Preparing Activity: NAVFAC Superseding
UFGS-32 13 13.06 (November 2011)

UNIFIED FACILITIES GUIDE SPECIFICATIONS

References are in agreement with UMRL dated July 2023
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USACE / NAVFAC / AFCEC / NASA	**UFGS-32 13 13.06 (May 2020)**

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SECTION 32 13 13.06

PORTLAND CEMENT CONCRETE PAVEMENT FOR ROADS AND SITE FACILITIES
05/20

****
NOTE: This guide specification covers the requirements for Portland cement concrete paving jobs such as roads, streets, sidewalks, and parking lots.

Adhere to UFC 1-300-02 Unified Facilities Guide Specifications (UFGS) Format Standard when editing this guide specification or preparing new project specification sections. Edit this guide specification for project specific requirements by adding, deleting, or revising text. For bracketed items, choose applicable item(s) or insert appropriate information.

Remove information and requirements not required in respective project, whether or not brackets are present.

Comments, suggestions and recommended changes for this guide specification are welcome and should be submitted as a Criteria Change Request (CCR).
****

****
NOTE: The extent and location of the work to be accomplished should be indicated on the project drawings, or included in the project specifications.

Portland cement pavements for airfields and special military vehicles, identified in UFC 3-201-01 (2018), paragraph 4-1, Surface and Unsurfaced Road And Site Pavement, are not included in this specification. Specify airfield and special military vehicle Portland cement concrete paving using Section 32 13 14.13 CONCRETE PAVING FOR AIRFIELDS AND OTHER HEAVY DUTY PAVEMENTS. Consult agency Subject Matter Expert (SME) for appropriate use of this guide specification.
****

PART 1 GENERAL

1.1 UNIT PRICES

****
NOTE: If lump sum payment is used, delete the following paragraphs on Measurement and Payment.
****

1.1.1 Measurement

The quantity of concrete to be paid for will be the volume of concrete in cubic meters yards including monolithic curb, where required, placed in the completed and accepted pavement. Concrete will be measured in place in the completed and accepted pavement only within the neat line dimensions shown in the plan and cross section. No deductions will be made for rounded edges or the space occupied by embedded items or voids.

1.1.2 Payment

Payment will be made at the contract price per cubic meter yard for the scheduled item. Payment will constitute full compensation for furnishing all materials, equipment, plant and tools, and for all labor and other incidentals necessary to complete the concrete pavement.

1.2 REFERENCES

****
NOTE: This paragraph is used to list the publications cited in the text of the guide specification. The publications are referred to in the text by basic designation only and listed in this paragraph by organization, designation, date, and title.

Use the Reference Wizard's Check Reference feature when you add a Reference Identifier (RID) outside of the Section's Reference Article to automatically place the reference in the Reference Article. Also use the Reference Wizard's Check Reference feature to update the issue dates.

References not used in the text will automatically be deleted from this section of the project specification when you choose to reconcile references in the publish print process.
****

The publications listed below form a part of this specification to the extent referenced. The publications are referred to within the text by the basic designation only.

AMERICAN CONCRETE INSTITUTE (ACI)

ACI 211.1	(1991; R 2009) Standard Practice for Selecting Proportions for Normal, Heavyweight and Mass Concrete

ACI 305R	(2020) Guide to Hot Weather Concreting
ACI 306R	(2016) Guide to Cold Weather Concreting

ASTM INTERNATIONAL (ASTM)

ASTM A184/A184M	(2019) Standard Specification for Welded Deformed Steel Bar Mats for Concrete Reinforcement
ASTM A615/A615M	(2022) Standard Specification for Deformed and Plain Carbon-Steel Bars for Concrete Reinforcement
ASTM A775/A775M	(2022) Standard Specification for Epoxy-Coated Steel Reinforcing Bars
ASTM A966/A966M	(2015; R 2020) Standard Test Method for Magnetic Particle Examination of Steel Forgings Using Alternating Current
ASTM C31/C31M	(2022) Standard Practice for Making and Curing Concrete Test Specimens in the Field
ASTM C33/C33M	(2018) Standard Specification for Concrete Aggregates
ASTM C42/C42M	(2020) Standard Test Method for Obtaining and Testing Drilled Cores and Sawed Beams of Concrete
ASTM C78/C78M	(2022) Standard Test Method for Flexural Strength of Concrete (Using Simple Beam with Third-Point Loading)
ASTM C88	(2018) Standard Test Method for Soundness of Aggregates by Use of Sodium Sulfate or Magnesium Sulfate
ASTM C94/C94M	(2022a) Standard Specification for Ready-Mixed Concrete
ASTM C143/C143M	(2020) Standard Test Method for Slump of Hydraulic-Cement Concrete
ASTM C150/C150M	(2022) Standard Specification for Portland Cement
ASTM C171	(2020) Standard Specification for Sheet Materials for Curing Concrete
ASTM C172/C172M	(2017) Standard Practice for Sampling Freshly Mixed Concrete
ASTM C231/C231M	(2022) Standard Test Method for Air Content of Freshly Mixed Concrete by the Pressure Method
ASTM C260/C260M	(2010a; R 2016) Standard Specification for

	Air-Entraining Admixtures for Concrete
ASTM C309	(2019) Standard Specification for Liquid Membrane-Forming Compounds for Curing Concrete
ASTM C494/C494M	(2019; E 2022) Standard Specification for Chemical Admixtures for Concrete
ASTM C595/C595M	(2021) Standard Specification for Blended Hydraulic Cements
ASTM C618	(2023; E 2023) Standard Specification for Coal Fly Ash and Raw or Calcined Natural Pozzolan for Use in Concrete
ASTM C881/C881M	(2020a) Standard Specification for Epoxy-Resin-Base Bonding Systems for Concrete
ASTM C989/C989M	(2022) Standard Specification for Slag Cement for Use in Concrete and Mortars
ASTM C1017/C1017M	(2013; E 2015) Standard Specification for Chemical Admixtures for Use in Producing Flowing Concrete
ASTM C1077	(2017) Standard Practice for Agencies Testing Concrete and Concrete Aggregates for Use in Construction and Criteria for Testing Agency Evaluation
ASTM C1240	(2020) Standard Specification for Silica Fume Used in Cementitious Mixtures
ASTM C1260	(2021) Standard Test Method for Potential Alkali Reactivity of Aggregates (Mortar-Bar Method)
ASTM C1542/C1542M	(2019) Standard Test Method for Measuring Length of Concrete Cores
ASTM C1549	(2016; R 2022) Standard Test Method for Determination of Solar Reflectance Near Ambient Temperature Using a Portable Solar Reflectometer
ASTM C1567	(2022) Standard Test Method for Potential Alkali-Silica Reactivity of Combinations of Cementitious Materials and Aggregate (Accelerated Mortar-Bar Method)
ASTM C1602/C1602M	(2022) Standard Specification for Mixing Water Used in Production of Hydraulic Cement Concrete
ASTM D1751	(2018) Standard Specification for Preformed Expansion Joint Filler for Concrete Paving and Structural

	Construction (Nonextruding and Resilient Bituminous Types)
ASTM D1752	(2018) Standard Specification for Preformed Sponge Rubber, Cork and Recycled PVC Expansion Joint Fillers for Concrete Paving and Structural Construction
ASTM D2995	(1999; R 2009) Determining Application Rate of Bituminous Distributors
ASTM D6155	(2019) Nontraditional Coarse Aggregate for Bituminous Paving Mixtures
ASTM E1274	(2018) Standard Test Method for Measuring Pavement Roughness Using a Profilograph

NATIONAL READY MIXED CONCRETE ASSOCIATION (NRMCA)

NRMCA QC 3	(2015) Quality Control Manual: Section 3, Plant Certifications Checklist: Certification of Ready Mixed Concrete Production Facilities

1.3 SUBMITTALS

****

NOTE: Review Submittal Description (SD) definitions in Section 01 33 00 SUBMITTAL PROCEDURES and edit the following list, and corresponding submittal items in the text, to reflect only the submittals required for the project. The Guide Specification technical editors have classified those items that require Government approval, due to their complexity or criticality, with a "G." Generally, other submittal items can be reviewed by the Contractor's Quality Control System. Only add a "G" to an item if the submittal is sufficiently important or complex in context of the project.

For Army projects, fill in the empty brackets following the "G" classification, with a code of up to three characters to indicate the approving authority. Codes for Army projects using the Resident Management System (RMS) are: "AE" for Architect-Engineer; "DO" for District Office (Engineering Division or other organization in the District Office); "AO" for Area Office; "RO" for Resident Office; and "PO" for Project Office. Codes following the "G" typically are not used for Navy, Air Force, and NASA projects.

The "S" classification indicates submittals required as proof of compliance for sustainability Guiding Principles Validation or Third Party Certification and as described in Section 01 33 00 SUBMITTAL PROCEDURES.

Choose the first bracketed item for Navy, Air Force,

and NASA projects, or choose the second bracketed item for Army projects.
****

Government approval is required for submittals with a "G" or "S" classification. Submittals not having a "G" or "S" classification are [for Contractor Quality Control approval.][for information only. When used, a code following the "G" classification identifies the office that will review the submittal for the Government.] Submit the following in accordance with Section 01 33 00 SUBMITTAL PROCEDURES:

SD-03 Product Data

Curing Materials

Reinforcement

Epoxy Resin

Cementitious Materials; G[, [_____]]

[Albedo

] Dowel Bars

Expansion Joint Filler

SD-04 Samples

Test Section; G[, [_____]]

SD-05 Design Data

Mix Design Report; G[, [_____]]

SD-06 Test Reports

Concrete Slump Tests

Concrete Uniformity

Flexural Strength

Air Content

SD-07 Certificates

Batch Tickets

NRMCA Certificate Of Conformance

SD-08 Manufacturer's Instructions

Diamond Grinding Plan

1.4 QUALITY CONTROL

1.4.1 NRMCA Certificate of Conformance

Provide a batching and mixing plant consisting of a stationary-type central mix plant, including permanent installations and portable or relocatable plants installed on stable foundations. Provide a plant designed and operated to produce concrete within the specified tolerances, with a minimum capacity of 200 cubic meters 250 cubic yards [_____] per hour. Submit NRMCA Certificate of Conformance that conforms to the requirements of NRMCA QC 3 including provisions addressing:

1. Material Storage and Handling

2. Batching Equipment

3. Central Mixer

4. Ticketing System

5. Delivery System

1.4.2 Qualifications

1.4.2.1 Laboratory Accreditation

Perform sampling and testing using an approved commercial testing laboratory or on-site facilities that are accredited in accordance with ASTM C1077. Do not start work requiring testing until the facilities have been inspected and approved. The Government will inspect all laboratories requiring validation for equipment and test procedures prior to the start of any concreting operations for conformance to ASTM C1077. Schedule and provide payment for laboratory inspections. Additional payment or a time extension due to failure to acquire the required laboratory validation is not allowed. Maintain this certification for the duration of the project.

1.4.2.2 Field Technicians

Provide field technicians meeting one of the following criteria:

a. Have at least one National Ready Mixed Concrete Association (NRMCA) certified concrete craftsman and at least one American Concrete Institute (ACI) Flatwork Finisher Certified craftsman on site, overseeing each placement crew during all concrete placement.

b. Have no less than three NRMCA certified concrete installers and at least two American Concrete Institute (ACI) Flatwork Finisher Certified installers on site working as members of each placement crew during all concrete placement.

1.4.3 Batch Tickets

Submit batch tickets for each load of ready-mixed concrete in accordance with ASTM C94/C94M.

1.5 DELIVERY, STORAGE, AND HANDLING

Deliver concrete paving in accordance with ASTM C94/C94M.

1.6 ACCEPTANCE

1.6.1 Tolerances

Acceptance of Portland cement concrete pavement is based on compliance with the tolerances presented in Table 1. Remove and replace concrete pavement represented by the failing tests or submit repair plan for approval.

Table 1	
Measurement	Tolerance
PLASTIC CONCRETE	
Slump	plus 0, minus 37.5 mm 1.5 inches
Air Content	plus/minus 1.5 percent
Flexural Strength	No individual specimen less than 0.69 MPa 100 psi below specified strength.
HARDENED CONCRETE	
Grade	plus/minus 15 mm 0.05 feet from plan
Smoothness	No abrupt change exceeding 3 mm 1/8 inch
Straightedge	Not more than 3 mm 1/8 in for roads. Not more than 6 mm 1/4 in for open storage areas.
Profilograph	Not more than 140 mm/km 9 inches/mile
Thickness	[minus 19 mm 3/4 inch for pavement equal to/greater than 200 mm 8 inches thick] [minus 12.5 mm 1/2 inch for pavement less than 200 mm 8 inches thick.]
Edge Slump	85 percent less than 6 mm 1/4 inch and 100 percent less than 9 mm 3/8 inch.

1.6.2 Test Section

Construct a minimum [_____] 37 square meters 400 square feet test section to demonstrate typical joints, surface finish, texture, color, thickness, and standard of workmanship using the mixture proportions, materials, and equipment as proposed for the project. Test in accordance with requirements in FIELD QUALITY CONTROL.

When a test section does not meet one or more of the tolerances in Table 1, remove and reconstruct the test section. If the test section is acceptable, it may be incorporated into the project.

PART 2 PRODUCTS

2.1 MATERIALS

2.1.1 Cementitious Materials

****
NOTE: Coal fly ash, slag, and silica fumes are EPA designated recovered products to be ingredients in concrete and cement. Use materials with recycled content where appropriate for use. The following section allows a percentage range of supplementary cementitious materials(SCM). Consult agency SME for guidance on choice.

Select sentence in brackets to specify SCM content.
****

[Provide cementitious materials in concrete mix with 20 to 50 percent non-portland cement pozzolanic materials [or slag]by weight.

]2.1.1.1 Portland Cement

Conforming to ASTM C150/C150M, Type I or II [III, for high early concrete] [or V] [low alkali].

2.1.1.2 Blended Cement

Provide blended cement conforming to ASTM C595/C595M, Type IP or IS, including the optional requirement for mortar expansion [and sulfate soundness]. Provide pozzolan added to the Type IP blend consisting of ASTM C618 Class F or Class N and that is interground with the cement clinker. Include in written statement from the manufacturer that the amount of pozzolan in the finished cement does not vary more than plus or minus 5 mass percent of the finished cement from lot to lot or within a lot. The percentage and type of mineral admixture used in the blend are not allowed to change from that submitted for the aggregate evaluation and mixture proportioning. The requirements of paragraph Supplementary Cementitious Materials (SCM) Content do not apply to the SCM content of blended cement.

2.1.1.3 Fly Ash and Pozzolan

****
NOTE: Use loss on ignition not exceeding 3 percent for frost areas to reduce carbon interference with air entraining admixture.
****

Conforming to ASTM C618, Type F, or N, with a loss on ignition not exceeding [3] [6] percent. Include test results in accordance with ASTM C618.

2.1.1.4 Ultra Fine Fly Ash and Ultra Fine Pozzolan

Ultra Fine Fly Ash (UFFA) and Ultra Fine Pozzolan (UFP) conforming to ASTM C618, Class F or N, and the following additional requirements:

a. The strength activity index at 28 days of age at least 95 percent of

the control specimens.

b. The average particle size not exceeding 6 microns.

c. Loss on ignition not exceeding [3] [6] percent.

2.1.1.5 Silica Fume

****
NOTE: Silica Fume is only used for OCONUS projects where Class F fly ash and slag cement are not available, and when approved by the TSMCX, AFCEC pavement SME, or NAVFAC. Delete this paragraph here and where encountered throughout the remainder of this section.
****

Provide silica fume that conforms to ASTM C1240, including the optional limits on reactivity with cement alkalis. Provide silica fume as a dry, densified material or as a slurry. Provide the services of a manufacturer's technical representative, experienced in mixing, proportioning, placement procedures, and curing of concrete containing silica fume, at no expense to the Government. This representative is required to be present on the project prior to and during at least the first 4 days of concrete production and placement using silica fume.

2.1.1.6 Slag

Conforming to ASTM C989/C989M, Slag Cement (formerly Ground Granulated Blast Furnace Slag) Grade 100 or 120. Include test results in accordance with ASTM C989/C989M.

2.1.1.7 Supplementary Cementitious Materials (SCM) Content

****
NOTE: Select first sentence in brackets for mandatory use of SCMs. Select second sentence in brackets for optional use of SCMs. Consult agency SME for guidance on choice.
****

[Include one of the SCMs listed in Table 2 within the range specified therein, whether or not the aggregates are found to be reactive in accordance with the paragraph Alkali Reactivity Test.] [Use of one of the SCMs listed below is optional, unless the SCM is required to mitigate ASR. The use of SCMs is encouraged in accordance with Section 01 33 29 SUSTAINABILITY REQUIREMENTS AND REPORTING.]

TABLE 2
SUPPLEMENTARY CEMENTITIOUS MATERIALS CONTENT

Supplementary Cementitious Material	Minimum Content (percent)	Maximum Content (percent)
Class N Pozzolan and Class F Fly Ash		

TABLE 2 SUPPLEMENTARY CEMENTITIOUS MATERIALS CONTENT		
Supplementary Cementitious Material	Minimum Content (percent)	Maximum Content (percent)
SiO2 + Al2O3 + Fe2O3 greater than 70 percent	25	35
SiO2 + A12O3 + Fe2O3 greater than 80 percent	20	35
SiO2 + A12O3 + Fe2O3 greater than 90 percent	15	35
UFFA and UFP	7	16
GGBF Slag	40	50
[Silica Fume]	[7]	[10]

2.1.2 Water

Water conforming to ASTM C1602/C1602M.

2.1.3 Aggregate

2.1.3.1 Durability

Evaluate and test all fine and coarse aggregates to be used in all concrete for durability in accordance with ASTM C88. Provide fine and coarse aggregates with a maximum of 18 percent loss when subjected to 5 cycles using Magnesium Sulfate or a maximum of 12 percent loss when subjected to 5 cycles of Sodium Sulfate.

2.1.3.2 Alkali Reactivity Test

****

NOTE: Documentation of alkali reactivity testing is required for all aggregate sources.

****

Evaluate and test fine and coarse aggregates to be used in all concrete for alkali-aggregate reactivity. Test all size groups and sources proposed for use.

a. Evaluate the fine and coarse aggregates separately, using ASTM C1260. Reject individual aggregates with test results that indicate an expansion of greater than 0.08 percent after 28 days of immersion in 1N NaOH solution, or perform additional testing as follows: utilize the proposed low alkali portland cement, blended cement, or SCM in combination with each individual aggregate. Test in accordance with ASTM C1567. Determine the quantity that meets all the requirements of these specifications and that lowers the expansion equal to or less than 0.08 percent after 28 days of immersion in a 1N NaOH solution. Base the mixture proportioning on the highest percentage of SCM required to mitigate ASR-reactivity.

b. If any of the above options does not lower the expansion to less than 0.08 percent after 28 days of immersion in a 1N NaOH solution, reject

the aggregate(s) and submit new aggregate sources for retesting. Submit the results of testing for evaluation and acceptance.

2.1.3.3 Fine Aggregates

Conforming to the quality and gradation of ASTM C33/C33M.

2.1.3.4 Coarse Aggregates

****

NOTE: Use materials with recycled content where appropriate for use. Verify suitability, availability within the region, cost effectiveness and adequate competition (including verification of bracketed percentages included in this guide specification) before specifying product recycled content requirements.

Select sentence in brackets for mandatory use of recycled materials. Consult agency SME for guidance.

****

Coarse aggregate consisting of crushed or uncrushed gravel, crushed stone, or a combination thereof.[Provide coarse aggregate with a minimum of [25][_____] percent recycled porcelain, concrete, stone, or other recycled material complying with ASTM D6155.] Provide aggregates, as delivered to the mixers, consisting of clean, hard, uncoated particles. Wash coarse aggregate sufficient to remove dust and other coatings. Provide fine aggregate consisting of natural sand, manufactured sand, or a combination of the two, and composed of clean, hard, durable particles. Provide both coarse and fine aggregates meeting the requirements of ASTM C33/C33M.

****

NOTE: Fill in the blank according to the size aggregate available in the project area, and the type of paving. Use nominal maximum aggregate size of 37.5 mm 1-1/2 inch. Subject to approval of the agency pavement SME, a 25 mm 1-inch nominal maximum aggregate size may be used to avoid durability problems associated with some larger size aggregate.

Select class 4M for exterior concrete exposed to frequent wetting in moderate weathering regions. Select class 4S for exterior concrete exposed to frequent wetting in severe weathering regions.

****

a. Gradation: Provide coarse aggregate with a nominal maximum size of [37.5] [_____] mm [1.5] [_____] inches. Grade and provide the individual aggregates in two or more size groups meeting the individual grading requirements of ASTM C33/C33M, Size No. 4 (37 mm to 19 mm1.5 to 0.75 inch) and Size No. 67 (19 mm to No. 40.75 inch to No. 4).

b. Quality: Conforming to ASTM C33/C33M, Class [4M] [4S].

2.1.4 Chemical Admixtures

2.1.4.1 Water Reducing Admixtures

Provide admixture conforming to ASTM C494/C494M: Type A, water reducing; Type B, retarding; Type C, accelerating; Type D, water-reducing and retarding; and Type E, water-reducing and accelerating admixture. Do not use calcium chloride admixtures. ASTM C494/C494M Type S specific performance admixtures and ASTM C1017/C1017M flowable admixtures are not allowed.

2.1.4.2 Air Entraining Admixture

Conforming to ASTM C260/C260M: Air-entraining.

2.1.4.3 High Range Water Reducing Admixture

****
NOTE: High Range Water Reducing Admixtures are permitted only for OCONUS projects when using Silica Fume. Retain first bracketed sentence for CONUS projects. Retain the second paragraph for OCONUS projects.
****

[ASTM C494/C494M Type F and G high range water reducing admixtures are not allowed.] [Provide a high-range water-reducing admixture that meets the requirements of ASTM C494/C494M, Type F or G, that is free from chlorides, alkalis, and is of the synthesized, sulfonated complex polymer type. Add the HRWRA to the concrete as a single component at the batch plant. Add the admixture to the concrete mixture only when its use is approved or directed, and only when it has been used in mixture proportioning studies to arrive at approved mixture proportions. Submit certified copies of the independent laboratory test results required for compliance with ASTM C494/C494M.]

2.1.5 Reinforcement

2.1.5.1 Dowel Bars

Dowel bars conforming to ASTM A615/A615M, [Grade 300] [Grade 420] [Grade 40] [Grade 60] for plain billet-steel bars of the size and length indicated. Remove all burrs and projections from the bars.[Epoxy coat in accordance with ASTM A775/A775M.]

2.1.5.2 Tie Bars

Billet or axle steel deformed bars conforming to ASTM A615/A615M or ASTM A966/A966M [Grade 300] [Grade 420] [Grade 40] [Grade 60].[Epoxy coat in accordance with ASTM A775/A775M.]

[2.1.5.3 Reinforcement

Deformed steel bar mats conforming to ASTM A184/A184M. Bar reinforcement conforming to [ASTM A615/A615M] [ASTM A966/A966M], [Grade 300] [Grade 420] [Grade 40] [Grade 60].[Epoxy coat in accordance with ASTM A775/A775M.]

]2.1.6 Curing Materials

Provide curing materials consisting of:

2.1.6.1 White-Burlap-Polyethylene Sheet

Conforming to ASTM C171, 0.10 mm 0.004 inch thick white opaque polyethylene bonded to 0.31 kg per meter 10 oz/linear yard (1.0 meter) (40 inch) wide burlap.

2.1.6.2 Liquid Membrane-Forming Compound

Conforming to ASTM C309, white pigmented, Type 2, Class B, free of paraffin or petroleum.

2.1.6.3 Liquid Chemical Sealer-Hardener Compound

Compound consisting of magnesium fluosilicate which when mixed with water seals and hardens the surface of the concrete. Do not use on exterior slabs exposed to freezing conditions.

2.1.7 Joint Fillers and Sealants

Provide as specified in Section [32 01 19.61 SEALING OF JOINTS IN RIGID PAVEMENT][32 13 73.19 COMPRESSION CONCRETE PAVING JOINT SEALANT].[Match new joints with existing alignment.]

2.1.8 Biodegradable Form Release Agent

****

NOTE: Concrete release fluids are recognized as a biobased material. Use materials with biobased content where suitable for application and cost effective. Verify suitability, availability within the region, cost effectiveness, and adequate competition before specifying product biobased content requirements. A resource that can be used to identify products with bio-based content is the "Catalog" tab within the USDA's "Biopreferred" website at https://www.biopreferred.gov/BioPreferred/. Other products with biobased content are also acceptable when meeting all requirements of this specification.

****

Provide form release agent that is colorless and biodegradable. Provide product that does not bond with, stain, or adversely affect concrete surfaces and does not impair subsequent treatments of concrete surfaces. Provide form release agent with a minimum of 87 percent biobased material and does not contain diesel fuel, petroleum-based lubricating oils, waxes, or kerosene.

2.1.9 Epoxy Resin

Provide epoxy-resin materials that consist of two-component materials conforming to the requirements of ASTM C881/C881M, Class as appropriate for each application temperature to be encountered, except that in addition, the materials meet the following requirements:

a. Type IV, Grade 3, for use for embedding dowels and anchor bolts.

b. Type III, Grade as approved, for use as patching materials for complete filling of spalls and other voids and for use in preparing epoxy resin mortar.

c. Type IV, Grade 1, for use for injecting cracks.

d. Type V, Grade as approved, for bonding freshly mixed portland cement concrete or mortar or freshly mixed epoxy resin concrete or mortar to hardened concrete.

2.1.10 Joint Materials

****

NOTE: Edit as appropriate for project requirements. Coordinate with Section 32 01 19.61 SEALING OF JOINTS IN RIGID PAVEMENT for Army projects and Section 32 13 73.19 COMPRESSION CONCRETE PAVING JOINT SEALANT for all other projects.

****

2.1.10.1 Expansion Joint Materials

Provide preformed expansion joint filler material conforming to [ASTM D1751][or][ASTM D1752 Type [II] [III]]. Provide expansion joint filler that is 19 mm 3/4 inch thick, unless otherwise indicated, and provided in a single full depth piece.

2.1.10.2 Slip Joint Material

Provide slip joint material that is 6 mm 1/4 inch thick expansion joint filler, unless otherwise indicated, conforming to paragraph EXPANSION JOINT MATERIAL.

2.2 MIX DESIGN

Proportion concrete mix in accordance with ACI 211.1 except as modified herein.

2.2.1 Specified Concrete Properties

****

NOTE: This specification is based on a flexural strength basis. Specify the design strength based on local or state DOT experience in the area. For small jobs 75 cubic meters or less 100 cubic yards or less, compressive strength may be used. In that case modify these paragraphs to reflect a compressive strength basis.

NOTE: Allowable Air Content: Select 5.5 percent air content for maximum aggregate size of 37.5 mm 1 1/2 inches, and 6 percent air content for maximum aggregate size of 25 mm one inch. Maximum water-cementitious material ratio should be 0.45 for exposure to moisture and freeze-thaw cycling or 0.40 for reinforcement corrosion protection and exposure to deicing salts.

****

2.2.1.1 Flexural Strength

Provide concrete with a minimum flexural strength of [4.48][_____]MPa [650][_____] psi at 28 days of age.

2.2.1.2 Air Entrainment

Provide an entrained air content of [5.5] [6.0] percent.

2.2.1.3 Slump

[For fixed form and hand placement, provide a maximum slump of 75 mm 3 inches.] [For slipformed pavement, at the start of the project, select a maximum allowable slump which will produce in-place pavement meeting the specified tolerances for control of edge slump. The selected slump is applicable to both pilot and fill-in lanes.]

2.2.1.4 Water/Cementitious Materials Ratio

Maximum allowable water-cementitious material ratio is [0.40] [0.45]. The water-cementitious material ratio is based on absolute volume equivalency, where the ratio is determined using the weight of cement for a cement only mix, or using the total volume of cement plus pozzolan converted to an equivalent weight of cement by the absolute volume equivalency method described in ACI 211.1.

2.2.1.5 Albedo

****

NOTE: The urban heat island effect forms as vegetation is replaced by low reflectivity materials such as dark colored paving. These surfaces absorb, rather than reflect, the sun's heat, causing surface temperatures and urban ambient temperatures to be 1 to 6 degrees C 2 to 10 degrees F hotter than surrounding rural areas.

Mitigation of heat island effect is not required by UFC 1-200-02 but may be desired for sustainability reasons. The albedo requirements below for roads and parking lot paving are most beneficial in ASHRAE climate zones 1 through 5. Retain the following section when needed to meet project requirements.

****

[Provide an Albedo with a minimum initial Solar Reflectance of at least 0.33 as tested in accordance with ASTM C1549.

]2.2.2 Mix Design Report

Perform trial design batches, mixture proportioning studies, testing, and include test results demonstrating that the proposed mixture proportions produce concrete of the qualities indicated. An existing mix design may be submitted if developed within the previous 12 months. Submit test results in a mix design report to include:

a. Coarse and fine aggregate gradations and plots.

b. Coarse and fine aggregate quality test results, include deleterious materials and ASR testing.

c. Mill certificates for cement and supplemental cementitious materials.

d. Certified test results for all proposed admixtures.

e. Specified flexural strength, slump, and air content.

f. Recommended proportions and volumes for proposed mixture and each of three trial water-cementitious materials ratios.

g. Individual beam breaks.

h. Flexural strength summaries and plots.

i. Historical record of test results, documenting production standard deviation (if available).

j. Narrative discussing methodology on how the mix design was developed.

2.2.3 Mix Verification

Mix verification tests may be performed by the Government. Provide quantities of cementitious materials, aggregates and admixtures as requested.

2.3 EQUIPMENT

2.3.1 Batching and Mixing

****
NOTE: Edit bracketed items according to whether use of truck mixers is to be permitted. Truck mixers should not be permitted for mixing concrete if slipform paving is permitted for pavement thicker than 200 mm 8 inches.
****

Provide [stationary mixers] [truck mixers]. Provide a batch plant conforming to ASTM C94/C94M and as specified. Do not weigh water or measure cumulatively with another ingredient. Batch all concrete materials in accordance with ASTM C94/C94M requirements. Verify batching, mixers, mixing time, permitted reduction of mixing time, and concrete uniformity in accordance with the requirements of ASTM C94/C94M, and document in the initial weekly QC Report.[Do not use truck mixers for mixing slipformed concrete. Provide only truck mixers designed for mixing or transporting paving concrete with extra large blading and rear opening specifically for low-slump paving concrete and conforming to the requirements of ASTM C94/C94M.]

2.3.2 Transporting Equipment

Provide transporting equipment in conformance with ASTM C94/C94M and as specified herein. Transport concrete to the paving site in rear-dump trucks, in truck mixers designed with extra large blading and rear opening specifically for low slump concrete, or in agitators. Do not permit bottom-dump trucks for delivery of concrete.

2.3.3 Delivery Equipment

When concrete transport equipment cannot operate on the paving lane, provide side-delivery transport equipment consisting of self-propelled moving conveyors to deliver concrete from the transport equipment and discharge it in front of the paver. Do not permit front-end loaders, dozers, or similar equipment to distribute the concrete.

2.3.4 Paver-Finisher

Provide a heavy-duty, self-propelled paver-finisher machine designed specifically for paving and finishing high quality pavement and capable of spreading, consolidating, and shaping the plastic concrete to the desired cross section in one pass.[Provide a paver-finisher weighing at least 3280 kg/m 2200 lb/foot of lane width, and powered by an engine having at least 15000 W/meter 6.0 horsepower/foot of lane width.] Equip the paver-finisher with a full width "knock-down" auger, capable of operating in both directions, which will evenly spread the fresh concrete in front of the screed or extrusion plate. Gang-mount immersion vibrators at the front of the paver on a frame equipped with suitable controls so that all vibrators can be operated at any desired depth within the slab or completely withdrawn from the concrete. Automatically control the vibrators so they will be immediately stopped as forward motion of the paver ceases. Space the immersion vibrators across the paving lane as necessary to properly consolidate the concrete, but limit the clear distance between vibrators not to exceed 750 mm 30 inches, and the outside vibrators not to exceed 300 mm 12 inches from the edge of the lane. Vibrators may be pneumatic, gas driven, or electric, and operated at frequencies within the concrete between 6,000 and 7,000 vibrations per minute, with an amplitude of vibration such that noticeable vibrations occur at 450 mm 1.5 foot radius when the vibrator is inserted in the concrete to the depth specified. Equip the paver-finisher with a transversely oscillating screed or an extrusion plate to shape, compact, and smooth the surface.

2.3.4.1 Paver-Finisher with Fixed Forms

Equip the paver-finisher with wheels designed to ride the forms, keep it aligned with the forms, and to prevent deformation of the forms.

2.3.4.2 Slipform Paver-Finisher

Provide a track-mounted slipform paver-finisher with automatic controls and padded tracks. Electronically reference horizontal alignment to a taut wire guideline. Electronically reference vertical alignment on both sides of the paver to a taut wire guideline, to an approved laser control system, or to a ski operating on a completed lane. Do not control from a slope-adjustment control or from the underlying material.

2.3.4.3 Other Types of Finishing Equipment

****

NOTE: Edit bracketed item according to whether use of bridge deck finishers is desired, and based on thickness of pavement and surface smoothness tolerances required.

****

[Bridge deck finishers are permitted for pavements 250 mm 10 inches or less in thickness.]Heavy duty vibratory truss screeds may be approved for use if successfully demonstrated on the test section to consolidate the slab full depth and without segregation. Clary screeds, rotating tube floats, or laser screeds will not be allowed on the project. Provide hand floats that are not less than 3.65 m 12 feet long and 150 mm 6 inches wide and stiffened to prevent flexing and warping.

2.3.4.4 Work Bridge

Provide a self-propelled work bridge capable of spanning the paving lane and supporting the workmen without excessive deflection.

2.3.5 Texturing Equipment

****
NOTE: Edit the following paragraphs and delete non-applicable texturing methods to correlate with the drawings and with paragraph TEXTURING in PART 3. Do not specify artificial turf drag for Air Force projects.
****

Provide texturing equipment as specified below.

2.3.5.1 Fabric Drag

[Clean, reasonably new burlap][Artificial turf fabricated of a plastic material]measuring from 0.91 to 3 m 3 to 10 feet long, 600 mm 2 feet wider than the width of the pavement, and securely attached to a separate wheel mounted frame spanning the paving lane or to one of the other similar pieces of equipment. Select dimension of burlap drag so that at least 0.91 m 3 feet of the material is in contact with the pavement.

2.3.5.2 Deep Texturing Equipment

Provide texturing equipment consisting of [a stiff bristled broom] [a comb with spring wire tines] [spring strips] which will produce true, even grooves. Mount this drag in a wheeled frame spanning the paving lane and constructed to mechanically pull the drag in a straight line across the paving lane perpendicular to the centerline.

2.3.6 Curing Equipment

Provide equipment for applying membrane-forming curing compound mounted on a self-propelled frame that spans the paving lane. Constantly agitate the curing compound reservoir mechanically (not air) during operation and provide a means for completely draining the reservoir. Provide a spraying system that consists of a mechanically powered pump which maintains constant pressure during operation, an operable pressure gauge, and either a series of spray nozzles evenly spaced across the lane to provide uniformly overlapping coverage or a single spray nozzle which is mounted on a carriage which automatically traverses the lane width at a speed correlated with the forward movement of the overall frame. Protect all spray nozzles with wind screens. Calibrate the spraying system in accordance with ASTM D2995, Method A, for the rate of application required in subpart CURING AND PROTECTION. Provide hand-operated sprayers powered by compressed air supplied by a mechanical air compressor. Immediately replace curing equipment if it fails to apply an even coating of compound

at the specified rate.

2.3.7 Sawing Equipment

Provide equipment for sawing joints and for other similar sawing of concrete consisting of standard diamond-type concrete saws mounted on a wheeled chassis which can be easily guided to follow the required alignment. Provide diamond tipped blades. If demonstrated to operate properly, abrasive blades may be used. Provide spares as required to maintain the required sawing rate. Early-entry saws may be used, subject to demonstration and approval. No change to the initial sawcut depth is permitted.

2.3.8 Straightedge

Furnish one 4 m 12 foot straightedge constructed of aluminum or magnesium alloy, having blades of box or box-girder cross section with flat bottom, adequately reinforced to insure rigidity and accuracy. Provide handles for operation on the pavement.

PART 3 EXECUTION

3.1 PREPARATION FOR PAVING

3.1.1 Weather Limitations

When windy conditions during paving appear probable, have equipment and material at the paving site to provide windbreaks, shading, fogging, or other action to prevent plastic shrinkage cracking or other damaging drying of the concrete.

3.1.1.1 Inclement Weather

Do not commence placing operations when heavy rain or other damaging weather conditions appear imminent. At all times when placing concrete, maintain on-site sufficient waterproof cover and means to rapidly place it over all unhardened concrete or concrete that might be damaged by rain. Suspend placement of concrete whenever rain, high winds, or other damaging weather commences to damage the surface or texture of the placed unhardened concrete, washes cement out of the concrete, or changes the water content of the surface concrete. Immediately cover and protect all unhardened concrete from the rain or other damaging weather. Completely remove and replace any slab damaged by rain or other weather full depth, by full slab width, to the nearest original joint.

3.1.1.2 Hot Weather

Maintain required concrete temperature in accordance with ACI 305R to prevent evaporation rate from exceeding 0.98 kg of water per square meter 0.2 pound of water per square foot of exposed concrete per hour. Cool ingredients before mixing, place concrete during cooler night time hours, or use other suitable means to control concrete temperature and prevent rapid drying of newly placed concrete. Water is not allowed to be added after the initial introduction of mixing water except, when on arrival at the job site, the slump is less than specified and the water-cement ratio is less than that given as a maximum in the approved mixture. Additional water may be added to bring the slump within the specified range provided the approved water-cement ratio is not exceeded. Inject water into the head of the mixer (end opposite the discharge opening) drum under

pressure, and turn the drum or blades a minimum of 30 additional revolutions at mixing speed. The addition of water to the batch at any later time is not allowed. After placement, use fog spray, apply monomolecular film, or use other suitable means to reduce the evaporation rate. Start curing when surface of fresh concrete is sufficiently hard to permit curing without damage. Cool underlying material by sprinkling lightly with water before placing concrete. Follow practices found in ACI 305R.

3.1.1.3 Prevention of Plastic Shrinkage Cracking

During weather with low humidity, and particularly with high temperature and appreciable wind, develop and institute measures to prevent plastic shrinkage cracks from developing. If plastic shrinkage cracking occurs, halt further placement of concrete until protective measures are in place to prevent further cracking. Periods of high potential for plastic shrinkage cracking can be anticipated by use of ACI 305R. In addition to the protective measures specified in the previous paragraph, the concrete placement may be further protected by erecting shades and windbreaks and by applying fog sprays of water, the addition of monomolecular films, or wet covering. Apply monomolecular films after finishing is complete, do not use in the finishing process. Immediately commence curing procedures when such water treatment is stopped.

3.1.1.4 Cold Weather

Do not place concrete when ambient temperature is below 5 degrees C 40 degrees F or when concrete is likely to be subjected to freezing temperatures within 24 hours. When authorized, when concrete is likely to be subjected to freezing within 24 hours after placing, heat concrete materials so that temperature of concrete when deposited is between 18 and 27 degrees C 65 and 80 degrees F. Methods of heating materials are subject to approval. Do not heat mixing water above 74 degrees C 165 degrees F. Remove lumps of frozen material and ice from aggregates before placing aggregates in mixer. Follow practices found in ACI 306R.

3.1.2 Conditioning of Underlying Material

Verify the underlying material, upon which concrete is to be placed is clean, damp, and free from debris, waste concrete or cement, frost, ice, and standing or running water. Prior to setting forms or placement of concrete, verify the underlying material is well drained and has been satisfactorily graded by string-line controlled, automated, trimming machine and uniformly compacted in accordance with the applicable Section of these specifications. Test the surface of the underlying material to crown, elevation, and density in advance of setting forms or of concrete placement using slip-form techniques. Trim high areas to proper elevation. Fill and compact low areas to a condition similar to that of surrounding grade, or fill with concrete monolithically with the pavement. Low areas filled with concrete are not to be cored for thickness to avoid biasing the average thickness used for evaluation and payment adjustment. Rework and compact any underlying material disturbed by construction operations to specified density immediately in front of the paver. If a slipform paver is used, continue the same underlying material under the paving lane beyond the edge of the lane a sufficient distance that is thoroughly compacted and true to grade to provide a suitable trackline for the slipform paver and firm support for the edge of the paving lane.

3.1.3 Forms

****
NOTE: Delete bracketed sentences on overlay pavements if not applicable.
****

Use steel forms, except that wood forms may be used for curves having a radius of 45 m 150 feet or less, and for fillets. Forms may be built up with metal or wood, added only to the base, to provide an increase in depth of not more than 25 percent. Provide forms with the base width not less than eight-tenths of the vertical height of the form, except that for forms 200 mm 8 inches or less in vertical height, provide forms with a base width not less than the vertical height of the form. Provide wood forms adequate in strength and rigidly braced for curves and fillets. Set forms on firm material cut true to grade so that each form section when placed will be firmly in contact with the underlying layer for its entire base. Do not set forms on blocks or on built-up spots of underlying material.[Set and secure forms in place with stakes or by other approved methods for overlay pavements and for other locations where forms are set on existing pavements. Carefully drill holes in existing pavements for form stakes without cracking or spalling the existing pavement. Prior to setting forms for paving operations, demonstrate the proposed form setting procedures at an approved location and do not proceed further until the proposed method is approved.] Before placing the concrete, coat the contact surfaces of forms[except existing pavement sections where bonding is required,] with a non-staining mineral oil, non-staining form coating compound, biodegradable form release agent, or two coats of nitro-cellulose lacquer.[When using existing pavement as a form, clean existing concrete and then coat with asphalt emulsion bondbreaker before concrete is placed.] Check and correct grade elevations and alignment of the forms immediately before placing concrete.

3.1.4 Reinforcement

3.1.4.1 Dowel Bars

****
NOTE: For projects which require dowel bars or coated dowel bars, show location, size, and tolerances on the drawings. Include sentence in brackets for coated dowel bars. Delete references to slipform paving installation of dowels and tie bars if slipform paving is not allowed. Delete references to installation in contraction joints if not required. Delete bracketed references to tie bars, if tie bars are not used.
****

Install dowels with horizontal and vertical alignment plus or minus 25 mm 1 inch. Except as otherwise specified, maintain location of dowels within a skew alignment of 6 mm over 300 mm length 1/4 inch over 1 foot length. [Reject coatings which are perforated, cracked or otherwise damaged. While handling avoid scuffing or gouging of the coatings.] Omit [Dowels] [and tie bars] when the center of the [dowel] [tie bar] is located within a horizontal distance from an intersecting joint equal to or less than one-fourth of the slab thickness. Maintain dowels in position during concrete placement and curing. Before concrete placement, thoroughly grease the entire length of each dowel secured in a dowel basket or fixed

form.

3.1.4.2 Tie Bars

****
NOTE: When tie bars are required in the contract, indicate location on drawings. Show bar size, spacing, and placement tolerances required and method of support.
****

Install bars, accurately aligned horizontally and vertically, and to the tolerances shown on the drawings, at indicated locations.[For slipform construction, insert bent tie bars by hand or other approved means.]

3.1.4.3 Setting Slab Reinforcement

****
NOTE: For contracts which require reinforcing steel, specify the type, size and material of reinforcement. Delete bracketed item if CRCP is not being constructed.
****

Position reinforcement on suitable chairs prior to concrete placement. At expansion, contraction and construction joints, place the reinforcement as indicated. Clean reinforcement free of mud, oil, scale or other foreign materials. Place reinforcement accurately and wire securely. Lap splices 300 mm 12 inches minimum. Maintain the bar spacing from ends and sides of slabs and joints as indicated.[If reinforcing for Continuously Reinforced Concrete Pavement (CRCP) is required, submit the entire operating procedure and proposed equipment for approval.]

3.2 MEASURING, MIXING, CONVEYING, AND PLACING CONCRETE

3.2.1 Measuring

Conform to ASTM C94/C94M.

3.2.2 Mixing

Conform to ASTM C94/C94M, except as modified herein. Begin mixing within 30 minutes after cement has been added to aggregates. When the air temperature is greater than 29.4 degrees C 85 degrees F, place concrete within 60 minutes. With approval, a hydration stabilizer admixture meeting the requirements of ASTM C494/C494M Type D, may be used to extend the placement time to 90 minutes. Additional water may be added to bring slump within required limits as specified in ASTM C94/C94M, provided that the specified water-cement ratio is not exceeded.

3.2.3 Conveying

Conform to ASTM C94/C94M.

3.2.4 Placing

Do not exceed a free vertical drop of 1.5 m 5 feet from the point of discharge. Deposit concrete either directly from the transporting equipment or by conveyor on to the pre-wetted subgrade or subbase, unless

otherwise specified. Deposit the concrete between the forms to an approximately uniform height. Place concrete continuously at a uniform rate, without damage to the grade and without unscheduled stops except for equipment failure or other emergencies. If an unscheduled stop occurs within 3 m 10 feet of a previously placed expansion joint, remove concrete back to joint, repair any damage to grade, install a construction joint and continue placing concrete only after cause of the stop has been corrected.

3.3 PAVING

Construct pavement with paving and finishing equipment utilizing [fixed forms] [slipforms].

3.3.1 Paving Plan

Submit for approval a paving plan identifying the following items:

a. A description of the placing and protection methods proposed when concrete is to be placed in or exposed to hot, cold, or rainy weather conditions.

b. A detailed paving sequence plan and proposed paving pattern showing all planned construction joints.

c. Plan and equipment proposed to control alignment of formed or sawn joints within the specified tolerances.

3.3.2 Required Results

Operate the paver-finisher to produce a thoroughly consolidated slab throughout, true to line and grade within specified tolerances. Adjust the paver-finishing operation to produce a surface finish free of irregularities, tears, voids of any kind, and other discontinuities, with only a minimum of paste at the surface. Do not permit multiple passes of the paver-finisher. Produce a finished surface requiring no hand finishing, other than the use of cutting straightedges, except in very infrequent instances. Do not apply water, other than true fog sprays (mist), to the concrete surface during paving and finishing.

3.3.3 Operation

When the paver is operated between or adjacent to previously constructed pavement (fill-in lanes), make provisions to prevent damage to the previously constructed pavement, including keeping the existing pavement surface free of debris, and placing rubber mats beneath the paver tracks. Operate transversely oscillating screeds and extrusion plates to overlap the existing pavement the minimum possible, but in no case more than 200 mm 8 inches.

3.3.4 Consolidation

Immediately after spreading concrete, consolidate full depth with internal type vibrating equipment along the boundaries of all slabs regardless of slab thickness, and interior of all concrete slabs. For pavements less than 250 mm 10 inches thick, operate vibrators at mid-depth parallel with or at a slight angle to the base course. For thicker pavements, angle vibrators toward the vertical, with vibrator tip preferably about 50 mm 2 inches above the base course, and top of vibrator a few mm inches below

pavement surface. Automatically control the vibrators or tamping units in front of the paver so that they stop immediately as forward motion ceases. Limit duration of vibration to that necessary to produce consolidation of concrete. Do not permit excessive vibration. Vibrate concrete in small, odd-shaped slabs or in locations inaccessible to the paver mounted vibration equipment with a hand-operated immersion vibrator operated from a bridge spanning the area. Do not operate vibrators at one location for more than 15 seconds. Do not use vibrators to transport or spread the concrete.

3.3.5 Fixed Form Paving

Spread and strike off concrete with with the paver. Shape the concrete to the specified and indicated cross section in one pass, and finish the surface and edges so that only a very minimum amount of hand finishing is required. Use single spud hand vibrators to consolidate the concrete adjacent to fixed forms as required to achieve a void-free formed edge. Do not allow vibrators to contact reinforcement, forms, or the grade during vibration.

3.3.6 Slipform Paving

****

NOTE: Retain slipform paving as an option unless the designer has specific, valid reasons for deleting it. Be sure all other paragraphs correlate with choice made here.

****

Shape the concrete to the specified and indicated cross section in one pass, and finish the surface and edges so that only a very minimum amount of hand finishing is required. Do not install dowels by dowel inserters attached to the paver or by any other means of inserting the dowels into the plastic concrete.[If a keyway is required, install a 0.45 to 0.55 mm 26 gauge thick metal keyway liner as the keyway is extruded.[Protect the keyway liner to remain in place and become part of the joint.]]

3.4 JOINTS

****

NOTE: Delete references to slipform paving installation of dowels and tie bars if slipform paving is not allowed. Delete references to installation in contraction joints if not required. Delete bracketed references to tie bars, if tie bars are not used.

****

3.4.1 Contraction Joints

Hold [dowels][and][tie bars] in longitudinal and transverse contraction joints within the paving lane securely in place by means of rigid metal basket assemblies. Weld the [dowels] [and tie bars] to the assembly or hold firmly by mechanical locking arrangements that will prevent them from becoming distorted during paving operations. Anchor the basket assemblies securely in the proper location.

3.4.2 Construction Joints - Fixed Form Paving

Install [dowels] [and tie bars] by the bonded-in-place method, supported by means of devices fastened to the forms. Do not permit installation by removing and replacing in preformed holes.

3.4.3 Dowels Installed In Hardened Concrete

Install by bonding the dowels into holes drilled into the hardened concrete. Drill holes into the hardened concrete approximately 3 mm 1/8 inch greater in diameter than the dowels. Bond the dowels in the drilled holes using epoxy resin injected at the back of the hole before installing the dowel and extruded to the collar during insertion of the dowel so as to completely fill the void around the dowel. Application by buttering the dowel is not permitted. Hold the dowels in alignment at the collar of the hole, after insertion and before the epoxy resin hardens, by means of a suitable metal or plastic collar fitted around the dowel. Check the vertical alignment of the dowels by placing the straightedge on the surface of the pavement over the top of the dowel and measuring the vertical distance between the straightedge and the beginning and ending point of the exposed part of the dowel.[Where tie bars are required in longitudinal construction joints of slipform pavement, install bent tie bars at the paver, in front of the transverse screed or extrusion plate. If tie bars are required, construct a standard keyway and install the bent tie bars into the plastic concrete through a 0.45 to 0.55 mm 26 gauge thick metal keyway liner. Do not install tie bars in preformed holes. Protect the keyway liner and maintain in place and become part of the joint. Before placement of the adjoining paving lane, straighten the tie bars, without spalling the concrete around the bar.]

3.5 FINISHING CONCRETE

Start finishing operations immediately after placement of concrete. Use finishing machine, except hand finishing may be used in emergencies and for concrete slabs in inaccessible locations or of such shapes or sizes that machine finishing is impracticable. Immediately halt any operations which produce more than 3 mm 1/8 inch of mortar-rich surface (defined as deficient in plus 4.75 mm U.S. No. 4 sieve size aggregate) and modify the equipment, mixture, or procedures. Finish pavement surface on both sides of a joint to the same grade. Finish formed joints from a securely supported transverse bridge. Provide hand finishing equipment for use at all times.

3.5.1 Machine Finishing

Strike off and screed concrete to the required [crown] [slope] and cross-section by a power-driven transverse finishing machine. A transverse rotating tube or pipe is not permitted. Maintain elevation of concrete such that, when consolidated and finished, pavement surface will be adequately consolidated and at the required grade. Equip finishing machine with a screed which is readily and accurately adjustable for changes in pavement [crown] [slope] and compensation for wear and other causes. Do not permit excessive operation over an area, which will result in an excess of mortar and water being brought to the surface.

3.5.1.1 Equipment Operation

Maintain the travel of machine on the forms without lifting, wobbling, or other variation of the machine which tend to affect the precision of

concrete finish. Keep the tops of the forms clean by a device attached to the machine. Maintain a uniform ridge of concrete ahead of the front screed for its entire length.

3.5.1.2 Joint Finish

Before concrete is hardened, correct edge slump of pavement, exclusive of edge rounding, in excess of 6 mm 0.25 inches. Finish concrete surface on each side of construction joints to the same plane, and correct deviations before newly placed concrete has hardened.

3.5.1.3 Hand Finishing

Strike-off and screed surface of concrete to elevations slightly above finish grade so that when concrete is consolidated and finished, the pavement surface is at the indicated elevation. Vibrate entire surface until required compaction and reduction of surface voids is secured with a strike-off template. After initial finishing, further smooth and consolidate concrete by means of hand-operated longitudinal floats.

3.5.2 Texturing

****

NOTE: Select type of texturing required by the using service, retain that subparagraph, and delete the others. If no guidance is given, the usual default method should be burlap drag. Edit bracketed sentence as appropriate.

Select the type of texturing for roads. Consider climatic conditions for exposed concrete. When required, specify surfaces to receive brooming.

1. Specify wire brooming for non-skid concrete surface textures. Permit steel or new fiber brooms.

2. Specify broomed finish, if required in lieu of burlap drag finish. Broomed finish may cause excessive tire wear and is not recommended, except for special conditions in which light mechanical brooming may be desirable.

3. Additional information is published by American Concrete Paving Association (ACPA) in Technical Bulletins No. 6 (1969) and No. 19 (1975), Interim Recommendations for the Construction of Skid-Resistant Concrete Pavement and Guideline for Texturing of Portland Cement Concrete Highway Pavements, respectively.

****

Before the surface sheen has disappeared and before the concrete hardens, provide a texture to the surface of the pavement as described herein. After curing is complete, thoroughly broom all textured surfaces to remove all debris. Finish the concrete in areas of recesses for tie-down anchors, lighting fixtures, and other outlets in the pavement to provide a surface of the same texture as the surrounding area.

3.5.2.1 Burlap Drag Finish

[Before concrete becomes non-plastic, finish the surface of the slab by dragging a strip of clean, wet burlap on the surface. Drag the surface so as to produce a finished surface with a fine granular or sandy texture without leaving disfiguring marks. Keep the burlap clean and saturated during use.

]3.5.2.2 Brooming

[Finish the surface of the slab by brooming the surface with a new wire broom at least 450 mm 18 inches wide. Gently pull the broom over the surface of the pavement from edge to edge just before the concrete becomes non-plastic. Slightly overlap adjacent strokes of the broom. Broom perpendicular to centerline of pavement so that corrugations produced will be uniform in character and width, and not more than 2 mm 1/16 inch in depth. Maintain broomed surface free from porous spots, irregularities, depressions, and small pockets or rough spots such as may be caused by accidentally disturbing particles of coarse aggregate embedded near the surface.

]3.5.2.3 Wire-Comb Texturing

[Apply surface texture transverse to the pavement center line using a mechanical wire comb drag capable of traversing the full width of the pavement in a single pass at a uniform speed and with a uniform pressure. Overlap successive passes of the comb the minimum necessary to obtain a continuous and uniformly textured surface, with scores 2 to 5 mm 1/16 to 3/16 inch deep, 1.5 to 3 mm 1/16 to 1/8 inch wide, and spaced 10 mm 3/8 inch apart.

]3.5.2.4 Surface Grooving

[Groove the areas indicated on the drawings with a spring tine drag producing individual grooves 6 mm 1/4 inch deep and 6 mm 1/4 inch wide at a spacing between groove centerlines of 50 mm 2 inches. Cut these grooves perpendicular to the centerline. Before grooving begins, allow the concrete to stiffen sufficiently to prevent dislodging of aggregate. Do not cut grooves within 150 mm 6 inches of a transverse joint or crack.

]3.5.3 Edging

At the time the concrete has attained a degree of hardness suitable for edging, carefully finish slab edges, including edges at formed joints, with an edge having a maximum radius of 3 mm 1/8 inch.[When brooming is specified for the final surface finish, edge transverse joints before starting brooming, then operate broom to obliterate as much as possible the mark left by the edging tool without disturbing the rounded corner left by the edger.] Clean by removing loose fragments and soupy mortar from corners or edges of slabs which have crumbled and areas which lack sufficient mortar for proper finishing. Refill voids solidly with a mixture of suitable proportions and consistency and refinish. Remove unnecessary tool marks and edges. Smooth remaining edges true to line.

3.6 CURING AND PROTECTION

Protect concrete adequately from injurious action by sun, rain, flowing water, [frost,] mechanical injury, tire marks and oil stains, and do not allow it to dry out from the time it is placed until the expiration of the

minimum curing periods specified herein. Do not use membrane-forming compound on surfaces where its appearance would be objectionable, on surfaces to be painted, where coverings are to be bonded to concrete, or on concrete to which other concrete is to be bonded.

3.6.1 Moist Curing

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NOTE: For OCONUS projects using Silica Fume, specify a minimum 24-hour moist cure before applying membrane curing compound.

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Maintain concrete to be moist-cured continuously wet for the entire curing period, or until curing compound is applied, commencing immediately after finishing. If forms are removed before the end of the curing period, provide curing on unformed surfaces, using suitable materials. Cure surfaces by ponding, by continuous sprinkling, by continuously saturated burlap or cotton mats, or by continuously saturated plastic coated burlap. Provide burlap and mats that are clean and free from any contamination and completely saturated before being placed on the concrete. Lap sheets to provide full coverage. Provide an approved work system to ensure that moist curing is continuous 24 hours per day and that the entire surface is wet.

3.6.2 White-Burlap-Polyethylene Sheet

Wet entire exposed surface thoroughly with a fine spray of water, saturate burlap but do not have excessive water dripping off the burlap and then cover concrete with White-Burlap-Polyethylene Sheet, burlap side down. Lay sheets directly on concrete surface and overlap 300 mm 12 inches. Make sheeting not less than 450 mm 18 inches wider than concrete surface to be cured, and weight down on the edges and over the transverse laps to form closed joints. Repair or replace sheets when damaged during curing. Check daily to assure burlap has not lost all moisture. If moisture evaporates, resaturate burlap and re-place on pavement (limit re-saturation and re-placing to less than 10 minutes per sheet). Leave sheeting on concrete surface to be cured for at least 7 days.

3.6.3 Liquid Membrane-Forming Compound Curing

Apply compound immediately after surface loses its water sheen and has a dull appearance and before joints are sawed. Agitate curing compound thoroughly by mechanical means during use and apply uniformly in a two-coat continuous operation by suitable power-spraying equipment. Apply a total coverage for the two coats at least 4 liters one gallon of undiluted compound per 20 square meters 200 square feet to produce a uniform, continuous, coherent film that will not check, crack, or peel and free from pinholes or other imperfections. The application of curing compound by hand-operated, mechanical powered pressure sprayers is permitted only on odd widths or shapes of slabs and on concrete surfaces exposed by the removal of forms. When the application is made by hand-operated sprayers, apply a second coat in a direction approximately at right angles to the direction of the first coat. Apply an additional coat of compound immediately to areas where film is defective. Respray concrete surfaces that are subject to heavy rainfall within 3 hours after curing compound has been applied in the same manner.

3.6.4 Protection of Treated Surfaces

After the initial saw cut is complete and the slurry has been removed, respray the area with curing compound or restore the white burlap polyethylene sheet to maintain a continuous curing environment in the area of the sawn joints. Keep concrete surfaces to which liquid membrane-forming compounds have been applied free from vehicular traffic and other sources of abrasion for not less than 72 hours. Foot traffic is allowed after 24 hours for inspection purposes. Maintain continuity of coating for entire curing period and repair damage to coating immediately.

3.7 FIELD QUALITY CONTROL

3.7.1 Sampling

Collect samples of fresh concrete in accordance with ASTM C172/C172M during each working day as required to perform tests specified herein. Make test specimens in accordance with ASTM C31/C31M.

3.7.2 Consistency Tests

Perform concrete slump tests in accordance with ASTM C143/C143M. Take samples for slump determination from concrete during placement. Perform tests at the beginning of a concrete placement operation and for each batch (minimum) or every 16 cubic meters 20 cubic yards (maximum) of concrete to ensure that specification requirements are met. In addition, perform tests each time test beams are made.

3.7.3 Flexural Strength Tests

Test for flexural strength in accordance with ASTM C78/C78M. Fabricate and cure four test specimens in accordance with ASTM C31/C31M for each set of tests. Test two specimens at 7 days, and the other two at 28 days. Concrete strength will be considered satisfactory when the minimum of the 28-day test results equals or exceeds the specified 28-day flexural strength, and no individual strength test is less than the tolerance indicated on Table 1. If the ratio of the 7-day strength test to the specified 28-day strength is less than 65 percent, make necessary adjustments for conformance. Fabricate, cure and test a minimum of one set of four beams for each shift of concrete placement. Remove concrete which is determined to be defective, based on the strength acceptance criteria therein, and replace with acceptable concrete.

3.7.4 Air Content Tests

Test air-entrained concrete for air content at the same frequency as specified for slump tests. Determine percentage of air in accordance with ASTM C231/C231M on samples taken during placement of concrete in forms.

3.7.5 Surface Testing

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NOTE: Edit these paragraphs as appropriate to the project. If it is desired to restrict surface smoothness testing and evaluation to either straightedge method or profilograph method, retain the one and delete the other; otherwise, retain both as an option. When the profilograph method is allowed, and there are areas with dimensions less

than 60 m 200 feet in any direction, retain the straightedge method for these short runs. Typically, a profilograph is used to measure longitudinal smoothness and a straightedge is used for transverse smoothness.
****

Use the profilograph method for all longitudinal testing, except for paving lanes less than 60 m 200 feet in length. Use the straightedge method for transverse testing, for longitudinal testing where the length of each pavement lane is less than 60 m 200 feet, and at the ends of the paving limits for the project. Smoothness requirements do not apply over crowns, drainage structures, or similar penetrations. Maintain detailed notes of the testing results and submit a copy to the Government after each day's testing.

3.7.5.1 Straightedge Testing Method

Test the surface of the pavement with the straightedge to identify all surface irregularities exceeding the tolerances specified in Table 1. Test the entire area of the pavement in both a longitudinal and a transverse direction on parallel lines approximately 4.5 m 15 feet apart. Hold the straightedge in contact with the surface and move ahead one-half the length of the straightedge for each successive measurement. Determine the amount of surface irregularity by placing the straightedge on the pavement surface and allowing it to rest upon the two highest spots covered by its length and measuring the maximum gap between the straightedge and the pavement surface, in the area between these two high points.

3.7.5.2 Profilograph Testing Method

Perform profilograph testing using approved California profilograph and procedures described in ASTM E1274. Utilize electronic recording and automatic computerized reduction of data equipment to indicate "must-grind" bumps and the Profile Index for each 0.1 km 0.1 mile segment of the day's paving. Accommodate grade breaks on parking lots by breaking the profile segment into short sections and repositioning the blanking band on each section. Provide the "blanking band" of 5 mm 0.2 inch wide and the "bump template" span 25 mm 1 inch with an offset of 10 mm 0.4 inch. Count the profilograph testing of the last 9.1 m 30 feet of a paving lane in the longitudinal direction from each day's paving operation on the following day's continuation lane. Compute the profile index for each pass of the profilograph (3 per lane) in each 0.1 km 0.1 mile segment. The profile index for each segment is the average of the profile indices for each pass in each segment. Scale and proportion profilographs of unequal lengths to an equivalent 0.1 km 0.1 mile as outlined in the ASTM E1274. Submit a copy of the reduced tapes to the Government at the end of each day's testing.

3.7.5.3 "Bumps" (Must Grind Areas)

Reduce any bumps ("must grind" areas) shown on the profilograph trace which exceed 10 mm 0.4 inch in height by diamond grinding in accordance with subparagraph Diamond Grinding until they do not exceed 7.5 mm 0.3 inch when retested. Taper such diamond grinding in all directions to provide smooth transitions to areas not requiring diamond grinding.

3.7.5.4 Diamond Grinding

Those performing diamond grinding are required to have a minimum of three years experience in diamond grinding of rigid concrete pavements. In areas not meeting the specified limits for surface smoothness and plan grade, reduce high areas to attain the required smoothness and grade, except as depth is limited below. Reduce high areas by diamond grinding the hardened concrete with an approved equipment after the concrete is at a minimum age of 14 days. Perform diamond grinding by sawing with an industrial diamond abrasive which is impregnated in the saw blades. Assemble the saw blades in a cutting head mounted on a machine designed specifically for diamond grinding that produces the required texture and smoothness level without damage to the concrete pavement or joint faces. Provide diamond grinding equipment with saw blades that are 3 mm 1/8-inch wide, a minimum of 60 blades per 300 mm 12 inches of cutting head width, and capable of cutting a path a minimum of 0.9 m 3 ft wide. Diamond grinding equipment that causes ravels, aggregate fractures, spalls or disturbance to the joints is not permitted. The maximum area corrected by diamond grinding the surface of the hardened concrete is 10 percent of the total area of a day's production. The maximum depth of diamond grinding is 6 mm 1/4 inch. Provide diamond grinding machine equipped to flush and vacuum the pavement surface. Dispose of all debris from diamond grinding operations off Government property. Prior to diamond grinding, submit a Diamond Grinding Plan for review and approval. At a minimum, include the daily reports for the deficient areas, the location and extent of deficiencies, corrective actions, and equipment. Remove and replace all pavement areas requiring plan grade or surface smoothness corrections in excess of the limits specified in Table 1.[Retexture pavement areas given a wire comb or tined texture, areas exceeding 2 square meters 25 square feet that have been corrected by diamond grinding by transverse grooving using an approved grooving machine of standard manufacture. Provide grooves that are 6 mm 1/4 inch deep by 6 mm 1/4 inch wide on 37 mm 1-1/2 inch centers and carried into, and tapered to zero depth within the non-corrected surface, or match any existing grooves in the adjacent pavement.] All areas in which diamond grinding has been performed are subject to the thickness tolerances specified in Table 1.

3.7.6 Plan Grade Testing and Conformance

Within 5 days after each day's paving, test the finished surface of the pavement area by running lines of levels at intervals corresponding with every longitudinal and transverse joint to determine the elevation at each joint intersection. Record the results of this survey and submit a copy to the Government at the completion of the survey.

3.7.7 Edge Slump

Test the pavement surface to determine edge slump immediately after the concrete has hardened sufficiently to permit walking thereon. Perform testing with a minimum 4 m 12 foot straightedge to reveal irregularities exceeding the edge slump tolerance specified in Table 1. Determine the vertical edge slump at each free edge of each slipformed paving lane constructed. Place the straightedge transverse to the direction of paving and the end of the straightedge located at the edge of the paving lane. Record measurements at 1.5 to 3.0 m 5 to 10 foot spacings, as directed, commencing at the header where paving was started. Initially record measurements at 1.5 m 5 foot intervals in each lane. When no deficiencies are present after 5 measurements, the interval may be increased. The maximum interval is 3.0 m 10 feet. When any deficiencies exist, return

the interval to 1.5 m 5 feet. In addition to the transverse edge slump determination above, at the same time, record the longitudinal surface smoothness of the joint on a continuous line 25 mm 1 inch back from the joint line using the minimum 4 m 12 foot straightedge advanced one-half its length for each reading. Perform other tests of the exposed joint face to ensure that a uniform, true vertical joint face is attained. Properly reference all recorded measurements in accordance with paving lane identification and stationing, and submit a report within 24 hours after measurement is made. Identify areas requiring replacement within the report.

3.7.8 Test for Pavement Thickness

Take full depth cores of 102 millimeter 4 inch diameter of concrete pavement every [_____] square meters square feet in accordance with ASTM C42/C42M. Measure thickness in accordance with ASTM C1542/C1542M. Record and submit testing, inspection, and evaluation of each core for surface paste, uniformity of aggregate distribution, segregation, voids, cracks, and depth of reinforcement or dowel (if present). Moisten the core with water to visibly expose the aggregate and take a minimum of three photographs of the sides of the core, rotating the core approximately 120 degrees between photographs. Include a ruler for scale in the photographs. Submit plan view of location for each core.

3.7.9 Reinforcement

Inspect reinforcement prior to installation to verify it is free of loose flaky rust, loose scale, oil, mud, or other objectionable material.

3.7.10 Dowels

Inspect dowel placement prior to placing concrete to verify that dowels are of the size indicated, and are spaced, aligned and painted and oiled as specified. Do not permit dowels to exceed the tolerances shown in paragraph: DOWEL BARS.

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NOTE: Suggestions for improvement of this specification will be welcomed using the Navy "Change Request Forms" subdirectory located in SPECSINTACT in Jobs or Masters under "Forms/Documents" directory or DD Form 1426. Suggestions should be forwarded to:

Commander
Naval Facilities Engineering Systems Command
Engineering Criteria Office, Code CI1
6506 Hampton Blvd.
Norfolk, VA 23508-1278

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