Amend **Section 401 – HOT MIX ASPHALT (HMA) PAVEMENT** to read as follows:

"SECTION 401 - HOT MIX ASPHALT (HMA) PAVEMENT

401.01 Description. This section describes furnishing and placing HMA pavement on a prepared surface. For the purpose of this section, the definition for the term Polymer Modified Asphalt (PMA) is Mix IV that uses PG 64E-22 as a binder.

401.02 Materials.

Asphalt Cement (Mix IV) (PG 64-16) 702.01

Asphalt Cement (PMA Mix) (PG 64E-22) 702.01

Performance Graded (PG) Binder. Performance graded binder shall conform to Performance Graded Asphalt Binder Specifications, AASHTO M 332 and meet the following additional requirement:

> AASHTO T 315 Determining the Rheological Properties of Asphalt Binder Using a Dynamic Shear Rheometer (DSR). Phase angle on original binder shall be less than 77 degrees.

Submit, before usage, a Certificate of Compliance, accompanied by substantiating test data, showing conformance with Performance Graded Asphalt Binder Specification. The Engineer will not accept the PG binder without adequate documentation.

PERFORMANCE GRADED BINDERS FOR SPECIFIC MIXES (Performance Graded Mixes)	
MIX	**BINDER***
Asphalt Cement for Surface Course (Mix IV)	PG 64-16
Asphalt Cement for Surface Course (PMA Mix)	PG 64E-22
*Neat asphalt with elastomer polymer modification shall be used to achieve the specified performance grading.	

Emulsified Asphalt 702.04

Warm Mix Asphalt Additive 702.06

Aggregate for Hot Mix Asphalt Pavement 703.09

Filler	703.15
Hydrated Lime	712.03

(A) General. HMA pavement shall be plant mixed and shall include mixture of aggregate and asphalt cement and may include reclaimed asphalt pavement (RAP) or filler, or both.

The manufacture of HMA may include warm mix asphalt (WMA) processes in accordance with these specifications. WMA processes include combinations of organic additives, chemical additives, and foaming.

HMA pavement shall include surface course and may include one or more binder courses, depending on HMA pavement thickness indicated in the contract documents.

RAP is defined as removed or reprocessed pavement materials containing asphalt and aggregates. Process RAP by crushing until 100 percent of RAP passes 3/4-inch sieve. Size, grade uniformly, and combine materials such that blend of RAP and aggregate material conforms to grading requirements of Subsection 703.09 - Aggregate for Hot Mix Asphalt Pavement.

In surface and binder courses, aggregate for HMA may include RAP quantities up to 20 percent of total mix weight. RAP shall not be used in stone matrix asphalt pavement.

Quantity of filler material to correct deficiencies in aggregate gradation passing the No. 200 sieve shall not exceed 3 percent by weight of fine aggregates.

(B) Job-Mix Formula and Tests. Design job-mix formula in accordance with procedures contained in current edition of Asphalt Institute's *Mix Design Methods for Asphalt Concrete and Other Hot Mix Types,* Manual Series No. 2 (MS-2) for either Marshall Method or Hveem Method of Mix Design.

Limit compacted lift thickness and asphalt content of job-mix formula as specified in Table 401.02-1 - Limits of Compacted Lift Thickness and Asphalt Content.

TABLE 401.02-1 - LIMITS OF COMPACTED LIFT THICKNESS AND ASPHALT CONTENT				
MIX NO.	**II**	**III**	**IV, PMA**	**V**
Minimum to Maximum Compacted Thickness for Individual Lifts (Inches)	2-1/4 to 3	2 to 3	1-1/2 to 3	1-1/4 to 3
Asphalt Content Limits (Percent of Total Weight of Mix)	3.8 to 6.1	4.3 to 6.1	4.3 to 6.5	4.8 to 7.0

Asphalt content limits for porous aggregate may be exceeded only if it is requested ahead of placement and is reviewed then accepted in writing by the Engineer.

Meet job-mix formula design criteria specified in Table 401.02-2 - Job-Mix Design Criteria for Performance Graded Binders.

TABLE 401.02-2 JOB-MIX DESIGN CRITERIA FOR PERFORMANCE GRADED BINDERS	
$N_{initial}$, N_{design}, N_{max}	8,100,160
Air Voids at N_{design}	4%
Voids in Mineral Aggregate (VMA) at N_{design} (for 1/2 inch Nominal Maximum Particle Size)	14.0% Minimum
Voids in Coarse Aggregate (VCA)	Less than VCA_{DRC}
Density at $N_{initial}$ (% of Theoretical Maximum Specific Gravity)	Not more than 89.0%
Density at N_{design} (% of Theoretical Maximum Specific Gravity)	96.0 %
Density at N_{max} (% of Theoretical Maximum Specific Gravity)	Not more than 98.0%
Stabilizer (by weight of total mix)	0.2 - 0.4 %

Minimum percent voids in mineral aggregates (VMA) of job-mix formula shall be as specified in Table 401.02-3 - Minimum Percent Voids in Mineral Aggregates (VMA).

TABLE 401.02-3 - MINIMUM PERCENT VOIDS IN MINERAL AGGREGATES (VMA)					
Nominal Maximum Particle Size, (Inches)	1-1/2	1	3/4	1/2	3/8
VMA, (percent)[1]	11.0	12.0	13.0	14.0	15.0
Notes: 1. VMA: See Asphalt Institute Manual MS-2, Chapter 4.					

(C) Submittals. Establish and submit job-mix formula for each type of HMA pavement mix indicated in the contract documents a minimum of 30 days before production. Job mix shall include the following applicable information:

(1) Design percent of aggregate passing each required sieve size.

(2) Design percent of asphalt content or PG binder material (type determined by type of mix) added to the aggregate (expressed as% by weight of total mix),

(3) Design proportion of processed RAP.

(4) Design temperature of mixture at point of discharge at paver or MTV.

(5) Source of aggregate.

(6) Grade of asphalt cement or PG binder.

(7) Type and percentage of stabilizer, or fiber

(8) Test data used to develop job-mix formula.

Except for item (4) in this subsection, if design requirements are modified after the Engineer accepts job-mix formula, submit new job-mix formula before using HMA produced from modified mix design. Submit any changes to the design temperature of mixture at point of discharge for acceptance by the Engineer.

Submit a certificate of compliance for the asphalt cement or PG binder, accompanied by substantiating test data from a certified testing laboratory.

The Contractor may use WMA processes in the production of HMA. Submit to the Engineer for acceptance, the proposed process and how it will be used in the manufacture of HMA. The process submittal shall include the temperature range of the WMA."

(D) Range of Tolerances for HMA. Provide HMA within allowable tolerances of accepted job-mix formula as specified in Table 401.02-4 - Range of Tolerances for Performance Graded Binders. These tolerances are not to be used for the design of the job mix, they are solely to be used during the testing of the production field sample of the HMA mix and its comparison with laboratory mix design.

TABLE 401-02-4 – RANGE OF TOLERANCES FOR PERFORMANCE GRADED BINDERS	
Passing 3/8 inch and larger sieves	±5.0
Passing No. 4 to No. 16 sieves (inclusive)	±4.0
Passing No. 30 to No. 100 sieves (inclusive)	±3.0
Passing No. 200 sieve	±2.0
Binder Content (expressed as% by weight of total mix)	±0.4
Temperature of Mixture	± 20
Voids, total mix	± 1.0

401.03 Construction.

(A) Weather Limitations. Placement of HMA will not be allowed under the following conditions:

(1) On wet surfaces, e.g., surface with ponding or running water, surface that has aggregate or surface that appears beyond surface saturated dry, as determined by the Engineer.

(2) When air temperature is below 50 degrees F and falling. HMA may be applied when air temperature is above 40 degrees F and rising. Air temperature will be measured in shade and away from artificial heat.

(3) When weather conditions prevent proper method of construction.

(B) Equipment.

(1) Mixing Plant. Use mixing plants that conform to AASHTO M 156, supplemented as follows:

(a) All Plants.

1. Automated Controls. Control proportioning, mixing, and mix discharging automatically. When RAP is incorporated into mixture, provide positive controls for proportioning processed RAP.

2. Dust Collector. AASHTO M 156, Requirements for All Plants, Emission Controls is amended as follows:

Equip plant with dust collector. Dispose of collected material. In the case of baghouse dust collectors, dispose of collected material or return collected material uniformly.

3. Modifications for Processing RAP. When RAP is incorporated into mixture, modify mixing plant in accordance with plant manufacturer's recommendations to process RAP.

(b) Drum Dryer-Mixer Plants.

1. Bins. Provide separate bin in cold aggregate feeder for each individual aggregate stockpile in mix. Use bins of sufficient size to keep plant in continuous operation and of proper design to prevent overflow of material from one bin to another.

2. Stockpiling Procedures. Separate aggregate into at least three stockpiles with different gradations as follows: coarse, intermediate, and fine. Separate aggregates for Mix V into at least two stockpiles. Stockpile RAP separately from virgin aggregates.

3. Checking Aggregate Stockpile. Check condition of the aggregate stockpile often enough to ensure that the aggregate is in optimal condition.

(c) Batch and Continuous Mix Plants.

1. Hot Aggregate Bin. Provide bin with three or more separate compartments for storage of screened aggregate fractions to be combined for mix. Make partitions between compartments tight and of sufficient height to prevent spillage of aggregate from one compartment into another.

2. Load Cells. Calibrated load cells may be used in batch plants instead of scales.

(2) Hauling Equipment. Use trucks that have tight, clean, smooth metal beds for hauling HMA.

Thinly coat truck beds with a minimum quantity of non-stripping release agent to prevent mixture from adhering to beds. Diesel or petroleum-based liquid release agents, except for paraffin oil, shall not be used. Drain excess release agent from truck bed before loading with HMA.

Provide a designated clean up area for the haul trucks.

Equip each truck with a tarpaulin conforming to the following:

(a) In good condition, without tears and holes.

(b) Large enough to be stretched tightly over truck bed, completely covering mix thereby aiding in keeping the mix unexposed to ambient air and aid in keeping the mix hot.

(3) Asphalt Pavers. Use asphalt pavers that are:

(a) Self-contained, power-propelled units.

(b) Equipped with activated screed or strike-off assembly, heated if necessary.

(c) Capable of spreading and finishing courses of HMA mixtures in lane widths applicable to typical section and thicknesses indicated in the Contract Documents.

(d) Equipped with receiving hopper having sufficient capacity for uniform spreading operation.

(e) Equipped with automatic feed controls to maintain uniform depth of material ahead of screed.

(f) Equipped with automatic screed controls with sensors capable of sensing grade from outside reference line, sensing transverse slope of screed, and providing automatic signals to control screed grade and transverse slope.

(g) Capable of operating at constant forward speeds consistent with satisfactory laying of mixture.

(h) Equipped with a means of preventing the segregation of the coarse aggregate particles from the remainder of the bituminous plant mix when that mix is carried from the paver hopper back to the paver augers. The means and methods used shall be approved by the paver manufacturer and may consist of chain curtains, deflector plates, or other such devices and any combination of these.

The following specific requirements shall apply to the identified bituminous pavers:

1. **Blaw-Knox Bituminous Pavers.** Blaw-Knox bituminous pavers shall be equipped with the Blaw-Knox Materials Management Kit (MMK).

2. **Cedarapids Bituminous Pavers.** Cedarapids bituminous pavers shall be those that were manufactured in 1989 or later.

3. **Barber-Green/Caterpillar Bituminous Pavers.** Barber-Green/Caterpillar bituminous pavers shall be equipped with deflector plates as identified in the December 2000 Service Magazine entitled “New Asphalt Deflector Kit {6630, 6631, 6640}”.

Bituminous pavers not listed above shall have similar attachments or designs that shall make them equivalent to the bituminous pavers listed above. The Engineer will solely decide if it is equal to or better that the setups described for the equipment listed above.

Submit for review and acceptance, prior to the start of using the paver for the placing of plant mix, a full description in writing of the means and methods that will be used to prevent the bituminous paver from having both aggregate and temperature segregation. Use of any paver that has not been accepted is prohibited until acceptance of the paver is received from the Engineer. Any pavement placed with an unaccepted paver will be regarded as not compliant work and may not be paid for and may require removal.

Supply a Certificate of Compliance that verifies that the manufacturer's approved means and methods used to prevent bituminous paver from having both aggregate and temperature segregation have been implemented on all pavers used on the project and are working in accordance with the manufacturer's requirements and Contract Documents.

(4) Rollers. Rollers shall be self-propelled, steel-tired tandem, pneumatic-tired, or vibratory-type rollers capable of reversing without shoving or tearing the just placed HMA mixture. Provide sufficient number, sequencing, type, and rollers of sufficient weight to compact the mixture to required density while mixture is still in workable condition unless otherwise indicated in the Contract Documents. Equipment shall not excessively crush aggregate. Operate rollers in accordance with manufacturer's recommendations and Contract Documents. The use of intelligent compaction is encouraged and may be required elsewhere in the Contract Documents.

(a) Steel-Tired Tandem Rollers. Steel-tired tandem rollers used for initial breakdown or intermediate roller passes shall have minimum gross weight of 12 tons and shall provide minimum 250-pound weight per linear inch of width on drive wheel.

Steel-tired tandem rollers used for finish roller passes shall have minimum total gross weight of 3 tons.

Do not use roller with grooved or pitted rolling drum or worn scrapers or wetting pads. Replace excessively worn scrapers and wetting pads before use.

(b) Pneumatic-Tired Rollers. Pneumatic-tired rollers shall be oscillating-type, equipped with smooth-tread pneumatic tires of equal size and diameter. Maintain tire pressure within 5 pounds per square inch of designated operational pressure when hot. Space tires so that gaps between adjacent tires are covered by following set of tires.

Pneumatic-tired rollers used for breakdown or intermediate roller passes shall have a ballast capable of establishing an operating weight per tire of not less than 3,000 pounds. Equip rollers with tires having minimum 20-inch wheel diameter with tires inflated to 70 to 75 pounds per square inch pressure when cold and 90 pounds per square inch when hot. Equip rollers with skirt-type devices to maintain temperature of tires during rolling operations.

Pneumatic-tired rollers used for kneading finished asphalt surfaces shall have a ballast capable of establishing an operating weight per tire of not less than 1,500 pounds. Equip rollers with tires having minimum 15-inch wheel diameter with tires inflated to 50 to 60 pounds per square inch pressure. Equip rollers with skirt-type devices to maintain temperature of tires during rolling operations.

Pneumatic-tired rollers and rubber-tired equipment shall not be used on stone matrix asphalt pavement.

(c) Vibratory Rollers. Vibratory rollers shall be steel-tired tandem rollers having minimum total weight of 3 tons. Equip vibratory rollers with amplitude and frequency controls and speedometer. Operate vibratory roller in accordance with manufacturer's recommendations. For very thin lifts, 1 inch or less in thickness, vibratory rollers shall not be used in the vibratory mode. Instead, operate the unit in the static mode.

(5) Hand Tools. Keep hand tools used in production, hauling, and placement of HMA clean and free of contaminants. Diesel or mineral spirits or other cleaning material that is potentially deleterious to HMA may be used to clean hand tools providing:

(a) It does not contaminate HMA with cleaning material.

(b) Clean hand tools over catch pan with capacity to hold all the cleaning material.

(c) Remove all diesel or mineral spirits or other cleaning material that is potentially deleterious to HMA from hand tools before using with HMA.

Hand tools used shall be in a condition such that it meets the requirements that it was manufactured for, e.g., a straightedge shall meet the straightness requirement of the manufacturer.

(6) Material Transfer Vehicle (MTV).

(a) Usage. MTV usage applies to surface courses of paving projects on all Islands except Lanai, unless otherwise indicated in the Contract Documents. When placing HMA surface use MTV to independently deliver mixtures from hauling equipment to paving equipment. MTV usage will not be required for the following:

1. Projects with less than 1,000 tons of HMA.

2. Temporary pavements.

3. Bridge deck approaches.

4. Shoulders.

5. Tapers.

6. Turning lanes.

7. Driveways.

8. Areas with low overhead clearances.

(b) Equipment. When using MTV, install minimum 10-ton-capacity hopper insert in conventional paver hopper. Provide the following equipment:

1. High-capacity truck unloading system in MTV capable of receiving HMA from hauling equipment.

2. MTV storage bin with minimum 15-ton capacity.

3. An auger mixing system in one of the following: the MTV storage bin, or paver hopper insert, or paver hopper to continuously mix HMA prior to discharging to the paver's conveyor system.

Avoid stop-and-go operations by coordinating plant production rate, number of haul units, and MTV and paver speeds to provide a continuous, uniform, segregation-free material flow and smooth HMA pavement. Maintain uniform paver speed to produce smooth pavements.

(c) Performance Evaluation. Evaluate the performance of MTV and mixing equipment by measuring mat temperature profile immediately behind paver screed on first day of paving and when it feels the need to do so due to perceived changes in performance or as directed by the Engineer.

Use a hand-held temperature device that has been calibrated within the past 12 months. It shall be an infrared temperature gun is capable of measuring in one degree or finer increments between the temperatures of 80 degrees to 400 degrees F with a laser to indicate where the temperature reading is being taken. Six temperature profile measurements shall be taken of mat surface using infrared temperature gun at 50-foot intervals behind paver. Each temperature profile shall consist of three surface temperature measurements taken transversely across the mat in approximately a straight line from screed while paver is operating. For each profile, temperatures shall be measured approximately 1 foot from each edge and in middle of mat. The difference between maximum and minimum temperature measurements for each temperature profile shall not exceed 10 degrees F. If any two or more temperature profiles exceeds the allowable 10-degree F temperature differential, halt paving operation and adjust MTV or mixing equipment to ensure that material placed by paver meets specified temperature requirements. Redo the measuring of mat temperature profile until adjustment of the MTV or mixing equipment is adequate. Submit all temperature profiles to the Engineer by next business day. Information on the report shall show location and temperature readings and time test was performed. Enough information shall be given, so the Engineer will be able to easily locate the test site of the individual measurement.

When requested temperature profile measurements shall be done in the presence of the Engineer.

Once adjustments are made, repeat measurement procedure for the next two placements to verify that material placed by paver meets specified temperature requirements. Terminate paving if temperature profile requirements are not met during repeated measurement procedure. If equipment fails to meet requirements after measurement procedure is repeated once, replace equipment before conducting any further temperature profile measurements

The Engineer may perform surface temperature profile measurements at any time during project. The Engineer may in lieu of a hand-held infrared temperature device use an infrared camera or device that is capable of measuring temperatures to locate cold spots. If such cold spots exist, the Engineer may require adjustments to the MTV.

If bleeding or fat spots occur in the pavement adjust means and methods to eliminate such pavement defects and perform remedial repair to pavement acceptable to the Engineer. Bleeding is defined as excess binder occurring on the surface of the pavement. It may create a shiny, glass-like, reflective appearance and may be tacky to the touch. Fat spots are localized bleeding.

(d) Transport.

1. Trailered MTV. Transport MTV by means of truck-tractor/trailer combination in accordance with Chapter 104 of Title 19, Department of Transportation, entitled “The Movement by Permit of Oversize and Overweight Vehicles on State Highways”.

2. Crossing Bridges for Self-Powered MTV. When self-powered MTV exceeds legal axle or total weight limits for vehicles under the HRS, Chapter 291, conform to the following when crossing bridges within project limits unless otherwise indicated in the Contract Documents:

a. Completely remove mix from MTV.

b. Move MTV at relatively constant speed not exceeding 5 miles per hour. MTV will not be allowed to stop on bridge.

c. No other vehicle or equipment will be allowed on bridge.

d. The MTV shall not attempt to cross a bridge where the posted load limit is less than or equal to the weight of the MTV empty. Permission to cross the bridge shall be obtained from the Engineer and HWY-DB in writing.

(C) Preparation of Surface. Clean existing pavement in accordance with Section 310 - Brooming Off. Apply tack coat in accordance with Section 407 - Tack Coat.

Where indicated in the Contract Documents, bring irregular surfaces to uniform grade and cross section by furnishing and placing one or more leveling courses of HMA Mix V. Spread leveling course in variable thicknesses to eliminate irregularities in existing surface. Place leveling course such that maximum depth of each course, when thoroughly compacted to the Contract Documents' requirements, does not exceed 3 inches.

In multiple-lift leveling course construction, spread subsequent lifts beyond edges of previously spread lifts in accordance with procedures contained in current edition of the Asphalt Institute's *Construction of Hot Mix Asphalt Pavements,* Manual Series No. 22 (MS-22) for leveling wedges.

Notify the Engineer of existing surfaces that may not be in a condition that will have enough strength to be a good bonding surface or foundation and should be removed or have remedial repairs done before new pavement placement.

(D) Plant Operation.

(1) Preparation of Asphalt Cement. Uniformly heat asphalt cement and provide continuous supply of heated asphalt cement from storage to mixer. Do not heat asphalt cement above 350 degrees F.

(2) Preparation of Aggregate. Dry and heat aggregate material at temperature sufficient to produce design temperature of job-mix formula. Do not exceed 350 degrees F. Adjust heat source used for drying and heating to avoid damage to and contamination of aggregate. When dry, aggregate shall not contain more than 1 percent moisture by weight.

For batch plants, screen aggregates immediately after heating and drying into three or more fractions. Convey aggregates into separate compartments ready for batching and mixing with asphalt cement.

(3) Mixing. Measure aggregate and asphalt; or aggregate, RAP, and asphalt into mixer in accordance with accepted job-mix formula. Mix until components are completely mixed and adequately coated with asphalt in accordance with AASHTO M 156. Percent of coated particles shall be 95 percent when tested in accordance with AASHTO T 195.

(4) Plant Inspection. For control and acceptance testing during periods of production, provide a testing laboratory next to plant that is acceptable to the Engineer. Provide space, utilities, and equipment required by the Engineer for performing specified tests. Do not start production of the project's HMA mix until the testing laboratory is acceptable to the Engineer. If the tests the Engineer needs to perform are not able to be done the mix shall not be used on the project unless the Engineer provides a waiver to this requirement.

(E) Spreading and Finishing. Prior to each day's paving operation, check screed or strike-off assembly surface with straight edge to ensure straight alignment and there is no damage or wear to the machine that will affect performance. Provide screed or strike-off assembly that produces finished surface without tearing, shoving, and gouging HMA. Discontinue using spreading equipment that leaves ridges, indentations, or other marks, or combination thereof in surface that cannot be eliminated by rolling or affects the final smoothness of the pavement or be prevented by adjustment in operation.

Maintain HMA at minimum 250 degrees F temperature at discharge to paver. Measure temperature of mix in hauling vehicle just before depositing into spreader or paver or MTV.

Deposit HMA in a manner that minimizes segregation. Raise truck beds with tailgates closed before discharging HMA.

Lay, spread, and strike off HMA upon prepared surface. Use asphalt pavers to distribute mixture.

Control horizontal alignment using automatic grade and slope controls from reference line, slope control device. Existing pavements or features shall not be used for grade control alone.

Obtain sensor grade reference, horizontal alignment by using established grade and slope controls. For subsequent passes, substitution of one ski with joint-matching shoe riding on finished adjacent pavement is acceptable. Use of a comparable non-contact mobile reference system and joint matching shoe is acceptable.

Avoid stop-and-go operation. Maintain a constant forward speed of paver during paving operation and minimize other methods that impact smoothness.

Offset longitudinal joint in successive lifts by approximately 6 inches. Incorporate into paving method an overlap of material of 1-inch +/- 0.5 inches at the longitudinal joint. The HMA overlap material shall be left alone when initially placed and shall not be bumped back or pushed back with a lute or any other hand-held device. If the overlap exceeds the maximum amount, remove the excess with a flat shovel, allowing recommended amount of overlap HMA material to remain in place to be compacted. Do not throw the removed excess HMA material on to the paving mat. The longitudinal joint in a surface course when total roadway width is comprised of two lanes shall be near the centerline of pavement or near lane lines when roadway is more than two lanes in width. The longitudinal joint shall not be constructed in the wheel path. Every effort should be made to not locate the longitudinal joint under the longitudinal lane lines. Make a paving plan drawing showing how the longitudinal joint will not located in these areas.

Control the horizontal alignment of the longitudinal edge of the HMA mat being installed so that the edge is parallel to the centerline or has a uniform alignment, e.g., the edge of the mat is straight line or uniform curve, no wavy edge, etc. to have a consistent amount of HMA material at the joint.

Check the compaction of the longitudinal joint during paving often enough to ensure that it will meet the compaction requirements.

If nuclear gauges are used as the contractor's quality control method, they shall be properly calibrated and periodically checked by comparison to cores taken from the pavement. The use of sand as an aid in properly seating the gauge may also be considered for improving the accuracy of the gauge.

In areas where irregularities or unavoidable obstacles make use of mechanical spreading and finishing equipment impracticable, spread, rake, and lute mixture by hand tools. For such areas, deposit, spread evenly, and screed mixture to required compacted thickness.

Demonstrate competence of personnel operating grade and crown control device before placing surface courses. If automatic control system becomes inoperative during the day's work, the Engineer will permit the Contractor to finish day's work using manual controls. The Engineer may also allow addition HMA to be ordered and placed using manual controls if it will provide a safer work site for the public to travel through. Do not resume work until automatic control system is made operative and will reliably function during the placement of HMA and has been demonstrated as being fully operational to the Engineer. The Engineer may waive requirement for electronic screed control device when paving gores, shoulders, transitions, and miscellaneous reconstruction areas where the use of the devices is not practical.

When production of HMA can be maintained and when practicable, use pavers in echelon shall be used to place surface course in adjacent lanes.

At the end of each workday; HMA pavement that is open to traffic shall not extend beyond the panel of the adjacent new lane pavement by more than distance normally placed in one workday. At end of each day's production, construct tapered transitions along all longitudinal and transverse pavement drop-offs; this shall apply to areas where existing pavement is to meet newly placed pavement. Use slopes of 6:1 for longitudinal taper transitions and 48:1 for transverse tapered transitions. Maximum drop-off height along the joints shall be 3 inches. Also, using a 48:1 slope provide a taper around any protruding object, e.g., manholes, drain boxes, survey monuments, inlets, etc., that may be above pavement surface when opened to the public. If the object is below the surface of the pavement then fill the depression until it is level with the surrounding pavement or raise depressed objects to the finish grade of the placed pavement. Remove and dispose of all transition tapers before placing adjoining panel or next layer of HMA. Notify traveling public of pavement drop-offs or raised objects with signs placed in every direction of traffic that may use and encounter pavement drop-offs or protruding objects or holes.

Use the same taper rates for areas where there is a difference in elevation due to construction work.

At end of each workweek, complete full width of the roadway’s pavement, including shoulders, to same elevation with no drop-offs.

(F) Compaction. Immediately after spreading and striking off HMA and adjusting surface irregularities, uniformly compact mixture by rolling.

Initiate compaction at highest mix temperature allowing compaction without excessive horizontal movement. Temperature shall not be less than 220 degrees F.

Finish rolling using tandem roller while HMA temperature is at or above 175 degrees F.

On superelevated curves, begin rolling at lower edge and progress to higher edge by overlapping of longitudinal trips parallel to centerline.

If necessary, repair damage immediately using rakes and fresh mix. Do not displace line and grade of HMA edges during rolling.

Keep roller wheels properly moistened with water or water mixed with small quantities of detergent. Use of excess liquid, diesel, and petroleum-based liquids will not be allowed on rollers.

Along forms, curbs, headers, walls and other places not accessible to rollers, compact mixture with hot hand tampers, smoothing irons, or mechanical tampers. On depressed areas, trench roller or cleated compression strips under roller may be used to transmit compression.

Before the start of compaction or during compaction or both remove pavement that is loose, broken, or contaminated, or combination thereof; pavement that shows an excess or deficiency in asphalt cement content; and pavement that is defective in any way. Replace with fresh HMA pavement of same type, and compact. Remove and replace defective pavement and compact at no increase in contract price or contract time.

Operate rollers at slow and uniform speed with no sudden stops. The drive wheels shall be nearest to the paver. Continue rolling to attain specified density and until roller marks are eliminated.

Rollers shall not be parked on the pavement place that day or shift.

(1) HMA Pavement Courses One and a Half Inches Thick or Greater. Where HMA pavement compacted thickness indicated in the Contract Documents is 1-1/2 inches or greater, compact to not less than 93.0 percent nor greater than 97.0 percent of the maximum specific gravity determined in accordance with AASHTO T 209, modified by deletion of Supplemental Procedure for Mixtures Containing Porous Aggregate.

Place HMA pavement in individual lifts that are within minimum and maximum allowable compacted thickness for various types of mixture as specified in Table 401.02-1 - Limits of Compacted Lift Thickness and Asphalt Content.

(2) HMA Pavement Courses Less Than One and a Half Inches Thick. Where HMA pavement compacted thickness indicated in the contract documents is less than 1-1/2 inches, compaction to a specified density will not be required.

Use only non-vibratory, steel-tired, tandem roller. Roll entire surface with minimum of two roller passes. A roller pass is defined as one trip of the roller in one direction over any one spot.

For intermediate rolling, roll entire surface with minimum of four passes of roller.

Finish rolling using steel-tired, tandem roller. Continue rolling until entire surface has been compacted with minimum of three passes of roller, and roller marks have been eliminated.

Do not use rollers that will excessively crush aggregate.

(3) HMA Pavement Courses One and a Half Inches Thick or Greater In Special Areas Not Designated For Vehicular Traffic. For areas such as bikeways that are not part of roadway and other areas not subjected to vehicular traffic, compact to not less than 90.0 percent of maximum specific gravity determined in accordance with AASHTO T 209, modified by deletion of Supplemental Procedure for Mixtures Containing Porous Aggregate. Increase asphalt content by at least 0.5 percent above that used for HMA pavements designed for vehicular traffic. Paved shoulders shall be compacted in the same manner as pavements designed for vehicular traffic.

(G) Joints, Trimming Edges and Utility Marking. At HMA pavement connections to existing pavements, make joints vertical to depth of new pavement. Saw cut existing pavement and cold plane in accordance with Section 415 - Cold Planing of Existing Pavement to depth equal to thickness of surface course or as indicated in the Contract Documents.

At HMA connections to previously placed lifts, form joints by cutting back on previous run to expose full depth of course. Dispose of material trimmed from edges. Protect end of freshly laid mixture from rollers.

Before and after paving, identify and mark location of existing utility manholes, valves, and handholes on finished surface. Adjust existing frames and covers and valve boxes to final pavement finish grade in accordance with Section 604 - Manholes, Inlets and Catch Basins and Section 626 - Manholes and Valve Boxes for Water and Sewer Systems.

(1) Longitudinal joints. Submit for review the means and methods that will be used to install longitudinal joints at the required compaction and density. The Engineer may allow a waiver to the Contract Documents by allowing the compaction of the HMA at the longitudinal joints to be no lower than 91.0 percent of the maximum specific gravity determined in accordance with AASHTO T 209, modified by deletion of Supplemental Procedure for Mixtures Containing Porous Aggregate. The air voids at the longitudinal joints shall not exceed 5 percent. Verify the compaction of the longitudinal joints meets the Contract Documents' requirements by using non-destructive testing methods during paving and submit the results on the daily quality control test reports.

Overband all longitudinal joints within the entire lot the non-compliant core represented with PG binder seal coat or other type of joint enrichment accepted by the Engineer when the longitudinal joints are found to have less than 93.0 percent but is no less than 90 percent of the maximum specific gravity or has an air void that exceeds 5 percent. The overband shall not decrease the skid resistance of the pavement under any ambient weather condition. Submit overband material's catalog cuts, test results and application procedure for review and acceptance by the Engineer before use. Center the overband over the longitudinal joint. The overband shall be placed in a uniform width and horizontal alignment. The overband shall have no holidays or streaking in its placement. The width of the overband shall be based on how the longitudinal joint was constructed or as directed by the Engineer. If a butt joint is used, the overband width shall be a minimum of 12-inches. For butt wedge or wedge joints the overband width shall be the width of the wedge plus an additional six-inches minimum. Replace any pavement markings damaged or soiled by the overband remedial repair process.

For longitudinal joints that have a compaction of less than 90 percent of the maximum specific gravity; removal may be required by the Engineer instead of overbanding the non-compliant joint. The Engineer will solely decide if removal or overbanding is required.

Persistent low compaction results may be cause to suspend work and remove non-conforming work. During the suspension of paving, revise means and methods used in constructing longitudinal joints and submit to the Engineer for review and acceptance. Suspension may occur when:

(1) Two or more longitudinal joints tests fail to meet the minimum compaction

(2) One sample reveals that the joint compaction is 90 percent or less.

(3) The maximum air void requirement exceeds 5 percent.

Test for compaction and density regardless of layer thickness. Compaction and density shall be determined by using six-inch diameter or larger cores instead of four-inch diameter cores. For longitudinal joints made using butt joints cores shall be taken over the joint with half of the core being on each side of the joint. For longitudinal joints using butt wedge joints, center core over the center of the wedge so that 50 percent of the material is from the most recently paved material and the remaining 50 percent of the core is from the material used to pave the previous layer. One core shall be taken at a maximum of every 250 feet of longitudinal joint and any fraction of that length for each day of paving with a minimum of three cores taken for each longitudinal joint per day. Cores taken for the testing of the longitudinal joint may be used to determine pavement thickness.

Compaction results for longitudinal joints until January 1, 2023 will not be included in any Sliding Scale Pay Factor for Compaction payment calculation. After, January 1, 2023 it will be included.

(H) HMA Pavement Samples. Obtain test samples from compacted HMA pavement within 72 hours of lay down. Provide minimum 4-inch diameter cores consisting of undisturbed, full-depth portion of compacted mixture taken at locations designated by the Engineer in accordance with the “Sampling and Testing Guide for Acceptance and Verification” in Hawaii DOT Highways Division, *Quality Assurance Manual for Materials*, Appendix 3. Turn cores over to Engineer immediately after cores have been taken. Before cores are taken inform Engineer so that the work may be observed by the Engineer and cores turned over to the Engineer at that time.

For pavement samples for longitudinal joints provide 6-inch diameter cores minimum. For pavement samples for other than longitudinal joints 4-inch diameter cores minimum shall be taken. All cores shall consist of undisturbed, full-depth portion of compacted mixture taken at locations designated by the Engineer in accordance with the “Sampling and Testing Guide for Acceptance and Verification” in Hawaii DOT Highways Division, *Quality Assurance Manual for Materials*, appendix 3. Coring of longitudinal joints shall use a modified HDOT Sampling and Testing Guide as required by the Contract Documents.

Cores that separate shall indicate to the Engineer that there is insufficient bonding of layers. Modify the previously used paving means and methods to prevent future debonding of layers. Debonding of a core sample after adjustment of the Contractor's methods will be an indication of continued non-conforming work and the Engineer may direct removal of the layer at no additional cost or contract time.

Restore HMA pavement immediately after obtaining samples. Clean core hole and walls of all deleterious material that will prevent the complete filling of the core hole and the bonding of the new HMA to the existing. Apply pavement joint cement to vertical faces of sample holes. Fill sampled area with new HMA pavement of same type as that removed. If hand compaction is used; fill in layers not exceeding the minimum thickness stated in Table 401.02-1 - Limits Of Compacted Lift Thickness And Asphalt Content and Compact. If Mechanical Compaction methods are used, then layers may be the maximum layer thickness stated in Table 401.02-1 - Limits Of Compacted Lift Thickness And Asphalt Content. Using tires or hand tamping to compact the HMA material to restore the pavement shall not be considered as mechanical compaction.

Only sample and test leveling course if 1-1/2 inches or greater. No compaction requirements for less than 1-1/2 inches.

(I) HMA Pavement Thickness Tolerances.

The Engineer will measure thickness of pavement by cores obtained by the Contractor in accordance with HDOT TM 09-19 Field Sampling Bituminous Material after Compaction (Obtaining Cores). The Engineer will measure cores in accordance with HDOT TM 09-19, except that measurement will be taken to nearest one thousandth of an inch; and average of such measurements will be taken to nearest one hundredth of an inch.

Thickness of finished HMA pavement shall be within 0.25 inch of thickness indicated in the Contract Documents. Pavement not meeting the thickness requirements of the Contract Documents may be required by the Engineer to be removed and replaced.

Corrective methods taken on pavement exceeding specified tolerances, e.g., insufficient thickness by methods accepted by the Engineer, including removal and replacement, shall be at no increase in contract price or contract time.

The checking of pavement thickness shall be done after all remedial repairs, e.g., smoothness compliance repairs, compaction, have been completed, reviewed and accepted by the Engineer.

(J) Quality Control Using New Technology. The Engineer and MTRB reserves the right to utilize new technology and methods to improve the detection of noncompliant work on the project. The technology or method may be used to locate defects in the work, e.g., ground penetrating radar to locate delaminations, moisture damage, thin sections, voids, non-compliant compaction, other non-destructive testing to locate flaws. The defect will be verified by the methods stated in the Contract Documents or by other established conventional means. If the technology or method has already been accepted elsewhere or has standardized testing procedures the results may be judged acceptable by the Engineer and no further testing will be required. These new technologies and methods may be used for the selection of sampling locations.

(K) Protection of HMA Pavement. Except for construction equipment directly connected with paving operations, keep traffic off HMA pavement.

Protect HMA pavement from damage until it has cooled and set.

Do not refuel equipment or clean equipment or hand tools over paved surfaces unless catch pan or device that will contain spilled fuel and other products is provided. After completion of refueling or cleaning, remove catch pan or device without spilling any of the collected content.

(L) Pavement Joint Adhesive

(1) Pavement Joint Adhesive on Joints. Use on all asphalt pavement construction where joints are formed at such locations but not limited to the following:

(a) Adjacent asphalt pavements, e.g., trafficked lanes, shoulders, etc.

(b) Asphalt pavement and adjacent concrete pavement or curb and gutter or any other surface where the bonding of the asphalt pavement and concrete surface is desired,

(c) Transverse joints between asphalt pavements not placed at the same time or if the pavement's temperature on one side of the joint is below the minimum temperature the mix can be at, during asphalt pavement compaction or installation.

(d) Entire wall and bottom of sample core holes in HMA pavement.

(e) Cut face of an existing pavement where it will have new HMA pavement placed against it, e.g., utility trenches, partial or full depth repairs, etc.

(f) Entire frame or face of a utility facility or similar feature that is to be imbedded in the asphalt pavement, e.g., manholes, pullboxes, handholes, survey monuments, valve boxes, etc.

Pavement joint adhesive is not required on a longitudinal construction joint between adjacent hot mix asphalt pavements formed by echelon paving. Echelon paving is defined as: paving multiple lanes side-by-side with adjacent pavers slightly offset at the same time.

A longitudinal construction joint between one shift's work and another shall have pavement joint adhesive applied at the joint. Any longitudinal construction joint formed with the temperature on one side of the joint that is below the minimum temperature, the mix can be, when compacted to contract requirements during asphalt pavement installation shall have pavement joint adhesive applied at the joint.

(2) Material requirements. Asphalt joint adhesive shall meet requirements as specified in Table 401.03-1 - Asphalt Joint Adhesive Specifications.

TABLE 401.03-1 – ASPHALT JOINT ADHESIVE SPECIFICATIONS		
TEST		**SPECIFICATION**
Brookfield Viscosity, 204 °C [**400 °F**]	ASTM D 3236	4,000-10,000 cp
Cone Penetration, 25 °C [**77 °F**]	ASTM D 5329	60-100 dmm
Resilience, 25 °C [**77 °F**]	ASTM D 5329	30% minimum
Ductility, 25 °C [**77 °F**]	ASTM D 113	30 cm minimum
Ductility, 4 °C [**39.2 °F**]	ASTM D 113	30 cm minimum
Tensile Adhesion, 25 °C [**77 °F**]	ASTM D 5329	500% minimum
Softening Point	ASTM D 36	77 °C [**170 °F**] min.
Asphalt Compatibility	ASTM D 5329	Pass

(3) Construction Requirements for Asphalt Joint Adhesive

(a) Equipment Requirements. Use a jacketed double boiler type melting unit, with both agitation and recirculation systems. Provide a pressure feed wand application system.

(b) Material Handling. Submit a copy of the manufacturer's recommendations for heating, re-heating, and applying the joint adhesive material. Follow manufacturer's recommendations. Do not remove the joint adhesive from the package until immediately before it is placed in the melter. Joint adhesive boxes must be clearly marked with the name of the manufacturer, the trade name of the adhesive, the manufacturer's batch and lot number, the application/pour temperature, and the safe heating temperature. Feed additional material into the melter at a rate equal to the rate of material used.

Verify the pouring temperature of the joint adhesive at least once per hour at the point of discharge. Stop production if the adhesive falls below the recommended application/pour temperature. When the temperature of the adhesive exceeds the maximum safe heating temperature, stop production, empty the melter, and dispose of that adhesive in an environmentally safe method. No payment will be made for this material or its disposal.

Do not blend or mix different manufacturer's brands or different types of adhesives.

(c) Joint Adhesive Application: The face of the joint that the new asphalt pavement will bind to shall be clean and dry before the joint adhesive is applied. Apply the pavement joint adhesive material to the entire face of the surface where HMA pavement shall be installed. The thickness of the asphalt adhesive application shall be approximately 1/8 inch. Use an application shoe attached to the end of application wand. Do not overlap the joint by greater than 1/2-inch at the top of the joint or two-inches at the bottom of the joint. Apply the joint adhesive immediately in front of the paving operation. If the adhesive is tracked by construction vehicles, repair the damaged area and restrict traffic from driving on the adhesive.

(d) Field Sampling. Take a sample during each shift from the application wand during the first 20 minutes of placing sealant from each melter on the Project in the presence of the Engineer.

Each sample shall consist of two aluminum or steel sample containers with the capacity to hold five pounds of sealant each. The two sampling containers shall be labeled with Contractor's name; project name and number; date and time sample taken; location of where material was used at, e.g., from where to where it was used at in stations; manufacturer and lot number of the sealant. Each container shall be numbered one of two, or two of two. Turn over samples to Engineer without Engineer losing sight of the sample. The Engineer reserves the right to conduct supplementary sampling and testing of the sealant material.

1. Document the locations where the material came from, each lot number of sealant that is placed and submit the document to the Engineer within 2 working days of placement.

2. If a field sample fails to meet any of the requirements in Table 401.03-1 - Asphalt Joint Adhesive Specifications; the work completed using the material from the lot that the field sample represents, shall be subject to a five percent reduction in the contract price of the lift of the HMA pavement it was used on; for example, if two lanes are paved and the longitudinal joint between the two lanes uses material

not meeting the contract requirements both of the lanes' asphalt pavement used for both lanes will be subject to a price reduction. If the joint was between an existing pavement and a new the price reduction will be based on the new pavement.

3. Overband with PG binder seal coat or other type of joint enrichment material over the entire length of the joint where the use of non-compliant material occurred.

4. Width of the overband shall follow the criteria used for low density longitudinal joints. In areas where the joint was formed with a curb or gutter use a joint sealer acceptable to the Engineer.

(M) HMA Pavement Surface Tolerances. The engineer will test surface of completed HMA pavement using 10-foot straightedge placed parallel and at right angles to the roadway centerline at selected locations. Pavement surface that varies more than 3/16 inch from testing edge of straightedge between two contacts exceeds surface tolerance.

Correct pavement exceeding specified tolerances by methods accepted by the Engineer, including removal and replacement, at no increase in contract price or contract time.

401.04 Measurement. The Engineer will measure PMA pavement per square yard in accordance with the Contract Documents.

401.05 Payment. The Engineer will pay for the accepted PMA pavement at the contract price per pay unit, as shown in the proposal schedule. Payment will be full compensation for the work prescribed in this section and the contract documents.

(A) Price and payment in Section 401 - Hot Mix Asphalt Pavement will be full compensation for all work and materials specified in this Section including furnishing all labor, materials, tools, equipment, testing, pavement profiles and incidentals and for doing all work involved in grinding existing or new pavement, removing residue, and cleaning the pavement, including necessary disposal of residue and furnishing any water or air used in cleaning the pavement and remedial work needed to conform to the requirements of the Contract Documents.

(B) Engineer will pay for the following pay items when included in proposal schedule:

Pay Item	Pay Unit
PMA Pavement	Ton”

END OF SECTION 401