporating part of previous Clause 5.1, on homogeneity. | | |
| | 5.3 | New Clause on conformity criteria for insitu air voids, incorporating part of previous Clause 4.1. | | |
| | 5.4 | New Clause on conformity criteria for course thickness, incorporating part of previous Clause 4.2. | | |
| | 5.5 | New Clause on conformity criteria for course position, incorporating part of previous Clause 4.3. | | |
| | 5.6 | New Clause on conformity criteria for surface shape, incorporating part of previous Clause 4.4. Location of test clarified to include across traffic lanes. | | |
| | 5.7 | New Clause on conformity criteria for ride quality, incorporating part of previous Clause 4.5. | | |
| | 5.8 | New Clause on treatment of nonconformities. | | |
| | 5.8.1 | New Clause, incorporating part of previous Clauses 4.3.2 and 4.4.2. Discrepancy on when to carry out rectification corrected. | | |
| | 5.8.2 | New Clause incorporating part of previous Clause 5.1, on acceptance of non-homogenous placed asphalt. | | |
| | 5.8.3 | New Clauses incorporating previous Clause B2.2, on acceptance of nonconforming work. | | |

| Ed/Rev Number | Clause Number | Description of Revision | Authorised By | Date |
|------------------------|---------------|--|---------------|------|
| Ed 2/Rev 0 (cont'd) | 5.8.4 | New Clause incorporating part of previous Clause 5.5, on rectification or replacement of nonconforming asphalt. Statement added that Principal is not bound to accept any proposals for acceptance of nonconforming Lots. | | |
| | 5.8.5 | New Clause incorporating part of previous Clause B2.1. | | |
| | Annex A | Guidance notes amended. Table A.1 reformatted and additional layers for intermediate course added. Determination of course thickness added to Table A.2. Previous provision to list pay items which will be measured by area changed to item in Table A.2. | | |
| | Annex B | Previous conflicting requirement on measurement of tackcoat quantity rectified. Pay Item P1 description for tackcoat amended. | | |
| | Annex E | New annex on requirements for rhyolite aggregates (previously in TD 2013/02). | | |
| | Annex F1 | Previously part of Clause 2.2.1 (c), on RAP approval level progression requirements. Previous Annex F becomes Annex F2. | | |
| | Annex K | Previously Annex E, on calculations of characteristic values. “MD” definition amended. | | |
| | Annex L | Frequency of testing rearranged in following order: constituent materials, production asphalt, placing process and placed asphalt. Table L.2 – Frequency changed for moisture content. Table L.5 – Frequency for - course position cross referred to spec G71; - longitudinal joint changed to 1 every 20 m. | | |
| | Annex M | Referenced documents updated. | | |

| |
|---|
| <p style="text-align: center;">GUIDE NOTES (Not Part of Contract Document)</p> |
|---|

Clause 2.1.2 Coarse Aggregates

This specification calls up Materials Specification TfNSW 3152, and Annexure 3152/A which must be completed to specify the Minimum PAFV.

Clause 3.2 Tackcoat

CQTD 2013/001, which highlights the problem during construction of the seal or primerseal peeling off under the paver tyres due to the application of tackcoat, provides some guidance on when tackcoat should not be applied. Note however that the clause references to R116 in CQTD 2013/001 are those of the previous edition of R116, and are no longer correct when read in relation to R116 Ed 9.

CQTD 2013/001 may be downloaded from the intranet at:

http://home.rms.nsw.gov.au/dts/cserv/os/original/tdconstructionquality/cqtd_2013_001.pdf



QA SPECIFICATION R117

LIGHT DUTY DENSE GRADED ASPHALT

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| VERSION FOR: DATE: |
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FOREWORD

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REVISIONS TO PREVIOUS VERSION

This document has been revised from Specification TfNSW R117 Edition 1 Revision 5.

All revisions to the previous version (other than minor editorial and project specific changes) are indicated by a vertical line in the margin as shown here, except when it is a new edition and the text has been extensively rewritten.

PROJECT SPECIFIC CHANGES

Any project specific changes are indicated in the following manner:

- (a) Text which is additional to the base document and which is included in the Specification is shown in bold italics e.g. ***Additional Text***.
- (b) Text which has been deleted from the base document and which is not included in the Specification is shown struck out e.g. ~~Deleted Text~~.

TfNSW QA SPECIFICATION R117

LIGHT DUTY DENSE GRADED ASPHALT

1 GENERAL

1.1 SCOPE

This Specification sets out the requirements for light duty dense graded asphalt for use in highways under traffic loading that is less than 10^7 Equivalent Standard Axles (ESAs).

The asphalt may contain recycled material, and can be manufactured using either conventional or warm mix asphalt technology.

The requirements include:

- (a) design of the asphalt mix(es);
- (b) production and transport of the asphalt;
- (c) application of tackcoat;
- (d) placement and compaction of asphalt;
- (e) inspection and testing necessary to demonstrate that the quality requirements of this Specification have been achieved.

1.2 STRUCTURE OF THE SPECIFICATION

This Specification includes a series of annexures that detail additional requirements.

1.2.1 Project Specific Requirements

Project specific details of work are shown in Annexure R117/A.

1.2.2 Measurement and Payment

The method of measurement and payment is detailed in Annexure R117/B.

1.2.3 Schedules of HOLD POINTS and Identified Records

The schedules in Annexure R117/C list the **HOLD POINTS** that must be observed. Refer to Specification TfNSW Q for the definition of **HOLD POINTS**.

The records listed in Annexure R117/C are **Identified Records** for the purposes of TfNSW Q.

1.2.4 Planning Documents

The PROJECT QUALITY PLAN must include each of the documents and requirements listed in Annexure R117/D and must be implemented.

In all cases where this Specification refers to the manufacturer's recommendations, these must be included in the PROJECT QUALITY PLAN.

1.2.5 Frequency of Testing

The Inspection and Test Plan must nominate the proposed frequency of testing to verify conformity of the item, which must not be less than the frequency specified in Annexure R117/L. Where a minimum frequency is not specified, nominate an appropriate frequency. Frequency of testing must conform to the requirements of TfNSW Q.

You may propose to the Principal a reduced minimum frequency of testing. The proposal must be supported by a statistical analysis verifying consistent process capability and product characteristics. The Principal may vary or restore the specified minimum frequency of testing, either provisionally or permanently, at any time.

1.2.6 Referenced Documents

Unless specified otherwise, the applicable issue of a referenced document, other than a TfNSW Specification, is the issue current at the date one week before the closing date for tenders, or where no issue is current at that date, the most recent issue.

Standards, specifications and test methods are referred to in abbreviated form (e.g. AS 1234). For convenience, the full titles are given in Annexure R117/M.

1.2.7 Guide Documents

Use the following documents as a guide when undertaking the Works:

- (a) AfPA (AAPA) Implementation Guide No.3 “Asphalt Plant Process Control Guide” (IG-3);
- (b) AS 2150 “Hot mix asphalt - A guide to good practice”;
- (c) Austroads AGPT04B “Guide to Pavement Technology Part 4B: Asphalt”.

1.3 DEFINITIONS AND ACRONYMS

1.3.1 Definitions

The terms “you” and “your” mean “the Contractor” and “the Contractor's” respectively.

Unless stated otherwise, all references in this Specification to the term “asphalt” mean “light duty dense graded asphalt”.

“Total filler” in asphalt is the combined fraction of fines produced from the crushing of aggregates and any added filler which passes the 75 µm AS sieve.

An asphalt course may comprise one or more layers.

“RAP Approval Level” is the level designation which corresponds to the maximum amount of reclaimed asphalt pavement (RAP) material which can be used in an asphalt mix design (refer to Table R117.4).

“Performance Period” is the period (in number of years) of proven past performance of a mix incorporating the maximum amount of RAP material corresponding to the RAP Approval Level.

A “shift” is a period of continuous work not exceeding 12 hours.

References to the term “Lot(s)” in Clauses 4.6 and 5.7 mean “Lot(s)” with in relation to ride quality.

Other definitions are in accordance with the Glossary of Austroads Terms.

1.4.2 Acronyms

The following acronyms apply to this Specification:

| | |
|-------------|--|
| AADT | Average Annual Daily Traffic (expressed as axle pairs) |
| AAPA | Australian Asphalt Pavement Association |
| AFPA | Australian flexible Pavement Association |
| AC | Dense graded asphalt |
| ESA | Equivalent Standard Axle |
| FGG | Fine Gap Graded Asphalt |
| IRI | International Roughness Index |
| MTV | Material Transfer Vehicle |
| MBV | Methylene Blue Value |
| NATA | National Association of Testing Authorities |
| PAFV | Polished Aggregate Friction Value |
| RAP | Reclaimed asphalt pavement (material) |
| VMA | Voids in Mineral Aggregate |

2 SUPPLY OF ASPHALT

2.1 CONSTITUENT MATERIALS

2.1.1 General

All constituent materials used in the manufacture of asphalt must comply with the requirements of this Specification, and maintain a uniform appearance, for the duration of the Contract.

2.1.2 Coarse Aggregate

Coarse aggregate must comply with Specification TfNSW 3152.

When aggregates are specified to be from a specific source or type, or with a high PAFV or other special characteristics, 100% of the coarse aggregate (by mass) in the asphalt must comply with all the requirements specified in TfNSW 3152.

Rhyolite aggregates must comply with Annexure R117/E1.

2.1.3 Fine Aggregate

Fine aggregate must comply with TfNSW 3152.

2.1.4 Recycled Materials

(a) Reclaimed Asphalt Pavement (RAP) Material

RAP material must comply with Specification TfNSW 3153.

If using RAP material, submit a RAP Management Plan as part of your PROJECT QUALITY PLAN which addresses the requirements of this Specification and comply with “Reclaimed Asphalt Pavement (RAP) Management Plan” published by AfPA (AAPA).

(b) Granulated Glass Aggregate

Granulated glass aggregate must comply with Specification TfNSW 3154 and be washed prior to use.

2.1.5 Filler

Added filler must conform to Specification TfNSW 3211.

Total filler (refer to Clause 1.3.1 for definition of “total filler”) in the asphalt must conform to TfNSW 3211 and Table R117.1.

Table R117.1 – Total (Combined) Filler Requirements

| Property | Unit | Test Method | Acceptance Criteria |
|-------------------------------------|------|----------------|---------------------|
| Voids in dry compacted filler | % | AS/NZS 1141.17 | ≥ 38 |
| Methylene Blue Value ⁽¹⁾ | mg/g | TfNSW T659 | ≤ 10 |

Note:

⁽¹⁾ MBV value of total filler, but excluding hydrated lime.

2.1.6 Binder

Binder used for the Works must be of the class specified in Annexure R117/A.

You may propose for approval by the Principal the use of an alternative class of binder if the asphalt contains either:

- (a) RAP material in excess of 25%; and/or
- (b) warm mix asphalt additive.

The binder must comply with Specifications TfNSW 3252 or TfNSW 3253 as appropriate for the class of binder specified. Provide documentary evidence of the binder conformity for asphalt used in the Works in accordance with TfNSW 3252 or TfNSW 3253.

2.1.7 Additives

(a) Bitumen Adhesion Agent

Bitumen adhesion agent may be added to improve the resistance of the asphalt’s propensity to stripping.

(b) Warm Mix Asphalt Additive

Warm mix asphalt additive may be added to asphalt, for purposes such as to reduce the asphalt manufacturing temperature and/or to improve workability during the paving and compaction operations, particularly during cool weather paving.

2.1.8 Bitumen Emulsion Tackcoat

Bitumen emulsion for use as a tackcoat must be CRS/170-60 complying with AS 1160, unless otherwise approved by the Principal.

2.1.9 Sampling and Testing of Constituent Materials

The frequency of sampling and testing for constituent materials must be in accordance with Annexure R117/L.

2.2 DESIGN OF ASPHALT MIX

2.2.1 Proportions of Constituent Materials

(a) Combined Particle Size Distribution of Aggregate

The combined particle size distribution of aggregates in the asphalt, when determined in accordance with AS/NZS 2891.3.1, must conform to Table R117.2.

Table R117.2 – Combined Particle Size Distribution Limits, Different Nominal Size of Asphalt

| AS Sieve Size | Combined Particle Size Distribution Passing Limits (% by mass) | | | | | | |
|---------------|--|---------------|-----------------|-----------------|-----------------|--------------|----------------|
| | Nominal Size of Asphalt (Asphalt Designation) | | | | | | |
| | 5 mm (AC5) | 7 mm (AC7) | 10 mm (AC10) | 14 mm (AC14) | 20 mm (AC20) | 7 mm FGG7 | 10 mm FGG10 |
| 53.0 mm | – | – | – | – | – | – | – |
| 37.5 mm | – | – | – | – | – | – | – |
| 26.5 mm | – | – | – | – | 100 | – | – |
| 19.0 mm | – | – | – | 100 | 90 – 100 | – | – |
| 13.2 mm | – | – | 100 | 90 – 100 | 71 – 86 | – | 100 |
| 9.50 mm | – | 100 | 90 – 100 | 72 – 89 | 58 – 75 | 100 | 85 – 100 |
| 6.70 mm | 100 | 85 – 100 | 68 – 87 | 54 – 79 | 46 – 64 | 85 – 100 | 60 – 86 |
| 4.75 mm | 85 – 100 | 70 – 87 | 50 – 76 | 43 – 69 | 37 – 55 | 65 – 85 | 55 – 74 |
| 2.36 mm | 55 – 75 | 44 – 65 | 32 – 57 | 28 – 53 | 24 – 42 | 55 – 72 | 50 – 70 |
| 1.18 mm | 38 – 57 | 29 – 48 | 22 – 42 | 19 – 40 | 15 – 32 | 45 – 65 | 45 – 65 |
| 600 µm | 26 – 43 | 19 – 35 | 15 – 31 | 13 – 30 | 10 – 24 | 30 – 60 | 30 – 60 |
| 300 µm | 15 – 28 | 12 – 25 | 10 – 23 | 9 – 22 | 7 – 17 | 18 – 40 | 18 – 40 |
| 150 µm | 8 – 18 | 8 – 16 | 6 – 14 | 6 – 15 | 4 – 12 | 8 – 18 | 8 – 18 |
| 75 µm | 4 – 11 | 5 – 8 | 4 – 7 | 4 – 7 | 3 – 6 | 5 – 11 | 5 – 11 |

(b) Binder

The proportion of binder in the asphalt, expressed as a percentage by mass of the total mix, must comply with Table R117.3.

Table R117.3 – Binder Content for Different Asphalt Designation

| Property | Nominal Size of Asphalt (Asphalt Designation) | | | | | | |
|--|---|---------------|-----------------|-----------------|-----------------|---------------|----------------|
| | 5 mm (AC5) | 7 mm (AC7) | 10 mm (AC10) | 14 mm (AC14) | 20 mm (AC20) | 7 mm FGG07 | 10 mm FGG10 |
| Binder Content (% by mass of total mix) | 5.4 – 7.0 | 5.4 – 7.0 | 5.1 – 6.5 | 4.8 – 6.3 | 4.4 – 5.8 | 6.3 – 7.3 | 6.0 – 7.0 |

The binder content ranges specified in Table R117.3 are applicable to commonly used natural sources of aggregates and sands for a known range of densities. If you propose to use constituent materials of substantially different density, you may propose for approval by the Principal the use of an alternative binder content that does not conform to the above.

Determine the binder content in accordance with AS/NZS 2891.3.1.

(c) Reclaimed Asphalt Pavement Material

You may incorporate RAP material in asphalt for use in the wearing and other courses, up to the maximum limits shown in Table R117.4. The amount of RAP material in the asphalt mix must

not exceed the percentages shown in Table R117.4 for the RAP Approval Level at which you have been approved.

Table R117.4 – Maximum Amount of RAP Material in Asphalt and their Prerequisites

| RAP Approval Level⁽¹⁾ | Other than Wearing Courses | | | RAP Approval Level⁽¹⁾ | Wearing Course | | |
|---|--|---|---|---|--|---|---|
| | Maximum Amount of RAP⁽²⁾ | Testing (Refer Table R117/F.1)⁽³⁾ | Performance Period⁽¹⁾ | | Maximum Amount of RAP⁽²⁾ | Testing (Refer Table R117/F.1)⁽³⁾ | Performance Period⁽¹⁾ |
| 1L | 30% | Section A | N/A | 1WL | 20% | Section A | N/A |
| 2L | 40% | Section B | 2 years | 2WL | 25% | Section B | 2 years |

Notes: “L” denotes light duty dense graded asphalt “W” denotes wearing course

⁽¹⁾ Refer to Clause 1.3.1 for definitions of “RAP Approval Level” and “Performance Period”.

⁽²⁾ Maximum amount of RAP material allowable in asphalt mix for the particular RAP Approval Level, expressed as a percentage by mass of total mix.

⁽³⁾ Testing specified in Annexure R117/F must be complied with. Testing requirements as per Sections A and B are detailed in Table R117/F.1.

Warm mix asphalt may contain RAP material.

(d) Granulated Glass Aggregate

Asphalt may contain a proportion of washed granulated glass aggregate not exceeding:

- (i) **wearing course:** 2.5% by mass of total mix;
- (ii) **other than wearing course:** 10% by mass of total mix.

(e) Hydrated Lime

Asphalt may contain hydrated lime complying with TfNSW 3211.

(f) Adhesion Agent

Asphalt may contain bitumen adhesion agent not exceeding 1.0% by mass of binder.

(g) Warm Mix Asphalt Additive

The maximum proportion of additive in the asphalt must comply with Table R117.5:

Table R117.5 – Maximum Proportion of Additive in Warm Mix Asphalt

| Additive | Maximum Proportion |
|---|----------------------------|
| Wax | 2.0% by mass of binder |
| Surfactants | Nominated by Contractor |
| Water (either added directly or in the form of water containing crystals) | 2% by mass of total binder |

2.2.2 Volumetric Properties

The asphalt mix design must comply with the volumetric properties shown in Table R117.6.

Table R117.6 – Volumetric Properties

| Property | Unit | Test Method | Acceptance Criteria |
|---|------|---|----------------------|
| Voids in mineral aggregate (VMA) at 80 cycles ⁽¹⁾ | % | AS/NZS 2891.2.2, AS/NZS 2891.7.1 or AS/NZS 2891.7.3, AS/NZS 2891.8, AS/NZS 2891.9.2 | Table R117.7 |
| Air voids in laboratory compacted mix at 80 cycles ⁽¹⁾ | % | | $\geq 3.0, \leq 6.0$ |
| Moisture content ⁽²⁾ | % | AS/NZS 2891.10 | < 0.5 |

Notes:

⁽¹⁾ Number of cycles of compaction required for AS/NZS 2891.2.2.

⁽²⁾ Applies to all mixes produced in a drum plant, or containing a warm mix asphalt additive, or containing RAP.

Table R117.7 – Voids in Mineral Aggregate (VMA)

| Property | Unit | Nominal Size of Asphalt (Asphalt Designation) | | | | | | |
|----------|------|---|---------------|-----------------|-----------------|-----------------|---------------|----------------|
| | | 5 mm (AC5) | 7 mm (AC7) | 10 mm (AC10) | 14 mm (AC14) | 20 mm (AC20) | 7 mm FGG07 | 10 mm FGG10 |
| VMA | (%) | ≥ 17 | ≥ 17 | ≥ 16 | ≥ 15 | ≥ 14 | ≥ 17 | ≥ 16 |

2.2.3 Mixes Containing Rhyolite Aggregates

Design of asphalt mixes containing rhyolite aggregates must comply with Annexure R117/E2.

2.3 NOMINATED MIX DESIGN

2.3.1 General

Submit to the Principal for approval one nominated mix design for each asphalt mix specified in Annexure R117/A.

The submitted nominated mix design is:

- materials specific, and substitution of constituent materials during production is not permitted;
- design specific, and variation to the design nominated mix submission is not permitted;
- asphalt plant specific, and except for component maintenance, changes in the components, configuration and/or location of the plant is not permitted.

For each new establishment of an asphalt plant, submit a full nominated mix design.

2.3.2 Production Trial

As part of your nominated mix design submission process, conduct a production trial to demonstrate conformity of the nominated mix.

All production trial tests on each nominated mix must be from one trial batch. The tests on the constituent materials must represent the materials used in this trial batch.

2.3.3 Nominated Mix Design Submission Details

The nominated mix design submission must include the following details:

(a) Constituent Materials

- (i) Coarse and fine aggregates: source, geological type. Aggregate of a different type or quality, even if from the same quarry face or from within the same quarry, will be regarded as from a different source.
- (ii) Added filler: type, grade and source.
- (iii) Binder: source, class or grade.
- (iv) Recycled materials:
 - RAP material: effective binder content (i.e. the portion that is considered to contribute to the binder content of the asphalt mix design) and recovered viscosity of binder.
 - granulated glass aggregate: source.
- (v) Additives: type, source, trade name and manufacturer's recommendations.
- (vi) Bitumen emulsion tackcoat: source, class of bitumen, any bitumen modification.

(b) Mix Design

For each nominated mix design:

- (i) Proportion of each constituent by percentage of mass of total mix.
- (ii) Nominated values and allowable tolerances for each requirement specified in Clause 2.2, where applicable.
- (iii) If using RAP material, the RAP Approval Level for which you are approved to use.
- (iv) Type and identification number of the asphalt manufacturing plant, and mix identification.
- (v) Temperature at which the asphalt is manufactured.

(c) Production Trial

Test results from the production trial in accordance with Clause 2.3.2.

(d) Warm Mix Asphalt Additives

If using warm mix asphalt additives, provide details of the additive(s) in your nominated mix design submission.

Clearly state in your submission:

- (i) any proposed amendments to the mix design procedure, operational processes and/or test methods as a result of the inclusion of a warm mix asphalt additive;
- (ii) classification of the warm mix asphalt additive.

Include evidence acceptable to the Principal that the additive is suitably designed and has proven performance for the purpose described in this Specification.

The nominated mix design will be rejected if the nature, intended purpose and dosage of the warm mix asphalt additive are not clear in your nominated mix design submission.

(e) Signed Statement

A signed statement certifying that each nominated mix, the associated production trial mix, and all constituents meet the requirements of Clauses 2.1 and 2.2. The statement must include NATA endorsed test results for all specified tests. Attach a copy of your completed verification checklist.

2.3.4 Test Report Validity Periods

Unless specified otherwise, all asphalt and binder tests relating to the nominated mix design submission must not be older than one month prior to the date of submission to the Principal.

All other tests relating to the submission must not be older than 6 months prior to the date of submission to the Principal.

All phases of any particular test must be performed at the same laboratory.

2.3.5 Hold Point

HOLD POINT

| | |
|------------------------|---|
| Process Held: | Placing of the nominated mix(es). |
| Submission Details: | Documents as detailed in Clause 2.3.3 at least 7 working days before the nominated mix(es) is (are) proposed to be placed. |
| Release of Hold Point: | The Principal will consider the submitted documents prior to authorising the release of the Hold Point. This Hold Point release is valid for a maximum period of 24 months. |

2.4 PRODUCTION OF ASPHALT

2.4.1 Method of Production

Your adopted method of production must:

- (a) control the process and target the nominated mix design;
- (b) supply a homogeneous and consistent product at the nominated manufacturing temperature.

You may vary the proportion of each constituent for the purpose of process control, provided that:

- (i) the asphalt produced remains uniform and of consistent quality, and subject to the production tolerances specified in Clause 2.4.2;
- (ii) the proportion of RAP does not exceed the RAP Approval Level in Table R117.4 for which you have been approved.

2.4.2 Production Tolerances

The actual combined particle size distribution and actual binder content may vary from their nominated values within the limits shown in Table R117.8, provided that the actual values also remain within the limits of Tables R117.2 and R117.3 respectively. The permissible variation to nominated values during production for each mix size is shown in Table R117.8.

Table R117.8 – Production Tolerances

| Description | Tolerance (% by mass) |
|--|-----------------------|
| Combined particle size distribution (AS sieve)^(1, 3) | – |
| 4.75 mm and larger | ± 7 |
| 2.36 mm | ± 5 |
| 1.18 mm | ± 5 |
| 600 µm | ± 4 |
| 300 µm | ± 4 |
| 150 µm | ± 2.5 |
| 75 µm | ± 1.5 |
| Binder content^(2, 3) | ± 0.3 |

Notes:

- (1) % by mass of total aggregate.
- (2) % by mass of total mix.
- (3) Determined in accordance with AS/NZS 2891.3.1.

2.4.3 Asphalt Manufacturing Plant

Operate the asphalt manufacturing plant with adequate production process controls to produce asphalt of a consistent quality and conforming to the requirements of this Specification. The production control system must produce auditable records of key process parameters including individual aggregate and filler feed rates/batch masses, binder application rate/batch mass and various process temperatures.

Implement a documented procedure in the PROJECT QUALITY PLAN for the management and control of the moisture content of each constituent aggregate material.

Disperse uniformly throughout the mix any added RAP materials such that there is no apparent variability or temperature segregation in the mix.

The asphalt manufacturing plant must have sufficient capacity to supply asphalt for continuous operation of the paver.

2.4.4 Storage and Handling

(a) Binder

Include in the PROJECT QUALITY PLAN the procedures for acquisition, storage and handling of binder which identify and prevent segregation and/or contamination of the binder.

Heating and storage of binder must comply with the temperature and time limits set out in Advisory Note 7 published by AfPA (AAPA).

At the asphalt manufacturing plant, binder supplied in accordance with TfNSW 3252 must be recirculated in delivery and/or storage tanks to a uniform consistency immediately prior to its use in the manufacturing process.

(b) Asphalt

Asphalt which does not contain RAP material may be retained in hot storage silos for a period not exceeding 24 hours. You may propose for approval by the Principal a longer period, based on effective temperature management and oxidation suppression systems.

Asphalt mixes containing RAP materials may be retained in a purpose designed storage system which has been demonstrated to cause no deterioration in the stored asphalt, for a period not exceeding 24 hours, subject to the approval of the Principal.

2.4.5 Manufacturing Temperatures

Control the temperatures of constituent materials in response to suitable thermometer elements placed in the flow of materials from the drier, and in the binder storage system or binder supply line. Thermometer must be readable and accurate to within $\pm 2^{\circ}\text{C}$.

Measure and record the temperature of the asphalt when:

- (a) asphalt leaves the pugmill or mixing drum; or
- (b) asphalt is being discharged from the hot storage bin(s); or
- (c) in the delivery vehicles, prior to them leaving the plant.

The temperature of asphalt must not at any time in the process exceed 175°C .

Include in the PROJECT QUALITY PLAN details of the project specific process temperatures and the frequency of recording.

2.4.6 Mixes Containing Rhyolite Aggregates

Asphalt mixes containing rhyolite aggregates must comply with Annexure R117/E3.

2.4.7 Sampling and Testing During Production

Verify conformity with the Specification by sampling and testing, and maintain records of your process control during asphalt production.

The frequency of sampling and testing must be in accordance with Annexure R117/L.

Take asphalt samples in accordance with AS/NZS 2891.1.1.

2.5 TRANSPORT OF ASPHALT

Transport of asphalt must be in accordance with AS 2150.

Include in the PROJECT QUALITY PLAN the method of application and control of release agent to ensure a uniform, light coating of the vehicle's tray without ponding of surplus release agent.

Facilitate continuous operation of the paving train by providing sufficient transport capacity and ensuring efficient on-site management of asphalt deliveries.

3 PLACING ASPHALT

3.1 GENERAL

3.1.1 Provision for Traffic

Provide for traffic in accordance with the requirements of Specification TfNSW G10 when carrying out asphalt paving.

3.1.2 Surface Preparation

Prepare the surface to be paved in accordance with AS 2150, including removal of raised extruded thermoplastic road markings and raised pavement markers.

3.1.3 Protection of Road and Services Fixtures

Implement measures to prevent asphalt or other material used on the work from entering or adhering to grates, hydrants or valve boxes, service covers, bridge joints and other road fixtures.

Immediately after the asphalt has been placed, clean and remove all waste asphalt adhering to road and services fixtures.

3.2 TACKCOAT

3.2.1 Existing Surface Condition

The existing surface must be clean, dry and free from loose material, prior to application of the tackcoat.

3.2.2 Application Rate

Apply the tackcoat evenly at a rate of between 0.15 and 0.30 litres of residual bitumen per square metre, ensuring that it is effectively bonded to the surface. For joints and chases, double the application rate.

Nominate in writing to the Principal your proposed tackcoat application rate prior to applying the tackcoat.

Determine the required volume by multiplying the nominated application rate of residual bitumen by the specified area of the surface to be tackcoated, including the faces of joints, kerbs and other structures.

3.2.3 Reduced Application Rate

You may propose in writing to the Principal a reduced application rate for the tackcoat, for reasons arising from the existing underlying surface material. Support your proposal by examples of previous cases where this has been done, including locations and insitu material types and the current pavement performance.

3.2.4 Daily Record

Provide to the Principal a signed daily record of the average tackcoat application rate applied to each Lot. Report the tackcoat application rate in terms of residual bitumen and state the percentage dilution of the tackcoat used during spraying.

3.2.5 Condition of Tackcoat at Commencement of Asphalt Placement

The tackcoat must be intact at the commencement of asphalt placement.

3.3 TEMPERATURE AND WEATHER CONDITIONS

3.3.1 Temperature and Wind Velocity Measurement

Measure and record the temperature of the surface to be paved, and wind velocity at the point of asphalt placing. Document the method and frequency of measurement and recording in the PROJECT QUALITY PLAN.

3.3.2 Conditions Suitable for Placing Asphalt

Do not commence or continue placing asphalt containing binder complying with TfNSW 3253 if the temperature of the surface to be paved over, measured at existing surface level, is less than 8°C where the nominal size of asphalt is less than 20 mm, or less than 5°C where the nominal size of asphalt is 20 mm or greater, for a zero wind speed.

These minimum temperatures are increased by 5°C for asphalt containing binder complying with TfNSW 3252.

These minimum temperatures are increased by a further 5°C for each 5 kph of wind speed above zero; however the minimum temperatures must not exceed 30°C.

Do not place tackcoat and/or asphalt when the surface is wet, and/or when wet weather appears imminent.

3.4 METHOD OF PLACEMENT

3.4.1 General

Your method of placing and finishing the asphalt must:

- (a) produce a homogeneous product with a tightly bound surface;
- (b) achieve a uniform bond to the surface below;
- (c) achieve the finished pavement properties, specified in Clause 5, within the specified tolerances.

Compact uniformly each layer of asphalt to achieve insitu air voids requirements before placing the next layer.

3.4.2 Equipment and Method

Place the asphalt using a self-propelled paver with the ability to be operated with automatic grade control and automatic joint matching facility.

Hand placement of asphalt is only permitted for minor corrections of the existing surface and in areas where placement with a paver is impractical.

Include in the PROJECT QUALITY PLAN the method of achieving conforming compaction, including roller type, number of passes and rolling pattern.

3.4.3 Material Transfer Vehicle

If so specified in Annexure R117/A, use a Material Transfer Vehicle (MTV) in your paving operations to receive asphalt from the delivery vehicles and transfer the asphalt to the paver.

The MTV must be a self-propelled machine with independent controls and demonstrated capability to minimise temperature variation and material segregation. It must be equipped with:

- (a) a receiving hopper compatible with delivery vehicles;
- (b) conveying mechanisms capable of delivering asphalt to the paver at a minimum rate to suit the paving output;
- (c) sufficient power output from the motor to operate with full load on grades up to 6% and travel in tandem with the paver, either directly in front or in an offset position;
- (d) capacity to store and remix asphalt if the time between loading the delivery vehicles at the asphalt plant and unloading at the Site is equal to or greater than 1.5 hours, or when the temperature of the surface to be paved is below the minimum specified in Clause 3.3.

The MTV must discharge into a holding bin in the paver hopper.

3.4.4 Echelon Paving

If so specified in Annexure R117/A, place the asphalt by echelon paving using a minimum of two pavers operating continuously in tandem. Plan the paving run layout, and the location of the hot joint between the two mats placed by the tandem pavers, to minimise the risk of cold joints developing within trafficked lanes, unless otherwise approved by the Principal.

3.5 PAVING AND COMPACTION TEMPERATURES

3.5.1 General

Include in the PROJECT QUALITY PLAN the temperatures at which asphalt can be placed and compacted to achieve the insitu air void requirements specified in Clause 5.3.

HOLD POINT

| | |
|------------------------|--|
| Process Held: | Commencement of paving using the nominated mix(es), including trial section (refer to Clause 3.8). |
| Submission Details: | If not previously submitted, details of the following: (a) minimum temperature at which asphalt will be delivered to the paver; (b) minimum temperature at which initial compaction of the asphalt can still commence; (c) method of temperature measurement. |
| Release of Hold Point: | The Principal will consider the submitted documents prior to authorising the release of the Hold Point. |

3.5.2 Thermometer

Measure the asphalt temperature using a handheld or machine mounted infrared thermometer, which is readable and accurate to within $\pm 2^{\circ}\text{C}$, either at the point of discharge from a tipper truck or at the distribution auger on the paver.

Carry out a daily check of the correlation factor of the handheld infrared thermometer, and at any other time upon the request of the Principal.

3.5.3 Temperature Variation

Do not incorporate in the Works asphalt that exhibits a temperature variation within the batch, unless it has been remixed to a consistent and adequate temperature for placing and compaction.

3.6 COURSE AND LAYER THICKNESSES

3.6.1 Course Thickness

The specified course thickness is detailed in Annexure R117/A, or shown on the Drawings.

Control the course thickness by maintaining the design levels during placing and the surface shape requirements specified in Clause 5.6.

3.6.2 Layer Thickness

Where a course comprises more than one layer, and the layer thicknesses have not been specified on the Drawings, nominate the thickness of each layer in your PROJECT QUALITY PLAN.

The nominated thickness of a layer of asphalt must be between 3.0 to 5.0 times the nominal mix size.

3.6.3 Nonconforming Layer Thicknesses

For corrective courses and tie-ins to an existing pavement, you may propose for approval by the Principal to place layers in thicknesses that does not conform to the specified thickness requirements of Clause 3.6.2.

HOLD POINT

| | |
|------------------------|--|
| Process Held: | Placing of asphalt in layer thicknesses that does not conform to specified layer thicknesses. |
| Submission Details: | Details of the following: <ul style="list-style-type: none">(a) nominated layer thicknesses which does not conform to specified thicknesses;(b) work methods capable of producing a dense homogeneous layer at these thicknesses;(c) areas affected, and evidence that these areas are the absolute minimum necessary. |
| Release of Hold Point: | The Principal will consider the submitted documents prior to authorising the release of the Hold Point. |

3.7 JOINTS

3.7.1 Locations

Longitudinal joints must be:

- (a) offset by 150 mm from the joint in the underlying layers;
- (b) located within 150 mm of the line of change in crossfall;
- (c) coincident with final traffic markings, unless otherwise approved by the Principal.

Transverse joints must be:

- (i) located at a minimum of 25 m apart;
- (ii) offset by a minimum of 1 m from the joint in the underlying layer;
- (iii) formed at the commencement of each paving run;
- (iv) formed when a delay in paving causes asphalt temperature to fall below the initial compaction temperature nominated in Clause 3.5.

3.7.2 Procedure

Include in your PROJECT QUALITY PLAN the procedure for the construction of joints. Your procedure must maximise joint density and include mechanised edge compaction or mechanised edge trimming details.

Hand tamping of edges is permitted where the use of a machine is impractical. Do not spread excess material resulting from hand preparation of edges on the surface of the work.

Remove all loose, cracked and/or boney material at the edge of a paved asphalt mat prior to placing the adjacent mat. Do not incorporate asphalt resulting from clean-up of process trimmings in the Works.

Finish each joint with a smooth, planar surface coinciding with the surface of the rest of the mat and satisfying the surface shape requirements specified in Clause 5.6.

3.7.3 Temporary Ramps at Joints

Construct temporary ramps at joints for safe trafficking of the work either by placement of asphalt complying with this Specification, or by cold milling the existing or new asphalt layer to form the ramp, as appropriate for the application.

The length and grade of temporary ramps must be equivalent to those specified for treatment at edges and structures described in Specification TfNSW R101.

3.7.4 Tie-ins to Existing Pavements

Construct permanent tie-ins to existing pavement by placement of asphalt complying with this Specification.

3.8 TRIAL SECTION

3.8.1 General

If so specified in Annexure R117/A, and prior to commencement of paving of the Works, construct a separate trial section using the plant and personnel proposed for the work for each nominated mix.

3.8.2 Location

Each trial section must be located remote from the Works, unless otherwise approved by the Principal. Limit the size of the trial section to the production which can be achieved in one shift (refer to Clause 1.3.1 for definition of “shift”).

3.8.3 Conformity Requirements

Design the trial to implement all the procedures described in your PROJECT QUALITY PLAN and demonstrate conformity with the Specification in respect of:

- (a) homogeneity;
- (b) insitu air voids;
- (c) course thickness;
- (d) course position;
- (e) surface shape;
- (f) joint quality;
- (g) ride quality, where specified.

3.8.4 New Trial Section

If there are nonconformities in the trial section, or when the Principal determines that a previous trial is not representative of the materials, asphalt mix proportions, temperature, plant, rate of output and/or method of placement, carry out paving of a new trial section.

3.8.5 Nonconformities

Where a trial section forms part of the Works, manage all nonconformity in respect of materials, process and finished pavement properties in accordance with Clause 5.8.

3.8.6 Hold Point

HOLD POINT

| | |
|------------------------|--|
| Process Held: | Commencement of paving at locations other than trial section. |
| Submission Details: | Verification checklist and all relevant test results from the trial section demonstrating conformity to the specified requirements, at least 3 working days prior. |
| Release of Hold Point: | The Principal will consider the submitted documents prior to authorising the release of the Hold Point. |

3.9 PROTECTION OF WORK

Protect the asphalt until it has been fully compacted and cooled sufficiently to carry traffic without damage to the work.

Do not induce rapid cooling in the asphalt surface by application of water at any stage in the process, including preparation for trafficking.

4 SAMPLING AND TESTING OF PLACED ASPHALT

4.1 GENERAL

4.1.1 Frequency of Sampling and Testing

Frequency of sampling and testing of placed asphalt must be in accordance with Annexure R117/L.

Show in the PROJECT QUALITY PLAN your method of determining the sampling locations, sampling and testing frequencies and associated test methods.

4.1.2 Lot and Sub-Lot

Carry out compaction control on Lots using statistical techniques as specified in TfNSW Q.

The maximum Lot size must conform to TfNSW Q.

A Lot which is nonconforming may be divided into sub-Lots to exclude sections of the Lot which are conforming.

For the purpose of determining the quantity of nonconforming placed asphalt, the boundaries of a sub-Lots represented by a single tested sample will be the midpoints between the sample point in question, and adjacent sample points.

4.1.3 Samples for the Principal

When the Principal requests loose asphalt samples for testing, riffle and/or quarter the samples.

Deliver all samples, including core samples, in sealed and labelled containers.

4.2 DETERMINATION OF INSITU AIR VOIDS

4.2.1 General

Do not test asphalt layers less than or equal to 30 mm thickness for insitu air voids.

Calculate the characteristic values of insitu air voids in accordance with Annexure R117/K1.

4.2.2 Determination of Bulk Density

Determine the bulk density (BD) from either one of the following methods, but do not use the nuclear density gauge method (see item (b) below) when steel reinforcement exists within 300 mm of the surface of the layer:

(a) Cores

Take cores in accordance with AS 2891.1.2.

When trimming, do not reduce the core layer thickness by more than 5 mm.

Determine the bulk density of cores taken in accordance with AS/NZS 2891.9.2.

(b) Nuclear density gauge

Take measurements in accordance with AS/NZS 2891.14.2 and AS/NZS 2891.14.3.

Determine the bulk density of cores taken for density offset calculations in accordance with AS/NZS 2891.9.2.

Determine the density offset separately for every change in nominated mix and specified layer thickness. Verify that the applied density offset is still valid wherever there is a change in site characteristics, such as underlying surface roughness, composition of underlying layer and density of underlying layer.

Report the density offset on all test reports.

4.3 DETERMINATION OF COURSE THICKNESS

4.3.1 General

Determine course thickness where so specified in Annexure R117/A.

4.3.2 From Cores

Determine the characteristic values and average value of thickness of the Lot using statistical techniques as specified in TfNSW Q from cores taken in accordance with AS 2891.1.2. The cores may be the same as those taken for determination of air voids (refer to Clause 4.2), but the core layer thickness is determined prior to trimming of the core.

Where the asphalt is placed in one or more layers to form a single course, determine the course thickness by adding the average thickness from cores of the lower and upper layers.

For the purpose of determining the course thickness from cores, the core diameter can be less than 95 mm and the test specimen may comprise more than one layer.

Calculate the maximum and minimum characteristic values of thickness for the Lot in accordance with Annexure R117/K2.

4.3.3 By Survey

Carry out surveys for product conformity in accordance with Specification TfNSW G71 Clause 5.3.3.

The average compacted course thickness of each Lot calculated from surveys must be consistent with the average compacted course thickness of the respective Lot determined from cores.

Include in your PROJECT QUALITY PLAN the statistical technique for verifying the consistency of the results.

4.4 DETERMINATION OF COURSE POSITION

4.4.1 Finished Surface Levels Not Specified

Where finished surface levels are not specified, determine the course position of each Lot by reference to existing pavement surface and road fixtures.

4.4.2 Finished Surface Levels Specified

Where finished surface levels are specified, measure the course position of each Lot by survey in accordance with TfNSW Q and TfNSW G71 Clause 5.3.3.

4.4.3 Survey Location for Determining Course Position

The survey location of any point on the surface of a course for level determination must be located within 25 mm from the corresponding point determined from the Drawings.

4.5 DETERMINATION OF SURFACE SHAPE

4.5.1 General

Determine and report the surface shape in accordance with Test Method TfNSW T183.

The maximum Lot size must be in accordance with TfNSW Q but extended to include the adjacent longitudinal joints, transverse joints and tie-ins.

4.5.2 Prior to Placing Overlying Course

Prior to placing the next overlying course, determine the surface shape in accordance with Clause 4.5.1. Deal with any conformities in accordance with Clause 5.8.1.

4.6 DETERMINATION OF RIDE QUALITY

4.6.1 General

If specified in Annexure R117/A, determine the ride quality from measurements of the longitudinal profile taken by a vehicular laser profilometer, where the ride quality is the International Roughness Index (IRI_S) determined in accordance with Test Method TfNSW T188.

For this purpose, the Lot is a section within the test lane as defined in the Test Method.

Where the Works comprise a single layer of asphalt placed over a pavement constructed by others, determine and report the ride quality of the existing surface prior to commencement.

The Lots of the existing surface selected must coincide as much as practicable with the Lots of the finished work.

4.6.2 Inspection and Test Plan

Develop an Inspection and Test Plan (ITP) for ride quality that meets the requirements of the Specification. Define the Lots (for ride quality) and the start and end locations for testing in your ITP.

4.6.3 Accreditation Certificates

Provide the Principal with copies of the TfNSW Accreditation Certificates for each proposed vehicular laser profilometer driver and operator.

4.7 TIME FOR SUBMISSION OF TEST RESULTS

Submit to the Principal test reports for:

- (a) combined particle size distribution, binder content and air voids in laboratory compacted mix – within one working day of placing the asphalt;
- (b) insitu air voids, course thickness and course shape – within three working days of placing the asphalt.

4.8 RESTORATION OF CORE HOLES

4.8.1 Materials

Materials used for restoration of core holes must be a bituminous mix, and may be installed either hot or cold in accordance with the product manufacturer's recommendations and suitable for the intended purpose.

Hot dense graded asphalt may be used, provided that the normal hot asphalt temperatures required during transport and placement are maintained throughout the entire process.

Normal cold mix asphalt, and materials which have significantly different stiffness and thermal response to the asphalt (e.g. concrete), must not be used.

Proprietary purpose-designed products may be used to reinstate core holes, subject to the approval of the Principal.

4.8.2 Core Hole Preparation

Prior to their backfilling, prepare the core holes by removing any dirt inside, then brush, sponge and/or vacuum the core hole clean and allow it to dry.

Apply by brush or spray, a heavy coating of rapid set bitumen emulsion or similar material, to the sides and floor of the core hole. Allow the coating material to break or cure prior to placing the fill material.

4.8.3 Core Hole Backfilling

Fill the core holes without segregation or contamination of the fill material in layers not exceeding 50 mm.

Compact each layer without crushing the aggregate particles, using suitable compaction equipment such as motorised hammer, plate compactor, and/or hand tampers.

The finish top surface of the backfill material must not be below the level of the existing pavement.

5 CONFORMITY**5.1 GENERAL**

During the first 24 months after the Actual Completion Date:

- (a) the placed asphalt must not ravel, rut, shove, strip or bleed; and
- (b) the wearing course for the first 12 months must comply with the surface shape requirements specified in Table R117.12.

5.2 HOMOGENEITY

Placed asphalt must be homogeneous in appearance, and must not exhibit segregation, cracking, ravelling, bony or fatty material, or have been damaged during construction.

5.3 INSITU AIR VOIDS

The characteristic values of insitu air voids for a Lot must be within the limits shown in Table R117.9.

Table R117.9 – Insitu Air Voids Requirements

| Layer Type | Characteristic Values of Insitu Air Voids | |
|----------------------------|---|-------------|
| | Lower Limit | Upper Limit |
| Specified layer thickness: | – | – |
| > 30 mm and < 50 mm | 3.0% | 8.0% |
| ≥ 50 mm | 3.0% | 7.0% |

5.4 COURSE THICKNESS**5.4.1 Finished Surface Levels Not Specified**

Where the course is a single layer and is placed over an existing pavement constructed by others, the average compacted course thickness for each Lot must be within the tolerances specified in Table R117.10 for the nominal size of asphalt.

Where the course is placed over one or more layers which have been placed by you, the characteristic values of the course thickness for the Lot must be within the tolerances specified in Table R117.10 for the nominal size of asphalt.

Where the asphalt is placed in one or more layers to form a single course, the course thickness calculated in accordance with Clause 4.3.1 must be within the tolerances specified in Table R117.10 for the nominal size of asphalt.

Table R117.10 – Allowable Tolerances for Course Thickness

| Nominal Size of Asphalt (mm) | Tolerances (mm) |
|---|----------------------------|
| 5 | -0 / + 5 |
| 7 | -0 / + 5 |
| 10 | -0 / + 6 |
| 14 | -0 / + 8 |
| 20 | -0 / + 10 |

5.4.2 Finished Surface Levels Specified

The course thickness is deemed to conform if the asphalt course surface levels conform under Clause 5.5.1 (refer also to Clause 3.6.1).

The average compacted course thickness of each Lot of the wearing course must be within 10% of the specified course thickness.

5.5 COURSE POSITION

5.5.1 General

The actual surface levels of the placed asphalt course as determined by survey must not deviate from the design levels by more than the tolerances shown in Table R117.11.

Table R117.11 – Course Surface Level Tolerances

| Course | Tolerances (mm) |
|----------------------------|------------------------|
| Wearing course | -0 / +10 |
| Top Intermediate course | -5 / +10 |
| Other Intermediate Courses | -10 / +10 |
| Corrective course | -15 / +10 |

Note: Minus (-) is below design level and plus (+) is above design level.

5.5.2 Matching Existing Surface Levels

Where the new asphalt wearing course is required to match the surface levels of an existing road structure (e.g. tie-in to existing pavement or bridge joints, pavement gutter, utility access point, etc), construct the pavement such that its surface levels match the surface levels of the existing road structure and its surface does not pond water.

Dispositions for nonconformity must be approved before a subsequent course is placed.

5.6 SURFACE SHAPE

The surface of the course including longitudinal and transverse joints must not pond water.

The surface shape of the course within and across traffic lanes must not deviate from the bottom of the straightedge (refer to Clause 4.5) laid in any direction by more than the tolerances shown in Table R117.12.

Table R117.12 – Maximum Deviation From Straightedge (mm)

| Course | Through Carriageway < 70 kph Traffic Speed, Ramps and Roundabouts | Through Carriageway ≥ 70 kph Traffic Speed |
|---|---|---|
| Immediately after placing | – | – |
| Corrective Course | 15 | 10 |
| Intermediate Course | 10 | 5 |
| Wearing Course | 5 | 3 |
| Prior to placing overlying layer⁽¹⁾ | – | – |
| Corrective Course | 18 | 13 |
| Intermediate Course | 13 | 8 |
| 12 months after placing | – | – |
| Wearing Course | 8 | 6 |

Notes

⁽¹⁾ If longer than 1 month after placing.

5.7 RIDE QUALITY

The surface of the wearing course must have a smooth longitudinal profile.

When:

- (a) construction of the underlying pavement forms part of the Contract; or
- (b) the course comprises more than one layer of asphalt, including any corrective course, placed over a pavement constructed by others; or
- (c) the aim of the asphalt paving work is to improve the ride quality;

the ride quality of each Lot must not exceed an IRI_S of 1.56 m/km.

Where a single layer of asphalt is placed over pavement constructed by others, the ride quality of each Lot must not exceed the IRI_{Sa} values determined as follows (refer to Clause 4.6):

$$IRI_{Sa} = 0.2 + (0.6 \times IRI_{Sb}), \text{ but not less than } 1.56 \text{ m/km}$$

where: IRI_{Sa} is the IRI_S after placing the asphalt layer (m/km)

IRI_{Sb} is the IRI_S before placing the asphalt layer (m/km)

5.8 TREATMENT OF NONCONFORMITIES

5.8.1 General

Where a Lot is nonconforming, submit to the Principal a Nonconformity Report and your proposed disposition for the Lot.

Dispositions for nonconformity of a placed layer must be approved and implemented before a subsequent layer is placed.

Where the surface shape of a surface to be paved has deviations from a straightedge exceeding the maximum deviations stated in Clause 5.6, carry out rectification of those areas before the subsequent layer is placed, unless directed otherwise by the Principal.

5.8.2 Non-homogeneous Work

You may propose to the Principal that placed asphalt which is non-homogeneous and/or contains segregated material be accepted. Any such proposal must be in writing and must:

- (a) state the technical reasons for acceptance;
- (b) show that the asphalt comply with the remaining requirements of the Specification;
- (c) sets out the extent of the nonconforming sub-Lots, taking into account any risk to the ride quality and future performance of the pavement structure.

5.8.3 Nonconforming Particle Size Distribution, Binder Content, Insitu Air Voids and Ride Quality

You may propose to the Principal in writing that Lots that are nonconforming with respect to combined particle size distribution, binder content, insitu air voids and ride quality be accepted with the pre-determined deductions specified in Annexure R117/B2, but subject to the limitations stated in Annexure R117/B2.

5.8.4 Rectification and Replacement

Notwithstanding Clauses 5.8.2 and 5.8.3, the Principal is not bound to accept any proposals for acceptance of nonconforming Lots.

Nonconforming Lots which are not accepted must be either rectified or replaced.

HOLD POINT

| | |
|------------------------|---|
| Process Held: | Rectification or replacement of a nonconforming Lot. |
| Submission Details: | Nonconformity Report and details of your proposal to rectify or replace the Lot. |
| Release of Hold Point: | The Principal will consider the submitted documents prior to authorising the release of the Hold Point. |

5.8.5 Cost of Rectification

The cost of rectifying, or removal and replacement, of nonconforming Lots, including any restoration work to any underlying or adjacent surface or structure which becomes necessary as a result of such rectification or replacement, will be borne by you.

ANNEXURE R117/A – PROJECT SPECIFIC REQUIREMENTS

Refer to Clause 1.2.1.

*NOTES TO TENDER DOCUMENTER: (Delete this boxed text after customising Annexure R117/A)**Complete Table R117/A.1 below by filling in the required details.**Where the pavement design details are shown on the Drawings, delete the table in its entirety and replace it with “As shown on the Drawings”. Retain the heading “Table R117/A.1 ...” to provide the context.**Where the pavement design details are not shown on the Drawings, and there are multiple pavement designs, extend Table R117/A.1 as required to show the details of each pavement design.***Table R117/A.1 – Pavement Design Details**

| Course | Layer | Nominal Size of Asphalt (mm) | Class of Binder | Specified Thickness (mm) |
|---------------------|--------------|-------------------------------------|------------------------|---------------------------------|
| Wearing course | | | | |
| Intermediate course | Layer 1 | | | |
| | Layer 2 | | | |
| | Layer 3 | | | |
| | Layer 4 | | | |
| Corrective course | Layer 1 | | | |
| | Layer 2 | | | |
| Footpath | | | | |

*NOTES TO TENDER DOCUMENTER: (Delete this boxed text after customising Annexure R117/A)**Complete Table R117/A.2 below by deleting whichever option is not applicable.**For the item under Clause 4.3.1, determination of course thickness is not required for work involving re-sheeting after milling.***Table R117/A.2 – Other Requirements**

| Clause | Description | Requirement |
|---------------|---|--------------------|
| 3.4.3 | Material Transfer Vehicle required for: | – |
| | - Wearing course | Yes / No |
| | - Intermediate courses | Yes / No |
| 3.4.4 | Placing by echelon paving required for: | – |
| | - Wearing course | Yes / No |
| | - Intermediate courses | Yes / No |

| Clause | Description | Requirement |
|---------------|---|--------------------|
| 3.8.1 | Trial section required | Yes / No |
| 4.3.1 | Determination of course thickness required | Yes / No |
| 4.6.1 | Measurement of ride quality required for: | – |
| | - Existing pavement | Yes / No |
| | - Finished pavement | Yes / No |
| Annex B1 | Measurement of asphalt quantity for payment purposes by | Mass / Area |

Other Project Specific Requirements:

List here other project specific requirements.

ANNEXURE R117/B – MEASUREMENT AND PAYMENT AND DISPOSITION OF NONCONFORMITIES

Refer to Clause 1.2.2.

B1 MEASUREMENT AND PAYMENT

Payment will be made for all costs associated with completing the work detailed in this Specification in accordance with the following Pay Items.

Where no specific pay items are provided for a particular item of work, the costs associated with that item of work are deemed to be included in the rates and prices generally for the Work Under the Contract.

Unless otherwise specified, a lump sum price for any of these items will not be accepted.

Measurement for payment of asphalt is either by mass or by area, specified in Table R117/A.2 in Annexure R117/A.

(a) Measurement by Mass

Where the quantity of asphalt for payment purposes is measured by mass, the unit of measurement is the “tonne”.

The Principal may approve measurement by batch weights using certified scales. The quantity of asphalt in place in the final work must be mutually agreed using the TfNSW Contract Quantity Agreement Sheet using the tally of the weigh bridge docket of delivered asphalt less the quantity of asphalt not incorporated in the Works.

Truck weighbridge dockets must be issued at a weighbridge certified by the NSW Office of Fair Trading and collected at the point of delivery.

(b) Measurement by Area

Where the quantity of asphalt for payment purposes is measured by area, the unit of measurement is the “square metre”.

The area will be determined from the dimensions shown on the Drawings or by measurements on site if not shown on the Drawings.

Pay Item R117P1 – Tackcoat

The rate must cover all costs associated with the application of the tackcoat in accordance with Clause 3.2, including supply of material and preparation of the surface to be paved.

The quantity of tackcoat for payment purposes is measured by volume and the unit of measurement is the “litre” of residual bitumen. The volume of residual bitumen is determined by applying a factor to the volume of bitumen used as obtained from sprayer tanker dipping’s.

Pay Item R117P2 – Light Duty Dense Asphalt in Corrective Courses

R117P2.1 5 mm Nominal Size

R117P2.2 7 mm Nominal Size

R117P2.3 10 mm Nominal Size

R117P2.4 14 mm Nominal Size

R117P2.5 20 mm Nominal Size

Pay Item R117P3 – Light Duty Dense Asphalt in Intermediate Courses

R117P3.1 10 mm Nominal Size

R117P3.2 14 mm Nominal Size

R117P3.3 20 mm Nominal Size

Pay Item R117P4 – Light Duty Dense Asphalt in Wearing Course

R117P4.1 5 mm Nominal Size

R117P4.2 7 mm Nominal Size

R117P4.3 10 mm Nominal Size

R117P4.4 14 mm Nominal Size

R117P4.5 Footpath mix

**Pay Item R117P5 – Light Duty Dense Asphalt Over Existing Pavement
(Levels Not Specified)**

R117P5.1 5 mm Nominal Size

R117P5.2 7 mm Nominal Size

R117P5.3 10 mm Nominal Size

R117P5.4 14 mm Nominal Size

R117P5.5 Footpath mix

**Pay Item R117P6 – Light Duty Dense Asphalt Over Existing Pavement
(Levels Specified)**

R117P6.1 5 mm Nominal Size

R117P6.2 7 mm Nominal Size

R117P6.3 10 mm Nominal Size

R117P6.4 14 mm Nominal Size

R117P6.5 Footpath mix

Pay Item R117P7 – Deductions and Incentives in accordance with Annexure R117/B2

R117P7.1 Deductions

R117P7.2 Incentives

Deductions and incentives under Pay Item R117P7 are not subject to rise and fall adjustments.

B2 DISPOSITION OF NONCONFORMITIES

Refer to Clause 5.8.

The deduction is applied to the schedule rate for the quantity of nonconforming asphalt in the Lot (or sub-Lot) represented by the test sample(s) and recorded against Pay Item R117P7.1.

B2.1 Combined Particle Size Distribution and Binder Content

Lots which are nonconforming with respect to combined particle size distribution and binder content will not be accepted under the following circumstances:

- (a) where the measured value is more than twice the production tolerance specified in Table R117.8 (refer to Clause 2.4.2);
- (b) where the cumulative deductions for each nonconformity with respect to combined particle size and binder content exceed 20%.

For other cases, the deductions shown in Table R117/B.1 will be applied to those nonconforming Lots with respect to combined particle size distribution and binder content which are accepted by the Principal.

Table R117/B.1 – Deductions for Nonconforming Combined Particle Size Distribution and Binder Content⁽¹⁾

| Description | Production Tolerance Exceedance ⁽²⁾ | Deductions (in % of Schedule Rate) |
|---|--|------------------------------------|
| Combined particle size distribution (AS sieve) | | |
| Pass 37.5 mm | Each 2% or part thereof | 1% |
| Pass 26.5 mm | Each 2% or part thereof | 1% |
| Pass 19.0 mm | Each 2% or part thereof | 1% |
| Pass 13.2 mm | Each 2% or part thereof | 1% |
| Pass 9.50 mm | Each 2% or part thereof | 1% |
| Pass 6.70 mm | Each 2% or part thereof | 1% |
| Pass 4.75 mm | Each 2% or part thereof | 1% |
| Pass 2.36 mm | Each 1% or part thereof | 1% |
| Pass 1.18 mm | Each 1% or part thereof | 1% |
| Pass 600 µm | Each 1% or part thereof | 1% |
| Pass 300 µm | Each 1% or part thereof | 2% |
| Pass 150 µm | Each 0.5% or part thereof | 2% |
| Pass 75 µm | Each 0.5% or part thereof | 2% |
| Binder content | | |
| 20 mm asphalt or smaller | Each 0.1% or part thereof | 3% |

Notes:

- (1) Refer to Clause 2.4.2 and Table R117.8 for production tolerances.
- (2) For combined particle size distribution: % by mass of total aggregate.
For binder content: % by mass of total asphalt mix.

B2.2 Insitu Air Voids

Lots which are nonconforming with respect to insitu air voids will not be accepted when the maximum characteristic value of insitu air voids exceeds the specified upper limit in Table R117.9 by more than 2.0%.

For other cases, the deductions shown in Table R117/B.2 will be applied to those nonconforming Lots with respect to characteristic insitu air voids which are accepted by the Principal.

Table R117/B.2 – Deductions for Nonconforming Insitu Air Voids

| Exceedance of Specified Upper Limit | Deduction (in % of Schedule Rate) |
|-------------------------------------|-----------------------------------|
| < 0.5% | 2.5% |
| 0.5% – 1.0% | 15% |
| 1.1% – 1.5% | 30% |
| 1.6% – 2.0% | 50% |

| Exceedance of Specified Upper Limit | Deduction (in % of Schedule Rate) |
|--|--|
| > 2.0% | Reject |

B2.3 Ride Quality

Lots which are nonconforming with respect to ride quality will not be accepted when the ride quality exceeds the specified limit by more than 0.80 m/km.

For other cases, the deductions shown in Table R117/B.3 will be applied to those nonconforming Lots with respect to ride quality which are accepted by the Principal.

Table R117/B.3 – Deductions for Ride Quality

| Exceedance of Specified Limit (m/km) | Deduction (in % of Schedule Rate) |
|---|--|
| < 0.25 | 2% |
| 0.25 – 0.43 | 4% |
| 0.44 – 0.61 | 8% |
| 0.62 – 0.80 | 16% |

B3 INCENTIVES

If a Lot of wearing course conforms to all requirements of this Specification, and the ride quality is conforming for all three adjacent Lots (for ride quality) in all directions, you may propose to the Principal in writing that pre-determined increases to the schedule rate be applied in accordance with Table R117/B.4 as incentives for improved ride quality of the wearing course.

Table R117/B.4 – Incentives for Ride Quality

| Ride Quality Below Specified Limit (m/km) | Incentive (in % of Schedule Rate) |
|--|--|
| < 0.44 | 0% |
| 0.44 – 0.61 | 1% |
| 0.62 – 0.80 | 2% |
| > 0.80 | 3% |

The increase is applied as incentive to the schedule rate for the quantity of asphalt in the Lot represented by the test results and recorded against Pay Item R117P7.2.

ANNEXURE R117/C – SCHEDULES OF HOLD POINTS AND IDENTIFIED RECORDS

Refer to Clause 1.2.3.

C1 SCHEDULE OF HOLD POINTS

| Clause | Description |
|---------------|---|
| 2.3.5 | Submission of nominated mix design details |
| 3.5.1 | Submission of paving and compaction temperature details to achieve conformity |
| 3.6.3 | Placing of asphalt in nonconforming layer thicknesses |
| 3.8.6 | Submission of verification checklists and test results from trial section |
| 5.8.4 | Submission of Nonconformity Report and proposed dispositions |
| Annex F | Progression to higher RAP Level |

C2 SCHEDULE OF IDENTIFIED RECORDS

The records listed below are Identified Records for the purposes of TfNSW Q.

| Clause | Description of Identified Record |
|-----------------|---|
| 2.1.4 (a) | RAP Management Plan |
| 2.1.6 | Documentary evidence of binder conformity for asphalt used in the Works |
| 2.3.3 | Nominated mix design details |
| 2.4.3, 2.4.5 | Asphalt manufacturing process parameters including process temperatures |
| 3.2.4 | Daily record of average tackcoat application rate in each Lot |
| 3.3.1 | Surface temperature and weather conditions at time of paving |
| 3.5 | Asphalt temperature at time of initial compaction |
| 3.8 | Verification checklist and all listed test reports of trial section for each combination of materials, mix proportions, equipment, rate of paving and methods for placement, compaction and finishing |

ANNEXURE R117/D – PLANNING DOCUMENTS

Refer to Clause 1.2.4. The following documents are a summary of documents that must be included in the PROJECT QUALITY PLAN. Review the requirements of this Specification and others included in the Contract to determine additional documentation requirements.

| Clause | Planning Documents |
|---------------|--|
| 2.1 | For each constituent material, Lot/stockpile sizes, method of defining each Lot and allocating a unique Lot Number |
| | Handling and storage of each constituent material |
| | Nominated particle size distribution and tolerances |
| 2.3 | Development and authorisation of nominated mix submission |
| 2.4 | For each nominated mix, method of defining each Lot and allocating a unique Lot Number |
| | Calibration of the asphalt manufacturing plant, including all weigh scales, flowmeters and thermometers |
| | Storage and handling of binder, including identification and prevention of segregation and/or contamination |
| | Process control, including plant operating instructions, key temperature targets and records, and response to process control charts |
| | Control of plant feed proportions, including regular checks on grading and moisture content |
| | Daily asphalt manufacturing plan to ensure timely and uninterrupted progress on site |
| 2.5 | Loading, delivery and unloading procedures that maintain adequate mix temperature and do not interrupt progress of the paving train |
| | Method of application and control of release agent |
| 3 | For each paving and related activity, method of defining each Lot and allocating a unique Lot Number |
| | Process control for surface preparation, tackcoating, placing asphalt, joint construction, compaction and clean up, including plant operating instructions, key temperature targets and records, patterns for paving and compaction operations, and process monitoring |
| 3.3 | Measurement and recording of pavement temperatures and weather conditions |
| 3.4 | Allocation of appropriate plant and equipment, including backup in case of breakdown |
| | Rolling pattern, including roller type and number of passes |
| 3.5 | Paving and compaction temperatures |
| | Calibration of all thermometers and other measuring equipment |
| 3.6.2 | Nominated layer thicknesses where not specified on the Drawings |
| 3.7 | Procedure for construction joints |
| 3.8 | Design, execution and quality verification of trial section |
| 4 | Inspection and test plan, including methods and frequencies of sampling, methods and frequencies of testing, verification checklists, and timeframe for submission of test results |

ANNEXURE R117/E – USE OF RHYOLITE AGGREGATES IN SKID RESISTANT MIXES

Rhyolite aggregates are currently sourced from Gosforth (near Maitland) in NSW, and are used in skid resistant asphalt mixes.

E1 PHYSICAL PROPERTIES

E1.1 General

Rhyolite aggregates must comply with TfNSW 3152, and the following additional requirements or exceptions under the Clauses E1.2 to E1.4.

E1.2 Polished Aggregate Friction Value

Refer also to Clause 2.1.2.

Where rhyolite aggregate is used for its high Polished Aggregate Friction Value, 100% of the coarse aggregates in the asphalt must be rhyolite aggregate.

Rhyolite crusher dust must not be used in the mix.

E1.3 Wet/Dry Strength Variation

Where the wet/dry strength variation exceeds the specified maximum value of 35%, seek advice and approval from the TfNSW Pavements Unit on the use of the rhyolite aggregates.

E1.4 Water Absorption

Water absorption of between 3% and 6%, which occurs in rhyolite aggregates from Gosforth and exceeds the maximum of 2.5% specified in TfNSW 3152, is acceptable but subject to the requirement under Clause E2.5.

E2 MIX DESIGN

E2.1 General

Design of asphalt mixes containing rhyolite aggregates must comply with Clauses 2.2 and 2.3, and the following additional requirements under Clauses E2.2 to E2.5.

E2.2 Air Voids in Laboratory Compacted Mix

(a) Laboratory compacted mix

Refer also to Clause 2.2.2.

Air void testing must be done on samples with 80 cycles of gyratory compaction.

(b) Production trial

Refer also to Clause 2.3.2.

Air void testing must be done on samples with 80 and 350 cycles of gyratory compaction.

E2.3 Oven Conditioning of Asphalt Samples

Where oven conditioning of samples of asphalt containing rhyolite is required by a test method, the conditioning period must be equivalent to the sum total of the estimated storage time (if applicable) plus the haulage time to the job site plus 30 minutes, or a minimum of 1 hour, whichever is the greater.

E2.4 Use of Hydrated Lime

Use of hydrated lime as a constituent material in the asphalt is optional, but the higher dry compacted voids (DCV) of hydrated lime must be considered in the mix design, as this may adversely impact the workability of the mix.

E2.5 Allowance for Higher Binder Absorption

Carry out your mix design using the volumetric principles in AS 2891.8.

Make allowance in the mix design for the higher rate of absorption of binder into the rhyolite aggregate during manufacture and transport.

E3 PRODUCTION

E3.1 General

Asphalt mixes containing rhyolite aggregates must comply with Clause 2.4, and the following additional requirements under Clauses E3.2 and E3.3.

E3.2 Water Absorption

Monitor the water absorption of the rhyolite aggregates during production. If the weighted average aggregate water absorption changes by $\pm 1\%$, re-design the mix and submit a new nominated mix design. The Hold Point in Clause 2.3.5 will again apply.

E3.3 Storage

As the amount of bitumen absorbed by the rhyolite aggregate is time dependent, asphalt mixes containing rhyolite aggregates can be held in hot storage bins for an extended period of time only if an allowance for the reduction in effective bitumen through bitumen absorption has been made in the mix design.

ANNEXURE R117/F – RAP APPROVAL LEVEL PROGRESSION**F1 GENERAL**

To progress from the existing RAP Approval Level to a higher Approval Level, you must demonstrate:

- (a) compliance with this Specification, including the requirements for RAP Level progression set out in Clause F2;
- (b) compliance with the Performance Period (refer to Clause 1.3.1 for definition of “Performance Period”) shown in Table R117.4 corresponding to the higher Approval Level applied for.

For warm mix asphalt containing RAP material, its RAP Approval Level may not progress beyond Level 1L or Level 1WL.

HOLD POINT

| | |
|------------------------|--|
| Process Held: | Progression to a higher RAP Approval Level. |
| Submission Details: | Documentation demonstrating compliance with the Performance Period corresponding to the higher RAP Approval Level applied for. |
| Release of Hold Point: | The Principal will consider the submitted documentation prior to authorising the release of the Hold Point. |

F2 PROCESS

To progress to a higher RAP Approval Level, demonstrate that you have met the testing requirements in Tables R117/F.1.

Table R117/F.1 – RAP Level Progression Criteria

| Stage | Testing |
|--|--|
| Section A | |
| At time of nominated mix design submission, thereafter annually | <ol style="list-style-type: none"> (a) Particle size distribution of RAP aggregate washed in solvent and tested in accordance with AS 1141.11.1 (b) Binder content of RAP in accordance with AS/NZS 2891.3.1 (c) Binder recovery of RAP in accordance with either AG:PT/T191 or ASTM D5404 (d) Recovered binder dynamic viscosity at 60°C of RAP in accordance with either AG:PT/T192 or AS 2341.3 (e) Quality of RAP aggregate washed in solvent to comply with TfNSW 3153 |
| During asphalt production for contract (frequency: each Lot of RAP used) | <ol style="list-style-type: none"> (a) Particle size distribution of RAP aggregate washed in solvent and tested in accordance with AS 1141.11.1 (b) Binder content of RAP in accordance with AS/NZS 2891.3.1 |

| Stage | Testing |
|--|--|
| During asphalt production for contract (frequency: daily on RAP used in asphalt) | (a) Moisture content of RAP in accordance with AS/NZS 2891.10 (b) Visual monitoring of incoming RAP by a person experienced in the process |
| Section B | |
| During asphalt production for contract, including during trial section (frequency: annually and at change in nominated mix design) | All testing required in Section A, plus: (a) Moisture sensitivity of asphalt containing RAP in accordance with TfNSW T640 (b) Moisture sensitivity of asphalt containing RAP in accordance with TfNSW T649 |

ANNEXURES R117/G TO R117/J – (NOT USED)

ANNEXURE R117/K – CALCULATIONS OF CHARACTERISTIC VALUES

K1 CALCULATION OF CHARACTERISTIC VALUES OF INSITU AIR VOIDS

Calculate the minimum (lower) and maximum (upper) characteristic values, designated V_L and V_U respectively, for insitu air voids of the Lot as follows:

$$V_L = \bar{a} - ks \quad V_U = \bar{a} + ks$$

where: s = the standard deviation of sub-Lot air voids, expressed as a percentage

k = value stated in TfNSW Q Annexure Q/L Clause L3.2

\bar{a} = arithmetic mean of insitu air voids, expressed as a percentage, for all sub-Lots

and
$$a = \left(\frac{MD - BD}{MD} \right) \times 100\%$$

MD = mean maximum density of the Lot, with individual maximum density values determined in accordance with AS/NZS 2891.7.1 or AS/NZS 2891.7.3

BD = bulk density of the sub-Lot determined in accordance with:

- (i) AS/NZS 2891.9.2 for cores
- (ii) AS/NZS 2891.14.2 and AS/NZS 2891.14.3 for nuclear density gauge

Round and report the values of V_L and V_U to the nearest 0.1%.

K2 CALCULATION OF CHARACTERISTIC VALUE OF THICKNESS

Calculate the minimum (lower) and maximum (upper) characteristic values, designated T_L and T_U respectively, for thickness of the Lot as follows:

$$T_L = \bar{x} - ks \quad T_U = \bar{x} + ks$$

where: s = the standard deviation of sub-Lot attribute test results

k = value stated in TfNSW Q Annexure Q/L Clause L3.2 (mm)

x = the average height of a core based on measurements taken at four equidistant points at the circumference of the core (mm)

\bar{x} = the arithmetic mean of attribute test results for all sub-Lots (mm)

Round and report the values of T_L and T_U to the nearest whole millimetre.

ANNEXURE R117/L – MINIMUM FREQUENCY OF TESTING

The minimum frequency of testing of constituent materials, and of asphalt during production, placing and in the finished pavement are listed in Tables R117/L.1 to R117/L.5.

Table R117/L.1 – Constituent Material Properties

| Clause | Constituent | Minimum Frequency of Testing |
|-----------|-----------------------------|---------------------------------------|
| 2.1.2 | Coarse aggregates | As per TfNSW 3152 |
| 2.1.3 | Fine aggregates | |
| 2.1.4 (a) | RAP material | As per TfNSW 3153 and Annexure R117/F |
| 2.1.4 (b) | Granulated glass aggregates | As per TfNSW 3154 |
| 2.1.5 | Added fillers | As per TfNSW 3211 |
| 2.1.6 | Binder | As per TfNSW 3252 and TfNSW 3253 |
| 2.1.8 | Bitumen emulsion tackcoat | As per AS 1160 |

Table R117/L.2 – Production Asphalt Properties

| Clause | Characteristic | Test Method | Minimum Frequency of Testing |
|-----------|--|---|---|
| 2.1.5 | Total filler in asphalt | | One per 10,000 tonnes or part thereof used in asphalt production, and at change in source of mineral matter |
| | - Dry compacted voids | AS/NZS 1141.17 | |
| | - Methylene blue value | TfNSW T659 | |
| 2.2.1 (a) | Combined particle size distribution | AS/NZS 2891.3.1 | As per Table R117/L.3 |
| 2.2.1 (b) | Binder content | | |
| 2.2.2 | VMA at 80 cycles | AS/NZS 2891.2.2, AS/NZS 2891.7.1 or AS/NZS 2891.7.3, AS/NZS 2891.8, AS/NZS 2891.9.2 | As per Table R117/L.3 |
| 2.2.2 | Air voids in laboratory compacted mix at 80 cycles | | |
| 2.2.2 | Moisture content | AS/NZS 2891.10 | One per shift per mix type |
| 2.4.5 | Production temperature of asphalt | Your documented procedure | As per PROJECT QUALITY PLAN |
| | Despatch temperature of asphalt | | Each delivered load |

Table R117/L.3 – Minimum Frequency of Testing of Asphalt

| Quantity of Asphalt Supplied in Each Shift ⁽¹⁾ | Minimum Frequency of Testing |
|---|------------------------------------|
| Less than 100 tonnes | One per 100 tonnes or part thereof |
| 101 to 300 tonnes | One per 150 tonnes or part thereof |

| Quantity of Asphalt Supplied in Each Shift ⁽¹⁾ | Minimum Frequency of Testing |
|---|------------------------------------|
| 301 to 600 tonnes | One per 200 tonnes or part thereof |
| Over 600 tonnes | One per 250 tonnes or part thereof |

Note:

⁽¹⁾ Refer to Clause 1.3.1 for definition of “shift”.

Table R117/L.4 – Asphalt Placing

| Clause | Property | Test Method | Minimum Frequency of Testing |
|--------|--------------------------------------|---------------------------|-------------------------------|
| 3.2 | Tackcoat application rate | Your documented procedure | Each paving Lot |
| 3.3 | Surface temperature Wind velocity | | One measurement every 2 hours |
| 3.5 | Temperature at initial compaction | | Each delivered load |

Table R117/L.5 – Placed Asphalt Properties

| Clause | Property | Test Method | Minimum Frequency of Testing |
|--------|---------------------------------------|-------------------|---|
| 5.2 | Homogeneity | Visual assessment | Each paving Lot |
| 5.3 | Insitu air voids | Clause 4.2 | As specified for relative compaction > 100.0% in TfNSW Q Clause L3.1 |
| 5.4 | Course thickness | Clause 4.3 | From cores: as for insitu air voids above By survey: as for course position below |
| 5.5 | Course position | Clause 4.4 | TfNSW G71 Clause 5.3.3 |
| 5.6 | Surface shape | TfNSW T183 | – |
| | - Within lane | | One measurement in longitudinal direction and 1 measurement in transverse direction every 60 m ² |
| | - Longitudinal joint excluding crowns | | One measurement per 20 lineal metres or adjacent to within lane measurements whichever is the lesser |
| | - Transverse joint | | One measurement in each wheel path in each lane except at the boundaries of the Site |
| 5.7 | Ride quality | TfNSW T188 | Each Lot as defined in TfNSW T188 |

ANNEXURE R117/M – REFERENCED DOCUMENTS

Refer to Clause 1.2.6.

TfNSW QA Specifications

| | |
|------------|---|
| TfNSW G10 | Traffic Management |
| TfNSW G71 | Construction Surveys |
| TfNSW Q | Quality Management System |
| TfNSW R101 | Cold Milling of Road Pavement Materials |
| TfNSW 3152 | Aggregates for Asphalt |
| TfNSW 3153 | Reclaimed Asphalt Pavement Material |
| TfNSW 3154 | Granulated Glass Aggregate |
| TfNSW 3211 | Cements, Binders and Fillers |
| TfNSW 3252 | Polymer Modified Binder for Pavements |
| TfNSW 3253 | Bitumen for Pavements |

TfNSW Test Methods

| | |
|------------|---|
| TfNSW T183 | Surface Deviation Using a Straightedge |
| TfNSW T188 | Project Ride Quality (Vehicular Laser Profilometer) |
| TfNSW T640 | Propensity for Moisture Damage in Asphalt (Specimens moulded in the laboratory) |
| TfNSW T649 | Propensity for Moisture Damage in Asphalt (Cores) |
| TfNSW T659 | Methylene Blue Adsorption Value of Road Construction Material |

Australian Standards

| | |
|-----------------|---|
| AS 1141 | Methods for sampling and testing aggregates |
| AS 1141.11.1 | Particle size distribution – Sieving method |
| AS/NZS 1141.17 | Voids in dry compacted filler |
| AS 1160 | Bituminous emulsions for construction and maintenance of pavements |
| AS 2150 | Asphalt – A guide to good practice |
| AS 2341.3 | Methods of testing bituminous and related roadmaking products - Determination of kinematic viscosity by flow through a capillary tube |
| AS/NZS 2891 | Methods of sampling and testing asphalt |
| AS/NZS 2891.1.1 | Sampling – Loose asphalt |
| AS 2891.1.2 | Sampling – Coring method |
| AS/NZS 2891.2.2 | Sample preparation - Compaction of asphalt test specimens using a gyratory compactor |
| AS/NZS 2891.3.1 | Bitumen content and aggregate grading – Reflux method |
| AS/NZS 2891.7.1 | Determination of maximum density of asphalt – Water displacement method |

| | |
|------------------|--|
| AS/NZS 2891.7.3 | Determination of maximum density of asphalt – Methylated spirit displacement |
| AS/NZS 2891.8 | Voids and density relationships for compacted asphalt mixes |
| AS/NZS 2891.9.2 | Determination of bulk density of compacted asphalt – Presaturation method |
| AS/NZS 2891.10 | Moisture Content of Asphalt |
| AS/NZS 2891.14.2 | Field density tests - Determination of field density of compacted asphalt using nuclear thin-layer density gauge |
| AS/NZS 2891.14.3 | Field density tests - Calibration of nuclear thin-layer density gauge using standard blocks |

Austrroads Documents

| | |
|------------|--|
| AG:PT-T191 | Extractions of Bituminous Binder from Asphalt |
| AG:PT-T192 | Characterisation of the Viscosity of Reclaimed Asphalt Pavement (RAP) Binder Using the Dynamic Shear Rheometer (DSR) |
| AG:PT-T231 | Deformation Resistance of Asphalt Mixtures by the Wheel Tracking Test |
| AG:PT-T233 | Fatigue Life of Compacted Bituminous Mixes Subject to Repeated Flexural Bending |
| AG:PT-T237 | Binder Film Index |
| AGPT04B | Guide to Pavement Technology Part 4B: Asphalt |

Other Standards

| | |
|------------|---|
| ASTM D5404 | Standard Practice for Recovery of Asphalt from Solution Using the Rotary Evaporator |
|------------|---|

AfPA (AAPA) Documents

| | |
|-----------------|---|
| Advisory Note 7 | Guide to the Heating and Storage of Binders for Sprayed Sealing |
| IG-3 | Asphalt Plant Process Control Guide |
| | Reclaimed Asphalt Pavement (RAP) Management Plan |