UNIFIED FACILITIES GUIDE SPECIFICATIONS

References are in agreement with UMRL dated July 2023
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SECTION TABLE OF CONTENTS

DIVISION 32 - EXTERIOR IMPROVEMENTS

SECTION 32 13 14.13

CONCRETE PAVING FOR AIRFIELDS AND OTHER HEAVY DUTY PAVEMENTS

11/22

PART 1 GENERAL

1.1 UNIT PRICES
1.1.1 Measurements
1.1.2 Payments
1.1.2.1 Unit Price
1.1.2.2 Lump Sum
1.1.3 Payment of Lots
1.1.4 Payment Adjustment for Smoothness
1.1.4.1 Straightedge Testing
1.1.4.2 Profilograph Testing
1.1.4.3 Aircraft Arresting Systems
1.1.5 Payment Adjustment for Plan Grade
1.1.6 Payment Adjustment for Thickness
1.2 REFERENCES
1.3 SUBMITTALS
1.4 QUALITY CONTROL
1.4.1 Contractor Quality Control (CQC) Staff
1.4.2 Other Staff
1.4.3 Laboratory Accreditation and Validation
1.4.3.1 Aggregate Testing and Mix Proportioning
1.4.3.2 Acceptance Testing
1.4.3.3 Contractor Pavement Quality Control Plan
1.4.3.4 Laboratory Inspection
1.4.4 Preconstruction Testing of Materials
1.4.4.1 Aggregates
1.4.4.2 Chemical Admixtures, Curing Compounds and Epoxies
1.4.4.3 Testing of Cementitious Materials
1.4.5 Testing During Construction
1.4.6 Test Section
1.4.6.1 General
1.4.6.2 Pilot Lane
1.4.6.3 Fill-In Lane
1.4.6.4 Testing and Inspection

1.4.6.5 Acceptance of Test Section
1.4.7 Acceptability of Work
1.4.8 Acceptance Requirements
1.4.8.1 Pavement Lots
1.4.8.2 Evaluation
1.5 DELIVERY, STORAGE, AND HANDLING
1.5.1 Bulk Cementitious Materials
1.5.2 Aggregate Materials
1.5.3 Other Materials

PART 2 PRODUCTS

2.1 SYSTEM DESCRIPTION
2.1.1 SURFACE SMOOTHNESS
2.1.1.1 Straightedge Testing
2.1.1.2 Profilograph Testing
2.1.1.3 Bumps ("Must Grind" Areas)
2.1.1.4 Testing Method
2.1.1.4.1 Straightedge Testing
2.1.1.4.2 Profilograph Testing
2.1.2 Edge Slump and Joint Face Deformation
2.1.2.1 Edge Slump
2.1.2.2 Joint Face Deformation
2.1.2.3 Edge Slump Determination
2.1.2.4 Excessive Edge Slump or Joint Face Deformation
2.1.3 Plan Grade
2.1.4 Flexural Strength
2.1.4.1 Sampling and Testing
2.1.4.2 Computations
2.1.5 Thickness
2.1.6 Evaluation of Cores
2.1.7 Diamond Grinding of PCC Surfaces
2.2 CEMENTITIOUS MATERIALS
2.2.1 Portland Cement
2.2.2 Blended Cements
2.2.3 Pozzolan
2.2.3.1 Fly Ash
2.2.3.2 Raw or Calcined Natural Pozzolan
2.2.3.3 Ultra Fine Fly Ash and Ultra Fine Pozzolan
2.2.3.4 Silica Fume
2.2.4 Slag Cement
2.2.5 Supplementary Cementitious Materials (SCM) Content
2.3 AGGREGATES
2.3.1 Aggregate Sources
2.3.1.1 Durability of Coarse Aggregate
2.3.1.2 Alkali-Silica Reactivity
2.3.1.3 Combined Aggregate Gradation
2.3.2 Coarse Aggregate
2.3.2.1 Coarse Aggregate Composition
2.3.2.2 Particle Shape Characteristics
2.3.2.3 Size and Grading
2.3.2.4 Deleterious Materials - Airfield Pavements
2.3.2.5 Testing Sequence for Deleterious Materials in Coarse Aggregate - Airfields Only
2.3.2.6 Deleterious Material - Heavy Duty Pavements
2.3.3 Fine Aggregate
2.3.3.1 Fine Aggregate Composition
2.3.3.2 Grading
2.3.3.3 Deleterious Material

2.3.3.4 Testing Sequence for Deleterious Materials in Fine Aggregate - Airfields Only
2.4 CHEMICAL ADMIXTURES
2.4.1 General Requirements
2.4.2 Lithium Nitrate
2.4.3 High Range Water Reducing Admixture (HRWRA)
2.5 MEMBRANE FORMING CURING COMPOUND
2.6 WATER
2.7 JOINT MATERIALS
2.7.1 Expansion Joint Material
2.7.2 Slip Joint Material
2.8 REINFORCING
2.8.1 Reinforcing Bars and Bar Mats
2.8.2 Welded Wire Reinforcement
2.9 DOWELS[AND TIE BARS]
2.9.1 Dowels
2.9.2 Dowel Bar Assemblies
2.9.3 Tie Bars
2.10 EPOXY RESIN
2.11 EQUIPMENT
2.11.1 Batching and Mixing Plant
2.11.1.1 Location
2.11.1.2 Type and Capacity
2.11.1.3 Tolerances
2.11.1.4 Moisture Control
2.11.2 Concrete Mixers
2.11.2.1 Stationary Mixers
2.11.2.2 Mixing Time and Uniformity for Stationary Mixers
2.11.2.3 Abbreviated Uniformity Test
2.11.2.4 Truck
2.11.3 Transporting Equipment
2.11.4 Transfer and Spreading Equipment
2.11.5 Paver-Finisher
2.11.5.1 Vibrators
2.11.5.2 Screed or Extrusion Plate
2.11.5.3 Longitudinal Mechanical Float
2.11.5.4 Other Types of Finishing Equipment
2.11.5.5 Fixed Forms
2.11.5.6 Slipform
2.11.6 Curing Equipment
2.11.7 Texturing Equipment
2.11.7.1 Burlap Drag
2.11.7.2 Broom
2.11.7.3 Artificial Turf
2.11.7.4 Deep Texturing Equipment
2.11.8 Sawing Equipment
2.11.9 Straightedge
2.11.10 Work Bridge
2.11.11 Hand Finishing Tools
2.12 SPECIFIED CONCRETE STRENGTH AND OTHER PROPERTIES
2.12.1 Specified Flexural Strength
2.12.2 Allowable Water-Cementitious Materials Ratio
2.12.3 Air Content
2.12.4 Slump
2.12.5 Concrete Temperature
2.12.6 Concrete Strength for Final Acceptance
2.13 MIXTURE PROPORTIONS
2.13.1 Mixture Proportions Composition
2.13.2 Proportioning Studies

2.13.2.1 Water-Cementitious Materials Ratio
2.13.2.2 Trial Mixture Studies
2.13.2.3 Mixture Proportioning for Flexural Strength
2.13.3 Average CQC Flexural Strength Required for Mixtures
2.13.3.1 From Previous Test Records
2.13.3.2 Without Previous Test Records

PART 3 EXECUTION

3.1 PREPARATION FOR PAVING
3.1.1 Weather Precaution
3.1.2 Proposed Techniques
3.2 CONDITIONING OF UNDERLYING MATERIAL
3.2.1 General Procedures
3.2.2 Traffic on Underlying Material
3.3 WEATHER LIMITATIONS
3.3.1 Placement and Protection During Inclement Weather
3.3.2 Paving in Hot Weather
3.3.3 Prevention of Plastic Shrinkage Cracking
3.3.4 Paving in Cold Weather
3.4 CONCRETE PRODUCTION
3.4.1 Batching and Mixing Concrete
3.4.2 Transporting and Transfer - Spreading Operations
3.5 PAVING
3.5.1 General Requirements
3.5.2 Consolidation
3.5.3 Operation
3.5.4 Required Results
3.5.5 Fixed Form Paving
3.5.5.1 Forms for Fixed-Form Paving
3.5.5.2 Form Removal
3.5.6 Slipform Paving
3.5.6.1 General
3.5.6.2 Guideline for Slipform Paving
3.5.6.3 Stringless Technology
3.5.7 Placing Reinforcing Steel
3.5.7.1 Pavement Thickness Greater Than 300 mm 12 inches
3.5.7.2 Pavement Thickness Less Than 300 mm 12 Inches
3.5.8 Placing Dowels[and Tie Bars]
3.5.8.1 Contraction Joints
3.5.8.2 Construction Joints-Fixed Form Paving
3.5.8.3 Dowels Installed in Hardened Concrete
3.5.8.4 Lubricating Dowel Bars
3.6 FINISHING
3.6.1 Machine Finishing With Fixed Forms
3.6.2 Machine Finishing with Slipform Pavers
3.6.3 Surface Correction and Testing
3.6.4 Hand Finishing
3.6.4.1 Equipment and Template
3.6.4.2 Finishing and Floating
3.6.5 Texturing
3.6.5.1 Burlap Drag Surface
3.6.5.2 Broom Texturing
3.6.5.3 Artificial Turf Drag Surface
3.6.5.4 Wire-Comb Texturing
3.6.5.5 Surface Grooving
3.6.6 Edging
3.6.7 Pavement Penetrations
3.7 CURING

3.7.1 Protection of Concrete
3.7.2 Membrane Curing
3.7.3 Moist Curing
3.8 JOINTS
3.8.1 General Requirements for Joints
3.8.2 Longitudinal Construction Joints
3.8.3 Transverse Construction Joints
3.8.4 Expansion Joints
3.8.5 Slip Joints
3.8.6 Contraction Joints
3.8.7 Thickened Edge Joints
3.9 REPAIR, REMOVAL AND REPLACEMENT OF NEWLY CONSTRUCTED SLABS
3.9.1 General Criteria
3.9.2 Repair of Free Edge Lane Vertical Faces
3.9.3 Slabs with Cracks
3.9.4 Removal and Replacement of Full Slabs
3.9.5 Repairing Spalls Along Joints
3.9.6 Weak Surfaces
3.9.7 Repair of Pilot Lane Vertical Faces
3.10 EXISTING CONCRETE PAVEMENT REMOVAL AND REPAIR
3.10.1 Removal of Existing Pavement Slab
3.10.2 Edge Repair
3.10.2.1 Spall Repair
3.10.2.2 Underbreak and Underlying Material
3.11 PAVEMENT PROTECTION
3.12 TESTING AND INSPECTION FOR CONTRACTOR QUALITY CONTROL DURING CONSTRUCTION
3.12.1 Testing and Inspection by Contractor
3.12.2 Testing and Inspection Requirements
3.12.3 Control Charts
3.12.4 Concrete Strength Testing for CQC
3.12.5 Reports

-- End of Section Table of Contents --

UNIFIED FACILITIES GUIDE SPECIFICATIONS

References are in agreement with UMRL dated July 2023
****

SECTION 32 13 14.13

CONCRETE PAVING FOR AIRFIELDS AND OTHER HEAVY DUTY PAVEMENTS
11/22

****
NOTE: This guide specification covers the requirements for construction of concrete pavement for Army, Navy and Air Force airfields and heavy-duty roads, parking areas, hardstands, and vehicular pavement.

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

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

PART 1 GENERAL

****
NOTE: In preparing contract specifications for concrete pavement, use UFC 3-250-04 STANDARD PRACTICE FOR CONCRETE PAVEMENTS for guidance. Use UFGS 32 13 13.06, "Portland Cement Concrete Pavement for Roads and Site Facilities," or State highway specifications only for non organizational parking, roads, streets, and driveways where the equivalent passes of an 18-kip ESAL are less than 5.7 million. Use UFGS 32 13 14.13 for all organizational vehicle parking, special military vehicles, and airfield concrete pavements. Special military vehicles identified in UFC 3-201-1 include, but are not limited to: cranes, aircraft tow tractors, forklifts, container handling vehicles, tracked vehicles, heavy military cargo trucks (greater than 10,000 pounds (4535 kg) (e.g., Heavy Expanded Mobility Tactical Truck (HEMTT), Heavy Equipment Transport Systems (HETS), Palletized Load Systems (i.e. M1074, M1075), Mine Resistant Ambush Protected

(MRAP), and Stryker vehicles.

Edit specifications developed for Corps of Engineers managed projects in accordance with ER 1110-34-1 Engineering and Design Transportation Systems Mandatory Center of Expertise (Section 11, 12, App A, B, C).

Contact the Corps of Engineers Transportation Systems Center (TSMCX), the Air Force Civil Engineer Center (AFCEC) pavement Subject Matter Expert (SME), or Naval Facilities Engineering Systems Command (NAVFAC) for guidance on interpreting and editing this specification section.

This specification section is structured for Contractor sampling and testing of materials and mixture proportioning. If Government sampling, testing and mixture proportioning are required, contact the TSMCX, AFCEC pavement SME, or NAVFAC for specification language.

****

1.1 UNIT PRICES

1.1.1 Measurements

The quantity of concrete to be paid for will be the volume of concrete in cubic meters yards including thickened edges [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 or beveled edges or the space occupied by pavement reinforcement, dowel bars, [tie bars,]or electrical conduits, nor for any void, or other structure extending into or through the pavement slab, measuring 0.1 cubic meter 3 cubic feet or less in volume. No other allowance for concrete will be made unless placed in specified locations in accordance with the approved contract modification. The quantity of other materials specified herein, and used in the construction of the work covered by this section, will not be measured for payment, but will be considered a subsidiary obligation, covered under the price per cubic meter yard for concrete. Joint sealing materials are covered in Section 32 01 19.61 SEALING OF JOINTS IN RIGID PAVEMENT or 32 13 73.19 COMPRESSION CONCRETE PAVING JOINT SEALANT.

1.1.2 Payments

****

NOTE: Use the applicable paragraph from the two choices below and delete the other. For Lump Sum payment, include concrete unit price from Government estimate in paragraph LUMP SUM to provide cost basis for calculating payment reduction.

Always retain one payment method.

****

1.1.2.1 Unit Price

The quantity of concrete measured as specified above will be paid for at the contract unit price when placed in completed and accepted pavements. Payment will be made at the contract price for cubic meter yard for the scheduled item, with necessary adjustments as specified below. Payment will constitute full compensation for providing all materials, equipment, plant and tools, and for all labor and other incidentals necessary to complete the concrete pavement, except for other items specified herein for separate payment.

1.1.2.2 Lump Sum

The quantity of concrete will be paid for and included in the lump-sum contract price. If less than 100 percent payment is due based on the pay factors stipulated below, a unit price of [_____] per cubic meter yard will be used for purposes of calculating the payment reduction. Payment will constitute full compensation for all materials, equipment, plant and tools, and for all labor and other incidentals necessary to complete the concrete pavement, except for other items specified herein for separate payment.

1.1.3 Payment of Lots

When a lot of material fails to meet the specification requirements, that lot will be accepted at a reduced price or be removed and replaced. The lowest computed percent payment determined for any pavement characteristic discussed below (for example, thickness, grade, and surface smoothness) becomes the actual percent payment for that lot. The actual percent payment will be applied to the unit price and the measured quantity of concrete in the lot to determine actual payment. Use results of strength tests to control concreting operations. Strength will be evaluated, but will not be considered for payment adjustment. Remove and replace any sublot not meeting the required 'Concrete Strength for Final Acceptance' at no additional cost to the Government.

1.1.4 Payment Adjustment for Smoothness

1.1.4.1 Straightedge Testing

Record location and deviation from straightedge for all measurements. Determine the computed percent payment for straightedge testing by entering Table 1.

TABLE 1	
PAYMENT ADJUSTMENT FOR SMOOTHNESS USING STRAIGHTEDGE	
Deviation from straightedge for all measurements made within a lot exceed the tolerance specified in paragraph SURFACE SMOOTHNESS by:	Computed Percent Payment
Less than or equal to 5.0 percent	100

TABLE 1	
PAYMENT ADJUSTMENT FOR SMOOTHNESS USING STRAIGHTEDGE	
Deviation from straightedge for all measurements made within a lot exceed the tolerance specified in paragraph SURFACE SMOOTHNESS by:	Computed Percent Payment
More than 5.0 percent but Less than or equal to 10.0 percent, after any reduction of high spots or removal and replacement	95
More than 10.0 percent but Less than or equal to 15.0 percent	90
More than 15.0 percent but Less than or equal to 20.0 percent	75
More than 20.0 percent	Remove and Replace

1.1.4.2 Profilograph Testing

Record location and data from all profilograph measurements. Determine the computed percent payment for profilograph smoothness by entering Table 2.

TABLE 2	
PAYMENT ADJUSTMENT FOR SMOOTHNESS USING PROFILOGRAPH	
Profile Index of a 0.1 km 0.1 mile segment of a lot exceeds the tolerance specified in paragraph SURFACE SMOOTHNESS by:	Computed Percent Payment
Less than 16 mm per km 1.0 inch per mile	100
16 mm per km 1.0 inch per mile but Less than 32 mm per km 2.0 inches per mile, after any reduction of high spots or removal and replacement	95
32 mm per km 2.0 inches per mile but Less than 47 mm per km 3.0 inches per mile	90
47 mm per km 3.0 inches per mile but Less than 63 mm per km 4.0 inches per mile	75

TABLE 2	
PAYMENT ADJUSTMENT FOR SMOOTHNESS USING PROFILOGRAPH	
Profile Index of a 0.1 km 0.1 mile segment of a lot exceeds the tolerance specified in paragraph SURFACE SMOOTHNESS by:	Computed Percent Payment
63 mm per km 4.0 inches per mile or more	Remove and Replace

1.1.4.3 Aircraft Arresting Systems

****

NOTE: Delete this paragraph, AIRCRAFT ARRESTING SYSTEMS, if not present or impacted by paving operations.

****

The 60 m 200 feet of airfield pavement on both the approach and departure sides of the arresting system pendant is a critical area. Consider this area as a separate lot for payment adjustment for smoothness. Protruding objects and undulating surfaces are detrimental to successful tailhook engagements and are not allowable. No exceedance of the tolerances specified in paragraph STRAIGHTEDGE TESTING is acceptable. Remove and replace pavements exceeding the tolerances.

1.1.5 Payment Adjustment for Plan Grade

Determine the computed percent payment for plan grade by entering TABLE 3.

TABLE 3	
PAYMENT ADJUSTMENT FOR PLAN GRADE	
Percent of all measurements made within a lot are outside the specified tolerance	Computed Percent Payment
Less than or equal to 5.0	100
More than 5.0 but Less than or equal to 10.0	95
More than 10.0 but Less than 20	90
More than 20.0 but Less than 50	75
50 or more	Remove and Replace

1.1.6 Payment Adjustment for Thickness

Using the Average Thickness of the lot, determine the computed percent payment for thickness by entering Table 4.

TABLE 4		
PAYMENT ADJUSTMENT FOR THICKNESS		
Deficiency in Thickness Determined by cores millimetersinches	Computed Percent Payment	
	Pavements Equal To or Greater Than 200 mm 8 inches Thick	Pavements Less Than 200 mm 8 inches Thick
0.00 to 6.2 0.00 to 0.24	100	100
6.3 to 12.5 0.25 to 0.49	75	65
12.6 to 18.9 0.50 to 0.74	50	Remove and Replace
19.0 0.75 or greater	Remove and Replace	Remove and Replace

Where either of the two cores from a sublot show a thickness deficiency of 19 mm 0.75 inch or greater, [13 mm 0.50 inch for pavements 200 mm 8 inches or less in thickness] drill two more cores in the sublot and compute the average thickness of the four cores. If this average shows a thickness deficiency of 19 mm 0.75 inch or more [13 mm 0.50 inch for pavements 200 mm 8 inches or less in thickness] remove the entire sublot.

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 ASSOCIATION OF STATE HIGHWAY AND TRANSPORTATION OFFICIALS (AASHTO)

AASHTO M 182	(2005; R 2017) Standard Specification for Burlap Cloth Made from Jute or Kenaf and Cotton Mats

AMERICAN CONCRETE INSTITUTE (ACI)

ACI 201.1R	(2008) Guide for Conducting a Visual Inspection of Concrete in Service
ACI 211.1	(1991; R 2009) Standard Practice for Selecting Proportions for Normal, Heavyweight and Mass Concrete
ACI 214R	(2011) Evaluation of Strength Test Results of Concrete
ACI 305R	(2020) Guide to Hot Weather Concreting
ACI 306R	(2016) Guide to Cold Weather Concreting
ACI 325.14R	(2017) Guide for Design and Proportioning of Concrete Mixtures for Pavements

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 A996/A996M	(2016) Standard Specification for Rail-Steel and Axle-Steel Deformed Bars for Concrete Reinforcement
ASTM A1064/A1064M	(2022) Standard Specification for Carbon-Steel Wire and Welded Wire Reinforcement, Plain and Deformed, for Concrete
ASTM A1078/A1078M	(2019) Standard Specification for Epoxy-Coated Steel Dowels in Concrete Pavement
ASTM C29/C29M	(2017a) Standard Test Method for Bulk Density ("Unit Weight") and Voids in Aggregate
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 C39/C39M	(2021) Standard Test Method for Compressive Strength of Cylindrical Concrete Specimens
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 C114	(2022) Standard Test Methods for Chemical Analysis of Hydraulic Cement
ASTM C117	(2017) Standard Test Method for Materials Finer than 75-um (No. 200) Sieve in Mineral Aggregates by Washing
ASTM C123/C123M	(2014) Standard Test Method for Lightweight Particles in Aggregate
ASTM C125	(2021a) Standard Terminology Relating to Concrete and Concrete Aggregates
ASTM C131/C131M	(2020) Standard Test Method for Resistance to Degradation of Small-Size Coarse Aggregate by Abrasion and Impact in the Los Angeles Machine
ASTM C136/C136M	(2019) Standard Test Method for Sieve Analysis of Fine and Coarse Aggregates
ASTM C138/C138M	(2017a) Standard Test Method for Density (Unit Weight), Yield, and Air Content (Gravimetric) of Concrete
ASTM C142/C142M	(2017) Standard Test Method for Clay Lumps and Friable Particles in Aggregates
ASTM C143/C143M	(2020) Standard Test Method for Slump of Hydraulic-Cement Concrete
ASTM C150/C150M	(2022) Standard Specification for Portland Cement
ASTM C172/C172M	(2017) Standard Practice for Sampling Freshly Mixed Concrete
ASTM C174/C174M	(2017) Standard Test Method for Measuring Thickness of Concrete Elements Using Drilled Concrete Cores
ASTM C192/C192M	(2019) Standard Practice for Making and Curing Concrete Test Specimens in the

	Laboratory
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 C294	(2012; R 2017) Standard Descriptive Nomenclature for Constituents of Concrete Aggregates
ASTM C295/C295M	(2019) Standard Guide for Petrographic Examination of Aggregates for Concrete
ASTM C309	(2019) Standard Specification for Liquid Membrane-Forming Compounds for Curing Concrete
ASTM C457/C457M	(2023) Standard Test Method for Microscopical Determination of Parameters of the Air-Void System in Hardened 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 C666/C666M	(2015) Resistance of Concrete to Rapid Freezing and Thawing
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 C1064/C1064M	(2017) Standard Test Method for Temperature of Freshly Mixed Hydraulic-Cement 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 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 C1646/C1646M	(2016) Making and Curing Test Specimens for Evaluating Frost Resistance of Coarse Aggregate in Air-Entrained Concrete by Rapid Freezing and Thawing
ASTM C1895	(2020) Standard Test Method for Determination of Mohs Scratch Hardness
ASTM D75/D75M	(2019) Standard Practice for Sampling Aggregates
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 D3665	(2012; R 2017) Standard Practice for Random Sampling of Construction Materials
ASTM D4791	(2019) Flat Particles, Elongated Particles, or Flat and Elongated Particles in Coarse Aggregate
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

U.S. ARMY CORPS OF ENGINEERS (USACE)

COE CRD-C 55	(1992) Test Method for Within-Batch

	Uniformity of Freshly Mixed Concrete
COE CRD-C 130	(2001) Standard Recommended Practice for Estimating Scratch Hardness of Coarse Aggregate Particles
COE CRD-C 143	(1962) Specifications for Meters for Automatic Indication of Moisture in Fine Aggregate
COE CRD-C 300	(1990) Specifications for Membrane-Forming Compounds for Curing Concrete
COE CRD-C 521	(1981) Standard Test Method for Frequency and Amplitude of Vibrators for Concrete
COE CRD-C 662	(2009) Determining the Potential Alkali-Silica Reactivity of Combinations of Cementitious Materials, Lithium Nitrate Admixture and Aggregate (Accelerated Mortar-Bar Method)

U.S. DEPARTMENT OF DEFENSE (DOD)

TSPWG M 3-250-04.97-05	(2019) Proportioning Concrete Mixtures with Graded Aggregates for Rigid Airfield Pavements

1.3 SUBMITTALS

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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.

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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-01 Preconstruction Submittals

Proposed Techniques; G[, [_____]]

Preliminary Proposed Proportioning; G, DO

Pavement Quality Control Plan; G[, [_____]]

Stringless Technology; G[, [_____]]

SD-03 Product Data

Diamond Grinding Plan; G[, [_____]]

Dowels; G[, [_____]]

Dowel Bar Assemblies; G[, [_____]]

Equipment; G[, [_____]]

Concrete Patching Mixture; G[, [_____]]

SD-05 Design Data

Proportioning Studies; G, DO

SD-06 Test Reports

Batch Plant Manufacturer's Inspection Report; G[, [_____]]

Slipform Paver Manufacturer's Inspection Report; G[, [_____]]

Sampling and Testing; G[, [_____]]

Diamond Grinding of PCC Surfaces; G[, [_____]]

Mixer Performance (Uniformity) Testing; G[, [_____]]

Repair Recommendations Plan; G[, [_____]]

Paving Lot Report; G[, [_____]]

SD-07 Certificates

Contractor Quality Control (CQC) Staff; G[, [_____]]

Laboratory Accreditation and Validation; G[, [_____]]

Commercial Laboratory; G[, [_____]]

NRMCA Certificate of Conformance

Petrographer Resume; G[, [_____]]

Licensed Surveyor; G[, [_____]]

Concrete Batch Plant Operator; G[, [_____]]

Profilograph Operator; G[, [_____]]

1.4 QUALITY CONTROL

****
NOTE: Select UFGS Section 01 45 00 for Army, Air Force, and Navy Projects, and 01 45 00.00 40 for NASA projects. Delete the others.

For Air Force and Army airfield paving projects, retain the first bracketed statement, delete the second bracketed statement, and coordinate Concrete Paving CQC Manager requirements with CQC System Manager paragraph of the Quality Control specification (01 45 00).

For Other Heavy Duty (non-airfield) paving projects, retain the second bracketed statement, delete the first bracketed statement, and ensure consistency with the Quality Control specification.
****

1.4.1 Contractor Quality Control (CQC) Staff

Reference Section [01 45 00] [01 45 00.00 40] QUALITY CONTROL for general CQC personnel qualification requirements. In addition, submit specific CQC personnel qualification requirements listed below. Submit qualifications and resumes for the Concrete Paving CQC Manager and petrographer. Submit certification for all CQC personnel assigned to concrete construction for their respective position:

a. Identify an individual within the onsite work organization as the Concrete Paving CQC Manager, who is responsible for overall management of concrete paving CQC and has the authority to act in all concrete paving CQC matters including authority to stop concrete paving work which is out of compliance.

   [The minimum requirements for the Concrete Paving CQC Manager consist of 8 years airfield concrete paving experience similar to work required under this contract with a minimum of 3 years in a concrete paving CQC role. The Concrete Paving CQC Manager is a separate person, and is in addition to the [CQC System Manager identified in Section 01 45 00] [Quality Program Manager identified in Section 01 45 00.00 40] QUALITY CONTROL.]

[The minimum requirements for the Concrete Paving CQC Manager consist of 5 years concrete paving experience similar to work required under this contract with a minimum of 2 years in a concrete paving CQC role. The Concrete Paving CQC Manager can also serve as the [CQC System Manager provided they meet the requirements of Section 01 45 00][Quality Program Manager provided they meet the requirements of Section 01 45 00.00 40] QUALITY CONTROL and the Concrete Paving CQC Manager experience requirements above.]

b. CQC personnel responsible for inspection of concrete paving operations: ACI Concrete Transportation Construction Inspector. The ACI Concrete Transportation Construction Inspector is required to be present at the paving site during all paving operations, with the exception of the initial saw cutting operation. The QC manager is required to be present during initial saw cutting operations.

c. CQC staff is required to oversee all aspects of sawing operations (sawing, flushing, vacuuming, checking for random cracking, lighting).

d. Lead Foreman or Journeyman of the Concrete Placing, Finishing, and Curing Crews: ACI Advanced Concrete Flatwork Finisher.

e. Batch Plant Manufacturer's Representative: A technical representative from the batch plant manufacturer is required to be on-site during the test section construction and when a stop is required per Table 17 to inspect and make necessary adjustments to all components of the batch plant including but not limited to aggregate bin weighing operations, water metering, cement and fly ash weighing devices. All necessary inspections and adjustments by the manufacturer technical representative are required to be performed prior to uniformity testing. Submit a written Batch Plant Manufacturer's Inspection Report signed by the technical representative noting all inspection items and corrections and stating the batch plant is capable of producing the volume of concrete as required herein.

f. Field Testing Technicians: ACI Concrete Field Testing Technician, Grade I.

g. Slipform Paving Equipment Manufacturer's Representative: A technical representative of the slipform paving equipment manufacturer is required to be on-site during the test section construction to inspect and make corrections to the paving equipment to provide proper operations. Perform a complete and full hydraulic flow test of the vibrator system prior to the test section being placed. Submit a written Slipform Paver Manufacturer's Inspection Report signed by the manufacturer's technical representative noting all inspections, corrections, and flow tests have been performed and the paver is in a condition to perform the required work.

h. Laboratory Testing Technicians: ACI Concrete Strength Testing Technician and ACI Concrete Laboratory Testing Technician, Level 1 or 2.

1.4.2 Other Staff

Submit for approval the qualifications and resumes for the following staff:

a. Petrographer: Bachelor of Science degree in geology or petrography,

trained in petrographic examination of concrete aggregate according to ASTM C294 and ASTM C295/C295M and trained in identification of the specific deleterious materials and tests identified in this specification. Detail the education, training and experience related to the project-specific test methods and deleterious materials in the Petrographer Resume and submit at least 20 days before petrographic and deleterious materials examination is to commence.

b. Licensed Surveyor: Perform all survey work under the supervision of a Licensed Surveyor.

c. Concrete Batch Plant Operator: National Ready Mix Concrete Association (NRMCA) Plant Manager certification.

d. Profilograph Operator: Certification by equipment manufacturer or a state Department of Transportation.

1.4.3 Laboratory Accreditation and Validation

****

NOTE: At the discretion of the Navy project engineer, the requirements for the USACE MTC validation of construction testing laboratories may be deleted. Validation of the project laboratories will provide an additional level of quality control for the project, and is strongly recommended by NAVFAC and USACE based on past experience.

For all Air Force and Army projects, retain the bracketed statement requiring USACE MTC validation of laboratories.

****

Provide laboratory and testing facilities. Submit accreditation of the commercial laboratory by an independent evaluation authority, indicating conformance to ASTM C1077, including all applicable test procedures identified in this specification. If multiple laboratories are proposed, identify which tests will be conducted by each. Submit accreditation documentation a minimum of 30 days before any specified testing is performed. The laboratories performing the tests are required to be accredited in accordance with ASTM C1077, including ASTM C78/C78M and ASTM C1260. Provide current accreditation and include the required and optional test methods, as specified. [In addition, all laboratories performing testing require USACE validation by the Material Testing Center (MTC) for both parent laboratory and on-site laboratory. Validation on all laboratories is required to remain current throughout the duration of the paving project. Request MTC laboratory validation at https://mtc.erdc.dren.mil/requestvalidation.aspx for costs and scheduling. Contact the MTC Director at https//mtc.erdc.dren.mil/contact2.aspx with questions or additional information.]

1.4.3.1 Aggregate Testing and Mix Proportioning

Aggregate testing and mixture proportioning studies are required to be performed by a commercial laboratory.

1.4.3.2 Acceptance Testing

****

NOTE: While ASTM C31 and ASTM C192 allow use of other materials for beam molds, steel molds are required for flexural beam specimens (ASTM C78).
****

Provide all materials, labor, and facilities required for molding, curing, testing, and protecting test specimens at the paving site and in the laboratory. Provide steel molds for molding the beam specimens. Provide on-site temperature-controlled concrete curing facilities. Provide and maintain boxes or other facilities suitable for storing and curing the specimens at the paving site while in the mold within the temperature range stipulated by ASTM C31/C31M. [Provide flexural loading equipment in accordance with ASTM C78/C78M] [Provide compressive loading equipment in accordance with ASTM C39/C39M.]

1.4.3.3 Contractor Pavement Quality Control Plan

****
NOTE: Select UFGS Section 01 45 00 for Army, Air Force, and Navy Projects, and 01 45 00.00 40 for NASA projects. Delete the others.
****

Submit the Pavement Quality Control Plan. The Pavement Quality Control Plan is specific to this specification and supplements the overall Quality Control Plan required by [01 45 00] [01 45 00.00 40]. Do not produce portland cement concrete pavement for payment until the pavement quality control plan has been approved. In the pavement quality control plan, address all elements which affect the quality of the pavement including, but not limited to:

a. Condition of underlying course
b. Condition of adjacent pavement and dowels
c. Stockpile management and aggregate grading
d. Mix proportions and batching operations
e. Transportation
f. Placing and consolidation
g. Placing dowels [and tie bars]
h. Finishing and texturing
i. Curing
j. Sawcutting Joints
k. CQC Testing and Inspection
l. Inclement / Hot / Cold Weather Plans

1.4.3.4 Laboratory Inspection

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. The laboratory is to maintain this certification for the duration of the project.

1.4.4 Preconstruction Testing of Materials

****

NOTE: For Design Build Contracts the testing is performed by the Contractor utilizing an approved petrographer and commercial testing laboratory. Delete any subparagraphs which are not applicable. Fill in blanks as appropriate.
****

All sampling and testing is required to be performed using an approved commercial laboratory or, for cementitious materials and chemical admixtures, a laboratory maintained by the manufacturer of the material. Materials are not allowed to be used until notice of acceptance has been given. Additional payment or extension of time due to failure of any material to meet project requirements, or for any additional sampling or testing required is not allowed. Additional tests may be performed by the Government; such Government testing does not relieve any required testing responsibilities.

1.4.4.1 Aggregates

Sample aggregates in the presence of a Government Representative. Obtain samples representative of the materials to be used for the project in accordance with ASTM D75/D75M. Perform all aggregate tests no earlier than 6 months prior to test section construction.

1.4.4.2 Chemical Admixtures, Curing Compounds and Epoxies

At least 30 days before the material is used, submit certified copies of test results for the specific lots or batches to be used on the project. Provide test results less than 5 years old prior to use in the work. Retest chemical admixtures that have been in storage for longer than 6 months or that have been subjected to temperatures outside of manufacturer requirements. Reject if test results do not meet the Level 2 proof of compliance requirements of ASTM C494/C494M.

1.4.4.3 Testing of Cementitious Materials

All materials referenced under paragraph CEMENTITIOUS MATERIALS will be accepted on the basis of manufacturer's certification of compliance, accompanied by mill test reports showing that the material in each shipment meets the requirements of the specification under which it is provided. Provide mill test reports no more than 1 month old, prior to use in the work. Do not use cementitious materials until notice of acceptance has been given. Cementitious materials may be subjected to testing by the Government from samples obtained at the mill, at transfer points, or at the project site. If tests prove that a cementitious material that has been delivered is unsatisfactory, promptly remove it from the project site. Retest cementitious material that has not been used within 6 months after testing, and reject if test results do not meet manufacturer requirements.

1.4.5 Testing During Construction

During construction, sample and test aggregates, cementitious materials, and concrete as specified herein. The Government will sample and test concrete and ingredient materials as considered appropriate. Provide facilities and labor necessary for procurement of representative test samples. Testing by the Government does not relieve the specified testing requirements.

1.4.6 Test Section

****
NOTE: If test section is not to be part of the production pavement area, delete the bracketed sentence referring to test sections constructed as part of production pavement and production lot payment.
****

1.4.6.1 General

a. After all plant, personnel, material, equipment, paving schedule, and uniformity testing submittals have been reviewed and approved, the test section paving can be scheduled.

b. Construct a separate test section for each placement method proposed for use. Construct a separate test section for each paver and each batch plant proposed for use.

c. Up to 15 days, but not more than 60 days, prior to construction of the concrete pavement, construct a test section [near the job site, but not as part of the production pavement area.][as part of the production paving area at an outer edge as indicated on the drawings.] Construct the pilot lane and fill-in lane test sections on separate days using the approved mixture proportions. Aggregate proportioning changes may be required due to specification requirements not being met.

d. Construct the test section matching the thickest pavement section and underlying structure required in the work. Use the same equipment, materials, and construction techniques on the test sections as proposed for use in all subsequent work. The underlying layers must be reviewed and approved by the Government prior to paving of the test section.

e. Perform underlying layer preparation, concrete production, placing, consolidating, texturing, curing, construction of joints, and all testing in accordance with applicable provisions of this specification.

f. Use the test sections to develop and demonstrate the proposed techniques of mixing, hauling, placing, consolidating, finishing, texturing, curing, initial saw cutting, start-up procedures, sampling, testing methods, plant operations, and the preparation of the construction joints for production paving. Report per requirements of paragraph Reports.

1.4.6.2 Pilot Lane

Construct the test section consisting of one continuous paving lane at least 130 m 400 feet long and to the same thickness as the thickest portion of pavement shown on the Drawings. The test section may not exceed 180 m 600 feet; all pavement placed for the test section before or after 130 m 400 feet of continuously acceptable placement must be removed. Construct at the same lane width as that required for use in the project. If [keyed or]doweled longitudinal construction joints are required in any of the production pavements, install them full length along one side of the test lane throughout the test section. [If both

keys and dowels are required, install each in half of the test section.]

1.4.6.3 Fill-In Lane

A fill-in lane is defined as full width concrete placement using two adjacent lanes as forms. Consider the first 130 m 400 feet of the initial production fill-in lane as a test section for purposes of testing and evaluation. All requirements for the test section are applicable. Obtain cores from the fill-in lane side of the longitudinal construction joint with the pilot lane.

1.4.6.4 Testing and Inspection

a. Provide aggregate, fresh concrete, and hardened concrete sampling and testing in accordance with paragraph Testing and Inspection by Contractor and Table 17. Provide inspection of the hardened concrete for surface smoothness, plan grade, edge slump and joint face deformation in accordance with the specifications. Provide a test section report in accordance with paragraph Reports.

b. Provide sampling and testing of the fresh air content of the concrete on samples obtained before and after the paver. Provide stationing references so samples before and after the paver can be obtained from the same location. After the paver, obtain a composite sample to the full depth of the placement. Obtain one sample from along the vibrator path and the second from between vibrators at each of two locations across the pavement width. Sample no closer than 600 mm 24 inches from the edge of the slab. Obtain samples from the interior of the slab from a work bridge spanning the lane width. Immediately fill voids resulting from sample collection with freshly mixed concrete, strike off, consolidate with an internal vibrator, and refinish.

c. No more than three working days after completion of the test sections, procure and evaluate eight cores with a minimum diameter of 150 mm 6 inches by full depth cut from points selected in the test sections by the Government on a basis of two cores per sublot. Evaluate cores in accordance with paragraph: Evaluation of Cores.

1.4.6.5 Acceptance of Test Section

a. Construct the test sections meeting the specification requirements including plastic and hardened concrete properties, surface texture, thickness, grade, smoothness, joint face deformation, edge slump, and plan joint alignment.

b. Compare the air contents taken before and after the paver to evaluate air loss through the paver. Limit the difference between before and after values within the tolerances of the design air content indicated in paragraph Air Content. Evaluate values exceeding this tolerance by determining the air void spacing and air void content in accordance with ASTM C457/C457M on core samples obtained on the same longitudinal line two/six meters/feet ahead of the sampling location as the fresh sample. Adjust the mix design air content behind the paver to meet the design air content and inspect the vibrators.

c. Do not commence production paving until the results on aggregates and concrete, including evaluation of cores, and all pavement measurements for edge slump, joint face deformation, actual plan grade, surface smoothness, and thickness have been submitted and approved, and the

payment calculation has been submitted for information only. Remove test sections which do not meet specification requirements and conduct additional test sections, as required. If an acceptable test section is unable to be constructed by slipform paving, repair or replace the slipform paving equipment, or complete the paving using fixed-forms and equipment as required by the specification. [Pavement accepted as a production lot will be evaluated and paid as specified in PART 1 GENERAL.]

1.4.7 Acceptability of Work

The materials and the pavement itself will be accepted on the basis of production testing. The Government may make check tests to validate the results of the production testing. If the results of the production testing vary by less than 2.0 percent of the Government's test results, the results of the production testing will be used. If the results of the Government and production tests vary by 2.0 percent, but less than 4.0 percent, the average of the two will be considered the value to be used. If these vary by 4.0 percent or more, carefully evaluate each sampling and testing procedure and obtain another series of Government and production tests on duplicate samples of material. If these vary by 4.0 percent or more, use the results of the tests made by the Government and the Government will continue check testing of this item on a continuous basis until the two sets of tests agree within less than 4.0 percent on a regular basis. Testing performed by the Government does not relieve the specified testing requirements.

1.4.8 Acceptance Requirements

1.4.8.1 Pavement Lots

****

NOTE: Specify the lot size on the basis of volume of production. Select the lot size not to exceed 750 cubic meters 1000 cubic yards of concrete pavement. When the total job does not exceed 750 cubic meters 1000 cubic yards, the lot size becomes the total job. Edit the following paragraphs accordingly. Do not change terminology (for instance computed percent payment, actual percent payment).

****

A lot is that quantity of construction to be evaluated for acceptance with specification requirements. A lot is equal to production paving not to exceed [750] [ ] cubic meters [1000] [ ] cubic yards. In order to evaluate thickness, divide each lot into sublots not to exceed 190 cubic meters 250 cubic yards. Make grade determinations on the lot as a whole. Make surface smoothness determinations on every 0.1 km 0.1 mile segment in each lot. Select sample locations on a random basis in accordance with ASTM D3665. [Areas of pavement placed with hand methods are considered a separate lot for evaluation.]When operational conditions cause a lot to be terminated before the specified four sublots have been completed, use the following procedure to adjust the lot size and number of tests for the lot. Where three sublots have been completed, they constitute a lot. Where one or two sublots have been completed, incorporate them into the next lot (except for the last lot), and the total number of sublots used and acceptance criteria adjusted accordingly.

1.4.8.2 Evaluation

Provide all sampling and testing required for acceptance and payment adjustment, including batch tickets with all required acceptance testing. Individuals performing sampling, testing and inspection duties are required to meet the requirements of paragraph: Contractor Quality Control Staff. The Government reserves the right to direct additional samples and tests for any area which appears to deviate from the specification requirements. Testing in these areas are in addition to the sublot or lot testing, and the requirements for these areas are the same as those for a sublot or lot. Provide facilities, and where directed personnel, to assist in obtaining samples for any Government testing.

1.5 DELIVERY, STORAGE, AND HANDLING

1.5.1 Bulk Cementitious Materials

Provide all cementitious materials in bulk at a temperature, as delivered to storage at the site, not exceeding 65 degrees C 150 degrees F. Provide sufficient cementitious materials in storage to sustain continuous operation of the concrete mixing plant while the pavement is being placed. Provide separate facilities to prevent any intermixing during unloading, transporting, storing, and handling of each type of cementitious material.

1.5.2 Aggregate Materials

Store aggregate at the site of the batching and mixing plant avoiding breakage, segregation, intermixing or contamination by foreign materials. Store each size of aggregate from each source separately and allow the fine aggregate and the smallest size coarse aggregate to drain. Provide a minimum 0.6 m 24 inch thick sacrificial layer left undisturbed for each aggregate stored on ground or provide a paved or chemically stabilized surface course beneath the stockpiles. Maintain sufficient aggregate at the site at all times to permit continuous uninterrupted operation of the mixing plant at the time concrete pavement is being placed. Do not allow tracked equipment on coarse aggregate stockpiles.

1.5.3 Other Materials

Store reinforcing bars and accessories above the ground on supports. Store all materials to avoid contamination and deterioration.

PART 2 PRODUCTS

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NOTE: Coordinate all product requirements with the appropriate agency's Pavements or Materials Engineer.

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2.1 SYSTEM DESCRIPTION

This section is intended to stand alone for construction of concrete pavement. However, where the construction covered herein interfaces with other sections, construct each interface to conform to the requirements of both this section and the other section, including tolerances for both.

2.1.1 SURFACE SMOOTHNESS

****

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. Require use of the profilograph method for airfield taxiways and runways. 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. Profilograph is typically used to measure longitudinal smoothness and straightedge for transverse smoothness. Aircraft arresting systems require straightedge for longitudinal and 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,[within 60 m 200 feet on both the approach and departure sides of an aircraft arresting gear,] 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 provide a copy to the Government after each day's testing.

2.1.1.1 Straightedge Testing

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NOTE: Retain first and third bracketed statements for airfield projects and delete the fourth bracketed statement. Retain second bracketed statement for projects with an aircraft arresting systems. Retain fourth bracketed statement for roads and streets projects and delete first and third bracketed statements.

****

Provide the finished surfaces of the pavements with no abrupt change of 6 mm 1/4 inch or more, and all pavements within the limits specified when checked with an approved 4 m 12 foot straightedge. Report measurements to the nearest 2 mm 1/16 inch. [Provide runways and taxiways with a variation from the specified straight edge not greater than 3 mm 1/8 inch in the longitudinal direction and not greater than 6 mm 1/4 inch in the transverse direction.][Provide runway pavement within 60 m 200 feet on both the approach and departure sides of an aircraft arresting gear with a variation in the longitudinal direction from the specified straightedge not more than plus or minus 3 mm 1/8 inch.][Provide all other airfield areas with a variation from a straight edge not greater than 6 mm 1/4 inch in either the longitudinal or transverse direction.] [Provide roads, streets, tank hardstands, vehicular parking areas, and open storage areas with a variation from the specified straight edge not greater than 6 mm 1/4 inch in either the longitudinal or transverse direction.]

2.1.1.2 Profilograph Testing

Provide the finished surfaces of the pavements with no abrupt change of 6 mm 1/4 inch or more, and each 0.1 km 0.1 mile segment of each pavement lot with a Profile Index not greater than specified when tested with an approved California-type profilograph. [Provide runways and taxiways with a Profile index not greater than 110 mm per km 7 inches per mile in the longitudinal direction. Provide runway and taxiway transverse smoothness measured with the straightedge method and the straightedge requirements in accordance with paragraph Straightedge Testing. Provide all other airfield areas with a Profile Index not greater than 140 mm per km 9 inches per mile in the longitudinal direction.] [Provide roads, streets, tank hardstands, vehicular parking areas and open storage areas with a Profile index not greater than 140 mm per km 9 inches per mile in the longitudinal direction.]

2.1.1.3 Bumps ("Must Grind" Areas)

Reduce any bumps ("must grind" areas) shown on the profilograph trace or by straightedge measurements which exceed 10 mm 0.4 inch in height by diamond grinding in accordance with paragraph DIAMOND GRINDING OF PCC SURFACES below 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.

2.1.1.4 Testing Method

After the concrete has hardened sufficiently to permit walking thereon, but not later than 48 hours after placement, test the entire surface of the pavement in each lot in such a manner as to reveal all surface irregularities exceeding the tolerances specified above. If any pavement areas are diamond ground, retest these areas immediately after diamond grinding. Test the entire area of the pavement in both a longitudinal and a transverse direction on parallel lines. Perform the transverse lines 4.5 m 15 feet or less apart, as directed. Perform the longitudinal lines at the 1/8th point in from each side of the lane and at the centerline of each paving lane shown on the drawings, regardless of whether multiple lanes are allowed to be paved at the same time. Also test other areas having obvious deviations. Perform longitudinal testing lines continuous across all joints. Perform transverse testing lines for pilot lanes carried to construction joint lines and for fill-in lanes carried 600 mm 24 inches across construction joints, and the readings in this area applied to the fill-in lane. Perform straightedge testing of the longitudinal edges of slipformed pilot lanes before paving fill-in lanes as specified below.

2.1.1.4.1 Straightedge Testing

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 freestanding (unleveled) straightedge on the pavement surface and measuring the maximum gap between the straightedge and the pavement surface. Determine measurements along the entire length of the straight edge.

2.1.1.4.2 Profilograph Testing

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 pavement lot. Accommodate grade breaks on aprons [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. Provide a copy of the reduced tapes or digital record to the Government at the end of each day's testing.

2.1.2 Edge Slump and Joint Face Deformation

2.1.2.1 Edge Slump

When slip-form paving is used, provide a maximum of 15.0 percent of each free edge of each pavement panel with a maximum edge slump of 6 mm 1/4 inch and none of the free edge of the pavement lot with an edge slump exceeding 9 mm 3/8 inch. (A pavement panel is defined as a lane width by the length between two adjacent transverse contraction joints. The free edge of the pavement is the linear measurement of pavement panel edge originally constructed as non-adjacent to any existing pavement; for example, 30 m 100 feet of pilot lane originally constructed as a separate lane, would have 30 m 100 feet of free edge on each side; 30 m 100 feet of fill-in lane would have no free edge.) The area affected by the downward movement of the concrete along the pavement edge is a maximum of 450 mm 18 inches back from the edge.

2.1.2.2 Joint Face Deformation

Provide a vertical joint face with a surface within the maximum limits shown in Table 5. Provide the offset measurements from all five Joint Face Deformation Limits from Table 5 at the specified testing frequency. Properly reference all recorded measurements in accordance with paving lane identification and stationing, and submit a report within 10 days after measurement is made. Identify areas requiring replacement within the report.

TABLE 5				
JOINT FACE DEFORMATION LIMITS				
Offset from Straightedge Applied Longitudinally to Pavement Surface (a)	Offset from Straightedge Applied Longitudinally to Vertical Face (b)	Offset from Straightedge Applied Top to Bottom Against the Joint Face (c)	Abrupt Offset in Any Direction (d)	Offset of Joint Face from True Vertical (e)
Airfield Pavement				

TABLE 5				
JOINT FACE DEFORMATION LIMITS				
Offset from Straightedge Applied Longitudinally to Pavement Surface (a)	Offset from Straightedge Applied Longitudinally to Vertical Face (b)	Offset from Straightedge Applied Top to Bottom Against the Joint Face (c)	Abrupt Offset in Any Direction (d)	Offset of Joint Face from True Vertical (e)
3 mm 1/8 inch	6 mm 1/4 inch	9.5 mm 3/8 inch	6 mm 1/4 inch	8 mm per 100 mm 1 inch per 12 inches
All Other Pavement				
6 mm 1/4 inch	All other items same as airfield pavement			
(a) Measurement is taken by placing the straightedge longitudinally on the pavement surface 25 mm 1 inch from the free edge. Record the longitudinal joint face deformation 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.				
(b) Measurement is taken by applying the straightedge longitudinally along the center of the vertical joint face. Record the longitudinal joint face deformation using the minimum 4 m 12 foot straightedge advanced one-half its length for each reading.				
(c) Measurement places a 9.5 mm 3/8 inch spacer attached to a straightedge and spaced approximately equal to the thickness of the concrete being measured. The offset from straightedge with spacers is measured by placing the spacers against the top and bottom of the vertical concrete face. Record measurements at 1.5 m 5 foot spacings.				
(d) Check for abrupt offsets at any location that an abrupt change in the joint face plane appears to be present through use of a 4 meter 12 foot straightedge.				
(e) Measurement of the offset from the joint face to a level in the true vertical position against the joint face. Record measurements at 1.5 m 5 foot spacings.				

2.1.2.3 Edge Slump Determination

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 above. 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. Perform other tests of the exposed joint face to produce a uniform, true vertical joint face. Properly reference all recorded measurements in accordance with paving lane identification and stationing, and submit a report within 10 days after measurement is made. Identify areas requiring replacement within the report.

2.1.2.4 Excessive Edge Slump or Joint Face Deformation

When edge slump or joint face deformation exceeding the limits specified above is encountered on either side of the paving lane, record additional straightedge measurements to define the linear limits of the excessive slump or joint face deformation. Remove and replace concrete slabs having excessive edge slump or joint deformation to the next transverse joint in conformance with paragraph REPAIR, REMOVAL AND REPLACEMENT OF NEWLY CONSTRUCTED SLABS. Discontinue use of slip-form paving equipment and procedures that fail to consistently provide edges within the specified tolerances on edge slump and joint face deformation and construct by means of standard paving procedures using fixed forms.

2.1.3 Plan Grade

Within 5 days after paving of each lot, 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 provide a copy signed by a registered professional land surveyor to the Government at the completion of the survey of each lot. [Provide finished surfaces of all airfield pavements that vary less than 13 mm 1/2 inch above or below the plan grade line or elevation indicated.][Provide surfaces of heavy-duty pavements other than airfield pavements that vary less than 19 mm 3/4 inch.]The above deviations from the approved grade line and elevation are not permitted in areas where closer conformance with the planned grade and elevation is required for the proper functioning of appurtenant structures. Provide finished surfaces of new abutting pavements that coincide at their juncture. Provide horizontal control of the finished surfaces of all airfield pavements that vary not more than 13 mm 1/2 inch from the plan joint alignment indicated.

2.1.4 Flexural Strength

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NOTE: Normally, concrete for airfield pavement is proportioned and accepted on the basis of 90-day flexural strength. If it is desired to use 28-day strength for design of airfield pavement, obtain written approval from the TSMCX, AFCEC pavement SME, or NAVFAC. Make the same changes if this is concrete for road pavement proportioned for 28-day strength (no approval needed).

Use "Beams" Tailoring Option for projects with less than 2,300 cubic meters 3,000 cubic yards of airfield paving. For airfield or heavy duty roads/streets paving projects with more than 2,300 cubic meters 3,000 cubic yards, choose the first Option "Cylinders/Beam" or the second Option "Beams" for strength testing.

****

Each lot of pavement will be evaluated for acceptance for flexural strength in accordance with paragraph Sampling and Testing and paragraph Computations.

2.1.4.1 Sampling and Testing

For acceptance, obtain one composite sample of concrete from each sublot in accordance with ASTM C172/C172M from one batch or truckload.Fabricate and cure test cylinders 152 x 305 mm 6 x 12 inches in accordance with ASTM C31/C31M, and test at 14 days in accordance with ASTM C39/C39M. Test two test cylinders per sublot (8 per lot).Fabricate and cure test beams 152 x 152 mm 6 x 6 inches in accordance with ASTM C31/C31M; and test at 14 days in accordance with ASTM C78/C78M. Test two beams per sublot (8 per lot).

2.1.4.2 Computations

Average the eight 14-day strength tests for the lot. Use the average strength in accordance with paragraph Concrete Strength For Final Acceptance.

2.1.5 Thickness

Each lot of pavement will be evaluated for acceptance and payment adjustment in accordance with the following procedure. Drill two cores, between 100 and 150 mm 4 and 6 inches in diameter, from the pavement, per sublot (8 per lot). Drill the cores within 3 days after lot placement, fill the core holes with an approved concrete patching mixture, and respray the cored areas with curing compound. Prevent the core hole from drying or damage until backfilled. Complete backfillng of core hole during the subsequent production placement or within 5 calendar days, whichever occurs first. Record eight measurements of thickness around the circumference of each core and one in the center, in accordance with ASTM C174/C174M. Provide the results with the thickness measurement data. Average the pavement thickness from the 8 cores for the lot and evaluate as described in paragraph Payment Adjustment For Thickness above.

2.1.6 Evaluation of Cores

Record and submit testing, inspection, and evaluation of each core for mortar-rich surface, uniformity of aggregate distribution, segregation, voids, cracks, and depth of reinforcement or dowels (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's entire length, rotating the core approximately 120 degrees between photographs. Provide photographs with the clarity and quality to identify the defects identified above. Each core is to be identified on the top with the core number referenced to paving lot plan view. Photograph the core against a contrasting background, in profile, and with an extended tape measure parallel and to the right of the core with incremental measurements clearly visible. Provide plan view of location for each core. Store the cores and make available to the Government when requested, until otherwise directed.

2.1.7 Diamond Grinding of PCC Surfaces

Those performing diamond grinding are required to have a minimum of three years experience in diamond grinding of airfield 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 and surface area is limited below. Reduce high areas by diamond grinding the hardened concrete with 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. Utilize diamond grinding equipment with saw blades that are 3 mm 1/8-inch wide, a minimum of 55 to 60 blades per 300 mm 12 inches of cutting head width, and cut a path with a minimum width of 0.9 m 3 ft. 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 any sublot. 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 above in conformance with paragraph REPAIR, REMOVAL AND REPLACEMENT OF NEWLY CONSTRUCTED SLABS. Repair aggregate popouts using the core and patch method of paragraph REPAIRING SPALLS ALONG JOINTS. [Retexture pavement areas given a wire comb, tined texture, or areas exceeding 2 square meters 25 square feet that have been corrected by diamond grinding transverse grooves 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 paragraph Thickness, above.

Prior to production diamond grinding operations, perform a test section at the approved location. Perform a test section that consists of a minimum of two adjacent passes with a minimum length of 12 m 40 feet to allow evaluation of the finish, transition between adjacent passes, and the results of crossing a transverse joint. Production diamond grinding operations are not to be performed prior to approval.

2.2 CEMENTITIOUS MATERIALS

****

NOTE: Edit these paragraphs as appropriate for the particular project. Obtain guidance for use of cementitious materials from the Pavement Materials engineer or from the TSMCX, AFCEC pavement SME, or NAVFAC, especially for areas subject to alkali-aggregate reactivity, or sulfate attack.

When sulfate bearing soil or water is encountered, specify Type II cement for moderate sulfate concentration and Type V cement for high concentration and consider requiring use of fly ash or slag cement for partial replacement. Do not specify Type I or III cement. See UFC 3-250-04 for

guidance. Specify limit on early stiffening (a.k.a.false set) if it is a problem in the area.

Do not specify Type III cement unless accelerated paving is involved and then only after laboratory mixture proportioning studies and tests during the design stage of the project.

****

Provide cementitious materials consisting of portland cement, [blended cement] or portland cement in combination with supplementary cementitious materials (SCM), that conform to appropriate specifications listed below. New submittals are required when the cementitious materials sources or types change.

2.2.1 Portland Cement

****

NOTE: ASTM C 150 has deleted the option to specify low alkali cement. To mitigate ASR, current practice (ASTM C 1778) is to limit the total alkalis in the concrete mixture as addressed in paragraph Mixture Proportions Composition.

****

Provide portland cement conforming to ASTM C150/C150M, Type [I] [II] [V], [including the Optional Physical Requirements for early stiffening]. [Provide Type III cement only in the following locations [_____].]

2.2.2 Blended Cements

****

NOTE: Portland cement blended with limestone up to 15 percent by mass of the blended cement is acceptable.

****

Provide blended cement conforming to ASTM C595/C595M, Type IP, IS, or IL. 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 a 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. Provide limestone added to the Type IL blend that is interground with the cement clinker. Include a written statement from the manufacturer that the amount of limestone in the finished cement does not vary more than plus or minus 2.5 mass percent of the finished cement from lot to lot or within a lot. Limit the percent of slag, pozzolan, or limestone to a maximum of IS(50), IP(35) or IL(15). The percentage and type of mineral admixture used in the blend is not allowed to change from that submitted for the aggregate evaluation and mixture proportioning.

2.2.3 Pozzolan

2.2.3.1 Fly Ash

****

NOTE: Class C fly ash is not permitted for paving concrete.

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

Provide fly ash that conforms to ASTM C618, Class F, including the optional requirement for uniformity with a loss on ignition not exceeding [3] [6] percent. Provide Class F fly ash for use in mitigating Alkali-Silica Reactivity with a total equivalent alkali content less than 4 percent.

2.2.3.2 Raw or Calcined Natural Pozzolan

Provide natural pozzolan that is raw or calcined and conforms to ASTM C618, Class N, including the optional requirement for uniformity with a loss on ignition not exceeding [3] [6] percent. Provide Class N pozzolan for use in mitigating Alkali-Silica Reactivity with a total equivalent alkali content less than 4 percent.

2.2.3.3 Ultra Fine Fly Ash and Ultra Fine Pozzolan

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

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

b. The average particle size is a maximum of 6 microns.

2.2.3.4 Silica Fume

****
NOTE: Use Silica Fume only for OCONUS projects where Class F fly ash and slag cement are not available, and with written approval from the TSMCX, AFCEC pavement SME, or NAVFAC. If not applicable, 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.]

2.2.4 Slag Cement

Provide slag cement (ground-granulated blast-furnace slag) that conforms to ASTM C989/C989M, Grade 100 or Grade 120.

2.2.5 Supplementary Cementitious Materials (SCM) Content

****
NOTE: Use first bracketed sentence for Navy

projects. Use second bracketed sentence for Army/Air Force projects.
****

[Provide a concrete mix that contain one of the SCMs listed in Table 6 within the range specified therein, whether or not the aggregates are found to be reactive in accordance with paragraph ALKALI SILICA REACTIVITY.][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 6		
SUPPLEMENTARY CEMENTITIOUS MATERIALS CONTENT		
Supplementary Cementitious Material	Minimum Content (percent)	Maximum Content (percent)
Class N Pozzolan and Class F Fly Ash		
$SiO_2 + Al_2O_3 + Fe_2O_3 > 70$ percent	25	35
$SiO_2 + A1_2O_3 + Fe_2O_3 > 80$ percent	20	35
$SiO_2 + A1_2O_3 + Fe_2O_3 > 90$ percent	15	35
UFFA and UFP	7	16
Slag Cement	40	50
[Silica Fume]	[7]	[10]

2.3 AGGREGATES

****
NOTE: During the design stage, research the availability of aggregate sources capable of conforming with the project specifications.
****

Provide aggregates meeting the requirements of this specification. If aggregate sources in the project area do not meet the requirements of this specification, provide aggregates from sources outside the project area.

2.3.1 Aggregate Sources

2.3.1.1 Durability of Coarse Aggregate

****
NOTE: Use first bracketed paragraph for Army and Air Force; use the second bracketed paragraph for Navy projects.

Subject to written approval by the Corps of Engineers Transportation Systems Center (TSMCX), the Air Force Civil Engineer Center (AFCEC) pavement Subject Matter Expert (SME), or Naval Facilities Engineering Systems Command (NAVFAC), the second

paragraph can be specified for projects in negligible weathering areas, as defined by ASTM C 33, Figure 1.
****

[Provide aggregate with a satisfactory service record in freezing and thawing of at least 5 years successful service in three concrete paving projects. Include a condition survey of the existing concrete and a review of the concrete-making materials, including coarse aggregates, cement, and mineral admixtures in the service record. Consider the previous aggregate source and test results, cement mill certificate data, mineral admixture chemical and physical composition, and the mix design (cement factor and water-cementitious material ratio) in the review. Provide service record performed by an independent third party professional engineer, petrographer, or concrete materials engineer along with their resume. Include photographs and a written report addressing D-cracks and popouts in accordance with ACI 201.1R in the service record. Provide coarse aggregate with a durability factor of 80 or more when subjected to freezing and thawing of specimens prepared in accordance with ASTM C1646/C1646M and tested in accordance with ASTM C666/C666M, Procedure A, when a coarse aggregate size group or source proposed for use does not have a satisfactory demonstrable service record. Test all coarse aggregate size groups and sources proposed for use individually.] [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 if Sodium Sulfate is used.]

2.3.1.2 Alkali-Silica Reactivity

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 individually.

a. Evaluate the aggregate size groups and sources 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 portland cement, blended cement, and SCM, or Lithium Nitrate in combination with each individual aggregate. If only SCMs are being evaluated, test in accordance with ASTM C1567. If Lithium Nitrate is being evaluated, with or without SCMs, test in accordance with COE CRD-C 662. 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.

2.3.1.3 Combined Aggregate Gradation

In addition to the grading requirements specified for coarse aggregate and for fine aggregate, provide the combined aggregate grading meeting the following requirements:

a. Provide materials selected and the proportions used such that when the Coarseness Factor (CF) and the Workability Factor (WF) are plotted on a diagram as described in d. below, the point and its associated production tolerance thus determined falls within the parallelogram described therein. Refer to TSPWG M 3-250-04.97-05 for combined aggregate plot locations for the intended placement technique(s).

b. Determine the Coarseness Factor (CF) from the following equation:

$$CF = \frac{\text{(cumulative percent retained on the 9.5 mm sieve)(100)}}{\text{(cumulative percent retained on the 2.36 mm sieve)}}$$

$$CF = \frac{\text{(cumulative percent retained on the 3/8 inch sieve)(100)}}{\text{(cumulative percent retained on the No. 8 sieve)}}$$

c. The Workability Factor (WF) is defined as the percent passing the 2.36 mm No. 8 sieve based on the combined aggregate gradation. Adjust the WF, prorated upwards only, by 2.5 percentage points for each 56 kg per cubic meter 94 pounds per cubic yard of cementitious material greater than 335 kg per cubic meter 564 pounds per cubic yard.

d. Plot a diagram using a rectangular scale with WF on the Y-axis with units from 20 (bottom) to 45 (top), and with CF on the X-axis with units from 80 (left side) to 30 (right side). On this diagram, plot a parallelogram with corners at the following coordinates (CF-75, WF-28), (CF-75, WF-40), (CF-45, WF-32.5), and (CF-45, WF-44.5). If the point determined by the intersection of the computed CF and WF does not fall within the above parallelogram, revise the grading of each size of aggregate used and the proportions selected as necessary.

e. Plot the associated production tolerance limits, identified in Table 17, around the CF and adjusted WF point.

2.3.2 Coarse Aggregate

2.3.2.1 Coarse Aggregate Composition

****

NOTE: Crushing gravel tends to improve quality and bond characteristics and generally results in higher flexural strength of concrete. When desirable to limit coarse aggregate to crushed materials, modify this paragraph appropriately.

For Vertical Landing Pads, V-22 parking positions and other areas subject to very high temperatures and jet blast, use UFGS 32 13 13.43 HIGH TEMPERATURE CONCRETE PAVING FOR AIRFIELDS USING LIGHTWEIGHT AND TRAPROCK AGGREGATES

Do not, under any conditions, permit use of steel furnace slag for any aggregate. (It is markedly different from iron blast furnace slag.)

In power check pads, the high temperatures from jet blast can cause distress in aggregates in the concrete. Include bracketed item if power check pads are to be constructed. If no service record is available, make a lab study of available aggregates.

Only basalt is permitted on Navy projects.

Give special attention to aggregates proposed for compass calibration pads. Do not use aggregates with magnetic properties, such as, but not limited to, magnetite in granites, high-iron minerals in traprock, pyrite in limestone, and free iron or iron oxide in slag. When the paving of compass calibration pads is required, add the bracketed item concerning compass pads as additional requirements for coarse and fine aggregates.

Retain the bracketed requirement for washing coarse aggregate if aggregates in the area require it. Add the requirement to use a log washer or other specific equipment if experience in the area shows the need. Delete if not needed. It is permissible to list certain aggregate sources that do not require washing, if that is appropriate. Make this decision during preparation of specifications; do not make the Resident Engineer decide after award if aggregates need to be washed.

****

Provide coarse aggregate consisting of crushed or uncrushed gravel, crushed stone, [crushed adequately seasoned air-cooled iron blast-furnace slag; steel furnace slag is not permitted,] or a combination thereof. [Provide aggregate used for paving compass calibration hardstands free of materials having undesirable magnetic properties, including magnetite in granite, high-iron minerals in traprock, and pyrite in limestone.][Provide coarse aggregate for paving power check pads consisting of limestone, dolomite, basalt or other approved low-silica content aggregate which do not cause thermal distress from jet blast.] Provide aggregates, as delivered to the mixers, consisting of clean, hard, uncoated particles meeting the requirements of ASTM C33/C33M except as specified herein. [Provide coarse aggregate that has been washed sufficient to remove dust and other coatings.] [Provide coarse aggregate that has been cleaned by processing with an approved log washer.] [Provide iron blast-furnace slag conforming to the grading to be used in the concrete with a compact density of not less than 1125 kg per cubic meter 70 lb per cubic foot determined in accordance with ASTM C29/C29M]. Provide coarse aggregate with no more than 40 percent loss when subjected to the Los Angeles abrasion test in accordance with ASTM C131/C131M. Provide coarse aggregates with a maximum sodium sulfate soundness loss of 12 percent, or with a magnesium sulfate soundness loss of 18 percent after five cycles when tested in accordance with ASTM C88.

2.3.2.2 Particle Shape Characteristics

Provide particles of the coarse aggregate that are generally spherical or cubical in shape. The quantity of flat particles and elongated particles in any size group coarser than the 9.5 mm 3/8 inch sieve are not allowed to exceed 20 percent by weight as determined by the Flat Particle Test and the Elongated Particle Test of ASTM D4791, Method A. A flat particle is defined as one having a ratio of width to thickness greater than 3; an elongated particle is one having a ratio of length to width greater than 3.

2.3.2.3 Size and Grading

****

NOTE: Aggregate quality requirements are not allowed to be reduced or eliminated for airfield projects. Use nominal maximum size of 37.5 mm 1-1/2 inch (ASTM C33 size number 4) for airfield pavements. Subject to written approval of the TSMCX, AFCEC pavement SME, or NAVFAC, a 25 mm 1-inch nominal maximum size may be used to avoid durability problems associated with some larger size aggregate. For thin bonded overlays, limit the nominal maximum size to less than one-third of the uniform overlay thickness (not including leveling portion). For projects with less than 7,650 cubic meters 10,000 cubic yards of airfield pavement, delete the second bracketed statement. For projects with 7,650 cubic meters 10,000 cubic yards or more of airfield pavement, delete the first bracketed statement.

****

Provide coarse aggregate with a nominal maximum size (as defined in ASTM C125) of [37.5] [_____] mm [1.5] [_____] inches with a minimum of 10 percent retained on the [25] mm [1.0] inch sieve of the proposed combined aggregate gradation that meets the criteria of paragraph COMBINED AGGREGATE GRADATION. [Grade and provide the coarse aggregates in a minimum of two size groups meeting the individual grading requirements of ASTM C33/C33M, Size No. 4 (37 mm to 19 mm 1.5 inches to 0.75 inch) and Size No. 67 (19 mm to No. 4 0.75 inch to No. 4). A third coarse aggregate size group may be required to meet the criteria of paragraph Combined Aggregate Gradation.] [Grade and provide the coarse aggregates in a minimum of three size groups. The ASTM C33/C33M, Size Number 4 coarse aggregate (37.5 mm to 19.0 mm1.5 inches to 0.75 inch) meets the 37.5 mm 1.5 inches requirement. The ASTM C33/C33M, Size Number 67 (19.0 mm to 4.75 mm0.75 inch to No. 4) is a common medium coarse aggregate.]

Mix designs that include a minimum of three coarse aggregate size groups can use grading limits not defined by ASTM C33/C33M provided all other requirements are met. Provide upper and lower grading limits of historic gradations and for all proposed coarse aggregates not defined by ASTM C33/C33M but intended for use in the mix design.

2.3.2.4 Deleterious Materials - Airfield Pavements

****

NOTE: Include these deleterious material requirements for airfield paving projects only, otherwise, delete. In Table 7A select columns showing appropriate percentage by weight in accordance with the following. Delete the inapplicable column in the table and the heading of the column used.

Weather Severity	Air Freezing Index Coldest Year in 30 (a)	Average Precipitation for any Single Month During the Freezing Period
Moderate	500 or less	Any Amount
Moderate (b)	501 or more	Less than 25 mm 1 inch
Severe	501 or more	25 mm 1 inch or more
(a) Calculated as described in UFC 3-130-01. See ASTM C33/C33M for simplified map of CONUS weather severity.		
(b) In poorly drained areas, the weather must be considered severe even though the other criteria indicate a rating of moderate.		
(c) For Navy projects, select "Severe Weather" column of Table 5. Delete "Moderate Weather" and associated limits.		

****

The amount of deleterious material in each individual size group and source of coarse aggregate is not allowed to exceed the limits shown in Table 7A below, determined in accordance with the test methods shown.

TABLE 7A		
LIMITS OF DELETERIOUS MATERIALS IN COARSE AGGREGATE FOR AIRFIELD PAVEMENTS		
Percentage by Mass		
Materials (h)	Severe Weather	Moderate Weather
Clay lumps and friable particles (ASTM C142/C142M)	0.2	0.2
Shale (a) (ASTM C295/C295M)	0.1	0.2
Material finer than 0.075 mm No. 200 sieve (b) (ASTM C117)	0.5	0.5
Lightweight particles (c) (ASTM C123/C123M)	0.2	0.2
Clay ironstone (d) (ASTM C295/C295M)	0.1	0.5
Chert, cherty stone, and other aggregates (less than 2.40 Sp. Gr.) (e) (ASTM C123/C123M and ASTM C295/C295M)	0.1	0.5
Claystone, mudstone, and siltstone (f) (ASTM C295/C295M)	0.1	0.1
Shaly and argillaceous limestone (g) (ASTM C295/C295M)	0.2	0.2

TABLE 7A		
LIMITS OF DELETERIOUS MATERIALS IN COARSE AGGREGATE FOR AIRFIELD PAVEMENTS		
Percentage by Mass		
Materials (h)	Severe Weather	Moderate Weather
Other soft particles (COE CRD-C 130)	1.0	1.0
Total of all deleterious substances exclusive of material finer than 0.075 mm No. 200 sieve	1.0	2.0
(a) Shale is defined as a fine-grained, thinly laminated or fissile sedimentary rock. It is commonly composed of clay or silt or both. It has been indurated by compaction or by cementation, but not so much as to have become slate.		
(b) Limit for material finer than 0.075 mm No. 200 sieve is allowed to be increased to 1.5 percent for crushed aggregates if the fine material consists of crusher dust that is essentially free from clay or shale. Use XRD or other appropriate techniques as determined by petrographer to quantify amount and justify increase.		
(c) Test with a separation medium with a density of Sp. Gr. of 2.0. This limit does not apply to coarse aggregate manufactured from blast-furnace slag unless contamination is evident.		
(d) Clay ironstone is defined as an impure variety of iron carbonate, iron oxide, hydrous iron oxide, or combinations thereof, commonly mixed with clay, silt, or sand. It commonly occurs as dull, earthy particles, homogeneous concretionary masses, or hard-shell particles with soft interiors. Other names commonly used for clay ironstone are "chocolate bars" and limonite concretions.		
(e) Chert is defined as a rock composed of quartz, chalcedony or opal, or any mixture of these forms of silica. It is variable in color. The texture is so fine that the individual mineral grains are too small to be distinguished by the unaided eye. Its hardness is such that it scratches glass but is not scratched by a knife blade. It may contain impurities such as clay, carbonates, iron oxides, and other minerals. Cherty stone is defined as any type of rock (generally limestone) that contains chert as lenses and nodules, or irregular masses partially or completely replacing the original stone. Other aggregates consist of obsidian, ash tuff, and palygorskite.		
(f) Claystone, mudstone, or siltstone, is defined as a massive fine-grained sedimentary rock that consists predominantly of indurated clay or silt without laminations or fissility. It may be indurated either by compaction or by cementation.		

TABLE 7A		
LIMITS OF DELETERIOUS MATERIALS IN COARSE AGGREGATE FOR AIRFIELD PAVEMENTS		
Percentage by Mass		
Materials (h)	Severe Weather	Moderate Weather
(g) Shaly limestone is defined as limestone in which shale occurs as one or more thin beds or laminae. These laminae may be regular or very irregular and may be spaced from a few inches down to minute fractions of an inch. Argillaceous limestone is defined as a limestone in which clay minerals occur disseminated in the stone in the amount of 10 to 50 percent by weight of the rock; when these make up from 50 to 90 percent, the rock is known as calcareous (or dolomitic) shale (or claystone, mudstone, or siltstone).		
(h) Perform testing in accordance with the referenced test methods, except use the minimum sample size specified below.		

2.3.2.5 Testing Sequence for Deleterious Materials in Coarse Aggregate - Airfields Only

No extension of time or additional payment due to any delays caused by the testing, evaluation, or personnel requirements is allowed. The minimum test sample size of the coarse aggregate is 90 kg 200 pounds for the 19 mm 3/4 inch and larger maximum size and 12 kg 25 pounds for the 4.75 to 19 mm No. 4 to 3/4 inch coarse aggregate. Provide facilities for the ready procurement of representative test samples. The testing procedure on each sample of coarse aggregate for compliance with limits on deleterious materials is as follows:

Step 1: Wash each full sample of coarse aggregate for material finer than the 0.075 mm No. 200 sieve. Discard material finer than the 0.075 mm No. 200 sieve.

Step 2: Test remaining full sample for clay lumps and friable particles and remove.

Step 3. Test remaining full sample for chert and cherty stone with SSD density of less than 2.40 specific gravity. Remove lightweight chert and cherty stone. Retain other materials less than 2.40 specific gravity for Step 4.

Step 4: Test the materials less than 2.40 specific gravity from Step 3 for lightweight particles (Sp. GR. 2.0) and remove. Restore other materials less than 2.40 specific gravity to the sample.

Step 5: Test remaining sample for clay-ironstone, shale, claystone, mudstone, siltstone, shaly and argillaceous limestone, and remove.

Step 6: Test a minimum of one-fifth of remaining full sample for other soft particles.

2.3.2.6 Deleterious Material - Heavy Duty Pavements

****

NOTE: Use this paragraph only for heavy-duty pavements, roads, streets, and parking lots for vehicular and tracked traffic identified in the PART 1 GENERAL Note. Otherwise, delete.
****

[The amount of deleterious material in each size group of coarse aggregate is not to exceed the limits in Table 7B when tested as indicated.

TABLE 7B	
LIMITS OF DELETERIOUS MATERIALS IN COARSE AGGREGATE FOR HEAVY DUTY PAVEMENTS	
Percentage by Mass	
Clay lumps and friable particles (ASTM C142/C142M)	2.0
Material finer than 0.075 mm No. 200 sieve (ASTM C117)	1.0
Lightweight particles (ASTM C123/C123M)	1.0
Other soft particles (COE CRD-C 130)	2.0
Total of all deleterious substances, exclusive of material finer than 0.075 mm No. 200 sieve	5.0

The limit for material finer than the 0.075 mm No. 200 sieve is allowed to be increased to 1.5 percent for crushed aggregates consisting of crusher dust that is essentially free from clay or shale. Use a separation medium for lightweight particles with a density of 2.0 specific gravity. This limit does not apply to coarse aggregate manufactured from blast-furnace slag unless contamination is evident.]

2.3.3 Fine Aggregate

2.3.3.1 Fine Aggregate Composition

Provide fine aggregate consisting of natural sand, manufactured sand, or a combination of the two, each composed of clean, hard, durable particles meeting the requirements of ASTM C33/C33M. [Provide aggregate used for paving compass calibration hardstands free of materials having undesirable magnetic properties, including magnetite in granite, high-iron minerals in traprock, and pyrite in limestone.]Stockpile and batch each type of fine aggregate separately. Provide fine aggregate with particles that are generally spherical or cubical in shape. For fine aggregate provided as a combination of sources, test each source individually.

2.3.3.2 Grading

Provide fine aggregate, as delivered to the mixer, with a grading that conforms to the requirements of ASTM C33/C33M and having a fineness modulus of not less than 2.50 nor more than 3.40. For fine aggregate supplied as a combination of sources, determine the fineness modulus on a composite sample.

2.3.3.3 Deleterious Material

****
NOTE: Retain sample size for airfield pavements.
****

[The minimum test sample size for fine aggregate proposed for use in airfield paving is 5 kg 10 pounds.] The amount of deleterious material in the fine aggregate is not to exceed the limits listed in Table 8 when performed on the full sample:

TABLE 8	
LIMITS OF DELETERIOUS MATERIALS IN FINE AGGREGATE	
Material	Percentage by Mass
Clay lumps and friable particles ASTM C142/C142M	1.0
Material finer than 0.075 mm No. 200 sieve ASTM C117	3.0
Lightweight particles ASTM C123/C123M using a medium with a density of Sp. Gr. of 2.0	0.5
Total of all above	3.0

2.3.3.4 Testing Sequence for Deleterious Materials in Fine Aggregate - Airfields Only

The testing procedure on each sample of fine aggregate for compliance with limits on deleterious materials is as follows:

Step 1: Wash each full sample of fine aggregate for material finer than the 0.075 mm No. 200 sieve. Discard material finer than the 0.075 mm No. 200 sieve.

Step 2: Test remaining full sample for clay lumps and friable particles and remove.

Step 3. Test remaining full sample for lightweight particles (Sp. GR. 2.0).

2.4 CHEMICAL ADMIXTURES

2.4.1 General Requirements

Only use chemical admixtures when the specific admixture type and manufacturer is the same material used in the mixture proportioning studies. Provide all chemical admixtures from the same manufacturer. Provide air-entraining admixture conforming to ASTM C260/C260M. Use an accelerating admixture conforming to ASTM C494/C494M, Type C or Type E, when specified in paragraph MIXTURE PROPORTIONS below provided it is not used to reduce the amount of cementitious material. Calcium chloride and admixtures containing calcium chloride are not allowed. Provide retarding or water-reducing admixture that meet the requirements of ASTM C494/C494M,

Type A, B, or D, except that the 6-month and 1-year compressive strength tests are waived. ASTM C494/C494M, Type F and G high range water reducing admixtures and Type S specific performance admixtures are not allowed. ASTM C1017/C1017M flowable admixtures are not allowed.

2.4.2 Lithium Nitrate

****
NOTE: Evaluate cost effectiveness and availability of a Lithium Nitrate admixture before specifying.
****

Provide lithium admixture consisting of a nominal 30 percent aqueous solution of Lithium Nitrate, with a density of 1.2 kg per L 10 pounds per gallon, with the approximate chemical form as shown below:

TABLE 9	
LITHIUM NITRATE COMPOSITION	
Constituent	Limit (Percent by Mass)
$LiNo_3$ (Lithium Nitrate)	30 plus or minus 0.5
SO_4^{-2} (Sulfate Ion)	0.1 (max)
Cl^- (Chloride Ion)	0.2 (max)
Na^+ (Sodium Ion)	0.1 (max)
K^+ (Potassium Ion)	0.1 (max)

Provide the services of a manufacturer's technical representative experienced in dispensing, mixing, proportioning, placement procedures and curing of concrete containing lithium nitrate, at no expense to the Government. This representative is required to be present on the project prior to and during at least the first two days of placement using lithium nitrate.

2.4.3 High Range Water Reducing Admixture (HRWRA)

****
NOTE: High Range Water Reducing Admixtures are permitted only when using Silica Fume. Delete for all other projects
****

[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.]

2.5 MEMBRANE FORMING CURING COMPOUND

****
NOTE: Use CRD-C 300 for airfield pavement projects. ASTM C309 may be used for roads and streets.
****

Provide membrane forming curing compound that [conforms to COE CRD-C 300 and is white pigmented.] [conforms to ASTM C309, white-pigmented Type 2, Class B.]

2.6 WATER

Provide water for mixing and curing that is fresh, clean, potable, and free of injurious amounts of oil, acid, salt, or alkali, except that non-potable water, or water from concrete production operations, can be used if it meets the requirements of ASTM C1602/C1602M.

2.7 JOINT MATERIALS

****
NOTE: Edit as appropriate for project requirements.
****

2.7.1 Expansion Joint Material

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.

2.7.2 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.

2.8 REINFORCING

****
NOTE: Edit these paragraphs to conform to project requirements. Delete those not needed. Add epoxy-coated bars (ASTM A775/A775M) or low-alloy bars (ASTM A706/A706M) when required by design.
****

Provide reinforcement that is free from loose, flaky rust, loose scale, oil, grease, mud, or other coatings that might reduce the bond with concrete. Removal of thin powdery rust and tight rust is not required. However, reinforcing steel which is rusted to the extent that it does not conform to the required dimensions or mechanical properties is not allowed to be used.

2.8.1 Reinforcing Bars and Bar Mats

Provide reinforcing bars conforming to [ASTM A615/A615M, billet-steel] [ASTM A996/A996M, rail and axle steel], Grade 60 [_____]. Provide bar mats

conforming to ASTM A184/A184M. The bar members may be billet rail or axle steel.

2.8.2 Welded Wire Reinforcement

Provide welded wire reinforcement that is deformed or smooth, conforming to ASTM A1064/A1064M, and provided in flat sheets.

2.9 DOWELS[AND TIE BARS]

****
NOTE: Retain paragraph on dowels. Even if not required, allow dowels as an option. Edit tie bars as required by design.
****

2.9.1 Dowels

Provide dowels in single piece bars fabricated or cut to length at the shop or mill before delivery to the site. Dowels are to be free of loose, flaky rust and loose scale and be clean and straight. Dowels may be sheared to length provided that the deformation from true shape caused by shearing does not exceed 1 mm 0.04 inch on the diameter of the dowel and does not extend more than 1 mm 0.04 inch from the end of the dowel. Dowels are required to be smooth steel bars conforming to ASTM A615/A615M, Grade 40 or 60; ASTM A996/A996M, Grade 50 or 60. Epoxy coat dowels in conformance with Type 1 coating requirements of ASTM A1078/A1078M, to include the ends. Provide grout retention rings that are fully circular metal or plastic devices capable of supporting the dowel until the epoxy hardens. Dowel sleeves or inserts are not permitted.

2.9.2 Dowel Bar Assemblies

Provide dowel bar assemblies that consist of a framework of metal bars or wires arranged to provide rigid support for the dowels throughout the paving operation, with a minimum of four continuous bars or wires extending along the joint line. Provide dowels that are welded to the assembly or held firmly by mechanical locking arrangements that prevent them from rising, sliding out, or becoming distorted during paving operations.

2.9.3 Tie Bars

Provide tie bars that are deformed steel bars conforming to ASTM A615/A615M, or ASTM A996/A996M, Grade 60 [_____], and of the sizes and dimensions indicated.

2.10 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 required for use as patching materials for complete filling of spalls, saw-cut runouts, 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 required for bonding freshly mixed portland cement concrete or mortar or freshly mixed epoxy resin concrete or mortar to hardened concrete.

2.11 EQUIPMENT

Maintain all plant, equipment, tools, and machines used in the work in satisfactory working conditions at all times. Submit the following:

a. Details and data on the batching and mixing plant prior to plant assembly including manufacturer's literature showing that the equipment meets all requirements specified herein.

****

NOTE: For OCONUS projects, contact NRMCA (http://www.nrmca.org) concerning approved engineers available in the geographic area.

****

b. Obtain National Ready Mixed Concrete Association (NRMCA) certification of the concrete plant, at no expense to the Government. Provide inspection report of the concrete plant by an engineer approved by the NRMCA. The NRMCA certified engineer cannot be employed by the primary contractor or a subcontractor. A list of NRMCA approved engineers is available on the NRMCA website at http://www.nrmca.org. Submit a copy of the NRMCA QC Manual Section 3 Concrete Plant Certification Checklist, NRMCA Certificate of Conformance, and Calibration documentation on all measuring and weighing devices prior to uniformity testing.

c. A description of the equipment proposed for transporting concrete mixture from the central mixing plant to the paving equipment.

d. A description of the equipment proposed for the machine and hand placing, consolidating and curing of the concrete mixture. Manufacturer's literature on the paver and finisher, together with the manufacturer's written instructions on adjustments and operating procedures necessary to assure a tight, smooth surface on the concrete pavement. The literature is required to show that the equipment meets all details of these specifications. [Include detailed information on automatic laser controlled systems if proposed for use.]

2.11.1 Batching and Mixing Plant

****

NOTE: Locate the batching and mixing plant on the construction site or as close as possible, but no farther than 30 minutes haul time from the placing site during all periods of the work day. Verify the availability of water and electrical power for sites on Government land. On Navy projects, specify an off-site batch plant. Edit bracketed items as appropriate.

Plant capacity is governed by the laydown pattern or the size of the job to prevent delay of paving

operations.
****

2.11.1.1 Location

Locate the batching and mixing plant [on project site as indicated on the drawings][off Government premises no more than 30 minutes haul and gate security check time from the placing site]. [Water and electrical power [are] [are not] available on the project site.] Provide operable telephonic or radio communication between the plant and the placing site at all times concreting is taking place.

2.11.1.2 Type and Capacity

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, 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

2.11.1.3 Tolerances

TABLE 10	
BATCH PLANT MIXING TOLERANCES	
Materials	Percentage of Required Mass
Cementitious Materials	plus or minus 1
Aggregate	plus or minus 2
Water	plus or minus 1
Admixture	plus or minus 3

For volumetric batching equipment for water and admixtures, the above numeric tolerances apply to the required volume of material being batched. Dilute concentrated admixtures uniformly, if necessary, to provide sufficient volume per batch so that the batchers operate consistently within the above tolerance.

2.11.1.4 Moisture Control

Provide a plant capable of ready adjustment to compensate for the varying moisture contents of the aggregates and to change the quantities of the materials being batched. Provide an electric moisture meter complying with the provisions of COE CRD-C 143 for measuring of moisture in the fine aggregate. Provide a sensing element arranged so that measurement is made near the batcher charging gate of the fine aggregate bin or in the fine aggregate batcher.

2.11.2 Concrete Mixers

Provide stationary or truck mixers that are capable of combining the materials into a uniform mixture and of discharging this mixture without segregation. Do not charge the mixers in excess of the capacity recommended by the manufacturer. Operate the mixers at the drum or mixing blade speed designated by the manufacturer. Maintain the mixers in satisfactory operating condition, with the mixer drums kept free of hardened concrete. Replace mixer blades or paddles when worn down more than 10 percent of their depth when compared with the manufacturer's dimension for new blades or paddles.

2.11.2.1 Stationary Mixers

Stationary mixers are required to be drum or pan mixers. Provide mixers with an acceptable device to lock the discharge mechanism until the required mixing time has elapsed. Perform mixer performance (uniformity) testing in accordance with COE CRD-C 55 and with paragraph TESTING AND INSPECTION FOR CONTRACTOR QUALITY CONTROL DURING CONSTRUCTION in PART 3.

2.11.2.2 Mixing Time and Uniformity for Stationary Mixers

Use the project's approved mixture proportions for uniformity testing. For stationary mixers, before uniformity data are available, the minimum mixing time for each batch after all solid materials are in the mixer, provided that all of the mixing water is introduced before one-fourth of the mixing time has elapsed, is 1 minute for mixers having a capacity of 0.75 cubic meter 1 cubic yard. For mixers of greater capacity, increase this minimum time by 20 seconds for each additional cubic meter 1.33 cubic yard or fraction thereof. Provide uniformity test results meeting the properties required by this specification in addition to meeting the requirements of Table 11. After results of uniformity tests are available, the mixing time may be reduced to the minimum time required to meet uniformity requirements; but if uniformity requirements are not being met, increase the mixing time as directed. Perform mixer uniformity tests at new mixing times immediately after any change in mixing time or volume. Any changes to the mix constituents or sequence of charging the mixer after a batch requires an additional three consecutive passing batches. For regular testing perform all six tests on three consecutive batches of concrete. The range for regular testing is the average of the ranges of the three consecutive batches. Conduct the Regular Test sequence for initial determination of the mixing time or as directed. When regular testing is performed, the concrete is required to meet the limits of any five of the six uniformity requirements listed in Table 11 below.

2.11.2.3 Abbreviated Uniformity Test

Use the project's approved mixture proportions for uniformity testing. Conduct the Abbreviated Test sequence for production concrete verification at the frequency specified in Table 17. Provide uniformity test results meeting the fresh and hardened concrete properties required by this specification in addition to meeting the requirements of Table 11. When abbreviated testing is performed, the concrete is required to meet only those requirements listed for abbreviated testing. Abbreviated testing is performed on a single batch of concrete. The range for abbreviated testing is the range for one batch. If more than one mixer is used and all are identical in terms of make, type, capacity, condition, speed of rotation, the results of tests on one of the mixers apply to the others,

subject to Government approval.

TABLE 11		
UNIFORMITY REQUIREMENTS--STATIONARY MIXERS		
Parameter	Regular Tests Allowable Maximum Range for 3 Consecutive Batches	Abbreviated Tests Allowable Maximum Range for 1 Batch
Unit weight of air-free mortar	32 kg per cubic m 2.0 pounds per cubic foot	32 kg per cubic m 2.0 pounds per cubic foot
Air content	1.0 percent	Not Applicable
Slump	25 mm 1.0 inch	25 mm 1.0 inch
Coarse aggregate	6.0 percent	6.0 percent
Compressive strength at 7	10.0 percent	10.0 percent
Water content	1.5 percent	Not Applicable

2.11.2.4 Truck

Truck mixers are not allowed for mixing or transporting slipformed paving 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. Provide truck mixers, the mixing of concrete therein, and concrete uniformity and testing thereof that conform to the requirements of ASTM C94/C94M. Any changes to the mix constituents or sequence of charging the truck mixer requires an additional three consecutive passing batches. Determine the number of revolutions between 70 to 100 for truck-mixed concrete and the number of revolutions for shrink-mixed concrete by uniformity tests as specified in ASTM C94/C94M and in requirements for mixer performance stated in paragraph TESTING AND INSPECTION FOR CONTRACTOR QUALITY CONTROL DURING CONSTRUCTION in PART 3. If requirements for the uniformity of concrete are not met with 100 revolutions of mixing after all ingredients including water are in the truck mixer drum, discontinue use of the mixer until the condition is corrected. 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.

2.11.3 Transporting Equipment

Transport slipform concrete to the paving site in non-agitating equipment conforming to ASTM C94/C94M or in approved open top agitators. Truck mixers are not allowed for mixing or transporting slipformed paving concrete. Transport fixed form concrete in non-agitating equipment or approved truck mixers designed with extra large blading and rear opening specifically for low slump concrete. Provide transporting equipment designed and operated to deliver and discharge the required concrete mixture completely without segregation.

2.11.4 Transfer and Spreading Equipment

****
NOTE: A transfer spreader is required for all Army and Air Force airfield paving projects. This paragraph is required for Navy projects if the design incorporates a drainage layer. Coordinate with Part 3 requirements in sub-paragraph TRAFFIC ON UNDERLYING MATERIAL.
****

Provide a Material Transfer Vehicle (MTV) capable of moving between the hauling equipment and the paver and equipped with a swing conveyor that delivers material to the paver from outside the paving lane without making contact with the paver while allowing the paver to operate at a constant speed.

2.11.5 Paver-Finisher

****
NOTE: The following subparagraphs apply to both fixed-form and slip-form paver-finishers. FIXED FORMS is applicable to fixed-form paver-finishers and SLIPFORM is applicable to slip-form paver-finishers.
****

Provide paver-finisher consisting of a heavy-duty, self-propelled machine designed specifically for paving and finishing high quality pavement, with a minimum weight of 3280 kg per m 2200 pounds per foot of lane width, and powered by an engine having a minimum 15,000 W per m 6.0 horsepower per foot of lane width. The paver-finisher is required to spread, consolidate, and shape the plastic concrete to the desired cross section in one pass. The mechanisms for forming the pavement are required to be easily adjustable in width and thickness. In addition to other spreaders required by paragraph above, equip the paver-finisher with a full width knock-down auger or plow mechanism, capable of operating in both directions, which evenly spreads the fresh concrete in front of the screed or extrusion plate.

2.11.5.1 Vibrators

****
NOTE: Retain bracketed electronic vibrator monitoring equipment statement for airfield paving.
****

Provide gang mounted 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, as required. Provide vibrators that are automatically controlled to immediately stop as forward motion of the paver ceases. [Equip the paver-finisher with an electronic vibrator monitoring device displaying the operating frequency of each individual internal vibrator with a readout display visible to the paver operator that operates continuously while paving, and displays all vibrator frequencies with manual or automatic sequencing among all individual vibrators. Discontinue paving if the vibrator monitoring system fails to operate

properly during the paving operation.] Provide the spacing of the immersion vibrators across the paving lane as necessary to properly consolidate the concrete, with a maximum clear distance between vibrators of 750 mm 30 inches and outside vibrators a maximum of 300 mm 12 inches from the lane edge. Determine vibrator frequency and amplitude per COE CRD-C 521.

2.11.5.2 Screed or Extrusion Plate

Equip the paver-finisher with a transversely oscillating screed or an extrusion plate to shape, compact, and smooth the surface and finish the surface that no significant amount of hand finishing, except use of cutting straightedges, is required. Provide adjustment for variation in lane width or thickness and to prevent more than 200 mm 8 inches of the screed or extrusion plate extending over previously placed concrete on either side when paving fill-in lanes. Repair or replace machines that cause displacement of properly installed forms or cause ruts or indentations in the prepared underlying materials and machines that cause frequent delays due to mechanical failures.

2.11.5.3 Longitudinal Mechanical Float

A longitudinal mechanical float may be used. If used, provide a float that is specially designed and manufactured to smooth and finish the pavement surface without working excess paste to the surface and is rigidly attached to the rear of the paver-finisher or to a separate self-propelled frame spanning the paving lane. Provide float plate at least 1.5 m 5 feet long by 200 mm 8 inches wide that automatically oscillates in the longitudinal direction while slowly moving from edge to edge of the paving lane, with the float plate in contact with the surface at all times.

2.11.5.4 Other Types of Finishing Equipment

Clary screeds (triple drum roller screeds), other rotating tube floats, or bridge deck finishers are not allowed on mainline paving, but may be allowed on irregular or odd-shaped slabs, and near buildings or trench drains, subject to approval. Only use vibrating screeds or pans for isolated slabs where hand finishing is permitted as specified, and only where specifically approved.

2.11.5.5 Fixed Forms

Provide paver-finisher equipped with wheels designed to ride the forms, keep it aligned with the forms, and spread the load so as to prevent deformation of the forms. When traveling on new or existing concrete to remain, provide paver-finishers traveling on guide rails located outside of the paving lane that are equipped with wheels that will not cause damage or spalling to concrete joint edges to remain. Alternatively, a modified slipform paver that straddles the forms may be used. Provide a modified slipform paver which has the side conforming plates removed or rendered ineffective and travels over or along pre-placed fixed forms.

2.11.5.6 Slipform

Provide an automatically controlled slipform paver-finisher that is crawler mounted with padded tracks so as to be completely stable under all operating conditions and provide a finish to the surface and edges so that no edge slump beyond allowable tolerance occurs. Provide suitable moving

side forms that are adjustable and produce smooth, even edges, perpendicular to the top surface and meeting specification requirements for alignment, edge slump, and joint face deformation.

2.11.6 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 paragraph MEMBRANE CURING. Provide hand-operated sprayers allowed by that paragraph with 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.

2.11.7 Texturing Equipment

****

NOTE: Select type of texturing desired, retain that subparagraph, and delete the others. Determine the type of texturing desired by the using service. If no guidance is given, the usual default method is a burlap drag. If other than a burlap drag textured finish is required, edit the appropriate paragraph(s) as shown below.

For Air Force airfield paving projects, do not specify artificial turf, wire comb, or deep textures. For Navy airfield paving projects, do not specify wire comb or deep textures. Use Section 32 01 18.71 GROOVING OF AIRFIELD PAVING to specify saw-cut grooves.

Spring tine grooving is limited to use on roads and streets only.

****

Provide texturing equipment as specified below. Before use, demonstrate the texturing equipment on the test section, and modify the equipment as necessary to produce the texture directed.

2.11.7.1 Burlap Drag

Securely attach a burlap drag to a separate wheel mounted frame spanning the paving lane or to one of the other similar pieces of equipment. Provide length of the material between 600 to 900 mm 24 to 36 inches dragging flat on the pavement surface and with a width at least equal to the width of the slab. Provide clean, reasonably new burlap material, completely saturated with water before attachment to the frame, moistened before start of use, and kept clean and maintained moist during use. Provide burlap conforming to AASHTO M 182, Class 3 or 4.

2.11.7.2 Broom

Apply surface texture using an approved mechanical stiff bristle broom drag of a type that provides a uniformly scored surface transverse to the pavement center line. Provide broom capable of traversing the full width of the pavement in a single pass at a uniform speed and with a uniform pressure that results in scores uniform in appearance and approximately 1.5 mm 1/16 inch in depth but not more than 3 mm 1/8 inch in depth.

2.11.7.3 Artificial Turf

[Provide full-width artificial turf drag with the leading transverse edge securely fastened to a lightweight pole on a traveling bridge. Provide a minimum of 600 mm 2 feet of the artificial turf in contact with the concrete surface during texturing operations that results in corrugations uniform in appearance and approximately 2 mm 1/16 inch in depth. A variety of different types of artificial turf are available and approval of any one type will be done only after it has been demonstrated to provide a satisfactory texture. One type that has provided satisfactory texture consists of 7,200 approximately 0.85-inch-long polyethylene turf blades per square foot.]

2.11.7.4 Deep Texturing Equipment

[Provide texturing equipment that consists of [a stiff bristled broom] [a comb with spring wire tines] [spring strips which produce true, even grooves] forming a drag at least 1.2 m 4 feet long. Mount this drag in a wheeled frame spanning the paving lane and so constructed that the drag is mechanically pulled in a straight line across the paving lane perpendicular to the centerline.]

2.11.8 Sawing Equipment

****
NOTE: Retain bracketed sentence as necessary to correlate with paragraph REMOVAL OF EXISTING PAVEMENT SLAB in PART 3. Otherwise delete. Also delete wheel saw option on Navy projects.
****

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. [Provide wheel saws used in the removal of concrete with large diameter tungsten carbide tipped blades mounted on a heavy-duty chassis which produce a saw kerf at least 40 mm 1-1/2 inches wide.]Provide saws capable of sawing to the full depth required. Early-entry saws may be used, subject to demonstration and approval. No change to the initial sawcut depth is permitted.

2.11.9 Straightedge

Provide and maintain at the job site, in good condition, a minimum 4 m 12 foot straightedge for each paving train for testing the hardened portland cement concrete surfaces. Provide straightedges constructed of aluminum or magnesium alloy and blades of box or box-girder cross section with flat

bottom, adequately reinforced to maintain rigidity and accuracy. Provide straightedges with handles for operation on the pavement.

2.11.10 Work Bridge

Provide a self-propelled work bridge capable of spanning the required paving lane width where workmen can efficiently and adequately reach the pavement surface.

2.11.11 Hand Finishing Tools

Provide hand finishing equipment in accordance with the provisions of this specification. Use the hand method only on isolated areas of odd slab widths or shapes and in the event of a breakdown of the mechanical finishing equipment. Keep supplemental hand finishing for machine finished pavement to an absolute minimum. Do not seal the paving surface with steel trowels.

2.12 SPECIFIED CONCRETE STRENGTH AND OTHER PROPERTIES

****
NOTE: Fill in blanks as appropriate. Specify the flexural strength used in the structural design of the pavement a maximum of 650 psi 4.5 MPa at 90 days of age. However, modify to 28-days if 28-day strength is approved in writing by TSMCX, AFCEC pavement SME, or NAVFAC as stated in paragraph FLEXURAL STRENGTH. Be sure this and succeeding paragraphs remain consistent.

For the standard coarse aggregate with the nominal maximum size of 37 mm 1.5 inches, the total air content must be specified as 6.0 percent where freezing and thawing is a concern. For a coarse aggregate with the nominal maximum size of 25 mm 1.0 inch, the total air content must be specified as 6.5 percent where freezing and thawing is a concern. Specify 4.0 percent where freezing and thawing is not a concern.
****

2.12.1 Specified Flexural Strength

****
NOTE: Use the Tailoring Option "Beams" or "Cylinders/Beams" to specify flexural strength for concrete.
****

Specified flexural strength, R, for concrete is [_____] MPa psi at [28] [90] days, as determined by tests made in accordance with ASTM C78/C78M of beams fabricated and cured in accordance with ASTM C192/C192Mequivalent flexural strength, as specified in paragraph Mixture Proportioning For Flexural Strength below.

2.12.2 Allowable Water-Cementitious Materials Ratio

The allowable water-cementitious material ratio is 0.38 to 0.45. The water-cementitious material ratio is the equivalent water-cement ratio as

determined by conversion from the weight ratio of water to cement plus SCM by the mass equivalency method described in ACI 211.1.

2.12.3 Air Content

Provide concrete that is air-entrained with a total air content of [4.0] [6.0] [6.5] plus or minus 1.5 percentage points, at the point of placement. Determine air content in accordance with ASTM C231/C231M.

2.12.4 Slump

The maximum allowable slump of the concrete at the point of placement is listed in Table 12.

TABLE 12	
MAXIMUM ALLOWABLE SLUMP	
Placement Method	Maximum Slump
Slipform	As required to meet edge slump and joint face deformation limits
Fixed Form	50 mm2 inches
Other Types of Finishing Equipment	75 mm3 inches
Hand Placement	75 mm3 inches

The selected slump is applicable to both pilot and fill-in lanes. Perform separate trial mixture studies for each placement method, as specified in paragraph Trial Mixture Studies.

2.12.5 Concrete Temperature

The temperature of the concrete as delivered is required to conform to the requirements of paragraphs Paving In Hot Weather and Paving In Cold Weather. Determine the temperature of concrete in accordance with ASTM C1064/C1064M.

2.12.6 Concrete Strength for Final Acceptance

****
NOTE: Use the Tailoring Option to specify concrete strength by using "Cylinders/Beams" or "Beams".
****

[The strength of the concrete will be considered acceptable when the average equivalent [90-day] [28-day] flexural strengths for each lot are above the 'Specified Flexural Strength' as determined by correlation with 14-day compressive strength tests specified in paragraph Mixture Proportioning For Flexural Strength below,][The strength of the concrete will be considered acceptable when the equivalent [90-day] [28-day] flexural strengths for each lot are above the 'Specified Flexural Strength' as determined by correlation with 14-day flexural strength tests specified in paragraph Mixture Proportioning For Flexural Strength below,]

and no individual set (2 specimens per sublot) in the lot are 170 kPa 25 psi or more below the equivalent 'Specified Flexural Strength'. If any lot or sublot, respectively, fails to meet the above criteria, remove and replace the lot or sublot at no additional cost to the Government. This is in addition to and does not replace the average strength required for day-to-day CQC operations as specified in paragraph Average Cqc Flexural Strength Required For Mixtures, below.

2.13 MIXTURE PROPORTIONS

****

NOTE: Edit bracketed items as appropriate. Normally, permit accelerating admixtures only with fast-track paving. If approval has been obtained and airfield pavement has been designed and specified for 28-day flexural strength in paragraph SPECIFIED FLEXURAL STRENGTH, modify the following subparagraphs accordingly. Do the same if this is road pavement designed for 28-day strength. Use the higher bracketed total cementitious content if a supplementary cementitious material is used.

Include bracketed sentences on limiting alkali loading for airfield pavement projects.

****

2.13.1 Mixture Proportions Composition

Provide concrete composed of cementitious material, water, fine and coarse aggregates, and admixtures. Include supplementary Cementitious Materials (SCM) choice and usage in accordance with paragraph Supplementary Cementitious Materials (SCM) Content. Provide a minimum total cementitious materials content of [280 kg per cubic meter 470 pounds per cubic yard] [310 kg per cubic meter 517 pounds per cubic yard]. [Limit the total alkali loading contributed by the portland cement or the portland cement portion of a blended cement to a maximum of 1.8 kg per cubic meter 3.0 lb per cubic yard. Calculate the alkali loading as the product of the portland cement content of the concrete multiplied by the alkali content of the portland cement or the portland cement portion of the blended cement, divided by 100. Determine the alkali content in accordance with ASTM C114.]Acceptable admixtures consist of air entraining admixture and may also include, as approved, [water-reducing admixture,][retarding admixture,][accelerating admixture,][water-reducing and retarding admixtures,][water reducing and accelerating admixtures].

2.13.2 Proportioning Studies

Perform trial design batches, mixture proportioning studies, and testing, at no expense to the Government. Submit for approval the Preliminary Proposed Proportioning to include items a., b., and i. below a minimum of 21 days prior to beginning a mixture proportioning study. Submit the results of the mixture proportioning studies signed and stamped by the registered professional engineer having technical responsibility for the mix design study, and submitted at least 30 days prior to commencing concrete placing operations. Include a statement summarizing the maximum nominal coarse aggregate size and the weights and volumes of each ingredient proportioned on a one cubic meter yard basis. Base aggregate quantities on the mass in a saturated surface dry condition. Provide test

results demonstrating that the proposed mixture proportions produce concrete of the qualities indicated. Base methodology for trial mixtures having proportions, slumps, and air content suitable for the work as described in ACI 211.1, modified as necessary to accommodate flexural strength. ACI 211.1 can be supplemented with ACI 325.14R. Submit test results including:

a. Individual coarse and fine aggregate gradations and plots. Include historic gradation averages and standard deviations on individual sieves for each aggregate size group.
b. Combined aggregate gradation and coarseness vs. workability plots.
c. Coarse aggregate quality test results.
d. Fine aggregate quality test results.
e. Mill certificates for cement and supplementary cementitious materials.
f. Certified test results for air entraining, water reducing, retarding, non-chloride accelerating[, and Lithium Nitrate] admixtures.
g. Specified flexural strength, slump, and air content.
h. Documentation of required average CQC flexural strength, Ra.
i. Recommended proportions and volumes for proposed mixture and each of three trial water-cementitious materials ratios for each proposed placement method.
j. Individual beam [and cylinder]breaks.
k. Flexural [and compressive]strength summaries and plots.
l. Correlation ratios for acceptance testing and CQC testing.
m. Historical record of ACI 214R strength test results, documenting production standard deviation (if available).
n. Narrative discussing methodology on how the mix design was developed in accordance with ACI 211.1 and ACI 325.14R.
o. Alternative aggregate blending to be used during the test section if necessary to meet the required surface and consolidation requirements.

2.13.2.1 Water-Cementitious Materials Ratio

Perform at least three different water-cementitious materials ratios, within the limits specified in paragraph Allowable Water-Cementitious Materials Ratio, which produce a range of strength encompassing that required on the project. The minimum and maximum water-cementitious materials ratios of the approved mix design become the minimnum and maximum water-cementitious materials ratio for the project during production.

2.13.2.2 Trial Mixture Studies

Perform separate sets of trial mixture studies made for each combination of cementitious materials and each combination of admixtures proposed for use. No combinations are to be used until proven by such studies, except that, if approved in writing and otherwise permitted by these specifications, an accelerating or retarding admixture can be used without separate trial mixture study. Perform separate trial mixture studies for each placing method (slip form, fixed form, or hand placement) proposed. Report the temperature of concrete in each trial batch. Design each mixture to promote easy and suitable concrete placement, consolidation and finishing, and to prevent segregation and excessive bleeding. Proportion laboratory trial mixtures for maximum slump and air content, as permitted by the placement method being utilized.

2.13.2.3 Mixture Proportioning for Flexural Strength

****

NOTE: The first Tailoring Option, "Beams", includes items a through j; the second option "Cylinders/Beams" includes the second listing of items a through j.

****

Follow the step by step procedure below:

a. Fabricate all beams for each mixture from the same batch or blend of batches. Fabricate and cure all beams in accordance with ASTM C192/C192M, using 152 x 152 mm 6 x 6 inches steel beam molds.

b. Cure test beams from each mixture for 3, 7, 14, and [and 28] [56 and 90]-day flexural tests; 6 beams to be tested per age.

c. Test beams in accordance with ASTM C78/C78M.

d. Using the average strength for each w/c at each age, plot all results from each of the three mixtures on separate graphs for w/c versus:
   3-day flexural strength
   7-day flexural strength
   14-day flexural strength
   [28-day flexural strength]
   [56 and 90-day flexural strength]

e. From these graphs select a w/c that produces a mixture giving a [28] [56] [90]-day flexural strength equal to the required strength determined in accordance with paragraph Average CQC Flexural Strength Required for Mixtures.

f. Using the above selected w/c, select from the graphs the expected 3, 7 and 14-day flexural strengths.

g. From the above expected strengths for the selected mixture, determine the Ratio of the 7-day flexural strength of the selected mixture to the [28] [56] [90]-day flexural strength of the mixture (for CQC control).

h. From the above expected strengths for the selected mixture, determine the Ratio of the 14-day flexural strength of the selected mixture to the [28] [90]-day flexural strength of the mixture (for acceptance).

i. If there is a change in materials, perform additional mixture design studies using the new materials and determine new Correlation Ratios.

j. No concrete pavement placement is allowed until the mixture proportions are approved. The approved water-cementitious materials ratio is restricted to the minimum and maximum values specified in paragraph Water-Cementitious Materials Ratio and is not to be increased without written approval.

a. Fabricate all beams and cylinders for each mixture from the same batch or blend of batches. Fabricate and cure all beams and cylinders in accordance with ASTM C192/C192M, using 152 x 152 mm 6 x 6 inches steel beam molds and 152 x 305 mm 6 x 12 inches single-use cylinder molds.

b. Cure test beams from each mixture for 3, 7, 14, [and 28] [56 and 90]-day flexural tests; 6 beams to be tested per age.

c. Cure test cylinders from each mixture for 3, 7, 14, [and 28] [56 and 90]-day compressive strength tests; 6 cylinders to be tested per age.

d. Test beams in accordance with ASTM C78/C78M, cylinders in accordance with ASTM C39/C39M.

e. Using the average strength for each w/c at each age, plot all results from each of the three mixtures on separate graphs for w/c versus:

    3-day flexural strength
    7-day flexural strength
    14-day flexural strength
    [28-day flexural strength]
    [56 and 90-day flexural strength]

    3-day compressive strength
    7-day compressive strength
    14-day compressive strength
    [28-day compressive strength]
    [56 and 90-day compressive strength]

f. From these graphs select a w/c that produces a mixture giving a [28] [56] [90]-day flexural strength equal to the required strength determined in accordance with paragraph Average CQC Flexural Strength Required for Mixtures.

g. Using the above selected w/c, select from the graphs the expected 3, 7, 14, [28] [56] [90]-day flexural strengths and the expected 3, 7, 14, [28] [56] [90]-day compressive strengths for the mixture.

h. From the above expected strengths for the selected mixture determine the following Correlation Ratios:

    (1) Ratio of the 14-day compressive strength of the selected mixture to the [28][90]-day flexural strength of the mixture (for acceptance).

    (2) Ratio of the 7-day compressive strength of the selected mixture to the [28][90]-day flexural strength of the mixture (for CQC control).

i. If there is a change in materials, perform additional mixture design studies using the new materials and new Correlation Ratios determined.

j. No concrete pavement placement is allowed until the mixture proportions are approved. The approved water-cementitious materials ratio is restricted to the minimum and maximum values specified in paragraph Water-Cementitious Materials Ratio and is not to be increased without written approval.

2.13.3 Average CQC Flexural Strength Required for Mixtures

a. In order to meet the strength requirements specified in paragraph SPECIFIED CONCRETE STRENGTH AND OTHER PROPERTIES during production, the mixture proportions selected during mixture proportioning studies and used during construction require an average CQC flexural strength, Ra, exceeding the specified flexural strength, R, by the amount indicated below.

b. The required average CQC flexural strength, Ra, is used only for proportioning studies and CQC operations as specified in paragraph Concrete Strength Testing for CQC.

c. Acceptance of production flexural strength results is based on the specified flexural strength R specified in paragraph: Specified Flexural Strength.

2.13.3.1 From Previous Test Records

Where a concrete production facility has previous test records current to within 18 months, establish a standard deviation in accordance with the applicable provisions of ACI 214R. Include test records from which a standard deviation is calculated that represent materials, quality control procedures, and conditions similar to those expected, that represent concrete produced to meet a specified flexural strength or strengths within 1 MPa 150 psi of the [28] [90]-day flexural strength specified for the proposed work, and that consist of at least 30 consecutive tests. Perform verification testing to document the current strength. A strength test is the average of the strengths of two specimens made from the same sample of concrete and tested at [28] [90] days. Required average CQC flexural strength, Ra, used as the basis for selection of concrete proportions is the value from the equation that follows, using the standard deviation as determined above:

$$Ra = R + 1.34S$$

Where: S = standard deviation
R = specified flexural strength
Ra = required average CQC flexural strength

Where a concrete production facility does not have test records meeting the requirements above but does have a record based on 15 to 29 consecutive tests, establish a standard deviation as the product of the calculated standard deviation and a modification factor from Table 13:

TABLE 13	
MODIFICATION FACTOR FOR STANDARD DEVIATION	
NUMBER OF TESTS	MODIFICATION FACTOR
20	1.08
25	1.03
30 or more	1.00

2.13.3.2 Without Previous Test Records

When a concrete production facility does not have sufficient field strength test records for calculation of the standard deviation, determine the required average CQC flexural strength, Ra, by adding 15 percent to the specified flexural strength, R.

PART 3 EXECUTION

3.1 PREPARATION FOR PAVING

Before commencing paving, perform the following actions to prepare for paving operations. If used, place cleaned, coated, and adequately supported forms. Have any reinforcing steel needed at the paving site; all transporting and transfer equipment ready for use, clean, and free of hardened concrete and foreign material; equipment for spreading, consolidating, screeding, finishing, and texturing concrete at the paving site, clean and in proper working order; and all equipment and material for curing and for protecting concrete from weather or mechanical damage at the paving site, in proper working condition, and in sufficient amount for the entire placement.

3.1.1 Weather Precaution

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. During these conditions, record and report the evaporation rate hourly.

3.1.2 Proposed Techniques

****

NOTE: Include joint layout and typical detail of joint/dowel bar spacing in drawings and coordinate with paragraph PLACING DOWELS AND TIE BARS. Insert office title for approval of joint plan changes.

****

Submit placing and protection methods; paving sequence; jointing pattern; data on curing equipment and profilographs; repair in accordance with paragraph REPAIR, REMOVAL AND REPLACEMENT OF NEWLY CONSTRUCTED SLABS, demolition of existing pavements, as specified; pavement diamond grinding equipment and procedures. Submit for approval the following items:

a. Pavement demolition work plan, presenting the proposed methods and equipment to remove existing pavement and protect pavement to remain in place.

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

c. A detailed paving sequence plan and proposed paving pattern showing all planned construction joints; transverse and longitudinal dowel bar spacing; and identifying pilot lanes, fill-in lanes, and hand placement areas. Include stationing for reference to all sampling and testing performed. Deviations from the jointing pattern shown on the drawings are not allowed without written approval of the [design engineer] [_____].

d. Plan and equipment proposed to control alignment of sawn joints within the specified tolerances.

e. Data on the curing equipment, media and methods to be used.

f. Data on profilograph and methods to measure pavement smoothness.

g. A description of the equipment and methods to be used for grinding and repairs.

3.2 CONDITIONING OF UNDERLYING MATERIAL

3.2.1 General Procedures

Confirm 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, confirm the underlying material is well drained and has been satisfactorily graded and uniformly compacted in accordance with the applicable contract documents. 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 beyond the edge of the lane a sufficient distance to provide a suitable trackline for the slipform paver and firm support for the edge of the paving lane.

3.2.2 Traffic on Underlying Material

****

NOTE: Do not allow transporting equipment to operate on the prepared underlying material for airfield paving. Operating hauling equipment in the paving lane can cause the paver to stop frequently, producing a discontinuity in the pavement surface. Edit bracketed items as appropriate and coordinate with paragraph TRANSFER AND SPREADING EQUIPMENT. The second bracketed item is only intended for use on roads and other areas where site limitations require consideration of this approach.

****

After the underlying material has been prepared for concrete placement, equipment is not permitted thereon with exception of the paver. Subject to specific approval, crossing of the prepared underlying material at specified intervals for construction purposes may be permitted, provided rutting or indentations do not occur. Rework and repair the surface before concrete is placed. [Transporting equipment is not to be allowed to operate on the prepared and compacted underlying material in front of the paver-finisher.] [Equipment may be allowed to operate on the underlying material only if approved and only if no damage is done to the underlying material and its degree of compaction. Correct any disturbance to the underlying material that occurs, as approved, before the paver-finisher or the deposited concrete reaches the location of the disturbance and replace the equipment or change procedures to prevent any future damage.]

3.3 WEATHER LIMITATIONS

3.3.1 Placement and Protection During 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. Immediately cover and protect all unhardened concrete from rain or other damaging weather. Suspend placement of concrete whenever rain, high winds, or other 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.

Remove and replace any slab damaged by rain or other weather, as defined in paragraph Weak Surfaces, full depth, by full slab width, to the nearest original joint as specified in paragraph REPAIR, REMOVAL AND REPLACEMENT OF NEWLY CONSTRUCTED SLABS, at no expense to the Government.

3.3.2 Paving in Hot Weather

****

NOTE: See ACI 305R for additional information concerning hot weather concreting. Do not delete this paragraph or the next paragraphs dealing with weather.

****

Prepare for hot weather paving in accordance with ACI 305R. When the ambient temperature during paving is expected to exceed 32 degrees C 90 degrees F, properly place and finish the concrete in accordance with procedures previously submitted, approved, and as specified herein. Provide concrete that does not exceed the temperature shown in Table 14 below when measured in accordance with ASTM C1064/C1064M at the time of delivery. Cool the mixing water or aggregates or place in the cooler part of the day to obtain an adequate placing temperature. Cool steel forms and reinforcing as needed to maintain steel temperatures below 49 degrees C 120 degrees F. Cool or protect transporting and placing equipment if necessary to maintain proper concrete placing temperature. Keep the finished surfaces of the newly laid pavement damp by applying a fog spray (mist) with approved spraying equipment until the pavement is covered by the curing medium.

TABLE 14	
Maximum Allowable Concrete Placing Temperature	
Relative Humidity, Percent, During Time of Concrete Placement	Maximum Allowable Concrete Temperature in Degrees C F
Greater than 60	3290
55-60	2985
Less than 55	2475

3.3.3 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, further protect the concrete placement by erecting shades and windbreaks and by applying fog sprays of water, the addition of monomolecular films, or wet covering. If monomolecular films are used, apply only after finishing is complete, do not use in the finishing process, and follow manufacturer recommendations. Immediately commence curing procedures when such water treatment is stopped. Repair plastic shrinkage cracks in accordance with paragraph REPAIR, REMOVAL AND REPLACEMENT OF NEWLY CONSTRUCTED SLABS. Never trowel over or fill plastic shrinkage cracks with slurry.

3.3.4 Paving in Cold Weather

Cold weather paving is required to conform to ACI 306R. Use special protection measures, as specified herein, if freezing temperatures are anticipated or occur before the expiration of the specified curing period. Do not begin placement of concrete unless the ambient temperature is at least 2 degrees C 35 degrees F and rising. Thereafter, halt placement of concrete whenever the ambient temperature drops below 5 degrees C 40 degrees F. When the ambient temperature is less than 10 degrees C 50 degrees F, the temperature of the concrete when placed is required to be not less than 10 degrees C 50 degrees F nor more than 25 degrees C 75 degrees F. Provide heating of the mixing water or aggregates as required to regulate the plastic concrete temperature. Provide materials entering the mixer that are free from ice, snow, or frozen lumps. Do not incorporate salt, chemicals or other materials in the concrete to prevent freezing. [If allowed under paragraph MIXTURE PROPORTIONS in PART 2, use an accelerating admixture when the ambient temperature is below 10 degrees C 50 degrees F.] Provide covering and other means for maintaining the concrete at a temperature of at least 10 degrees C 50 degrees F for not less than 72 hours after placing, and at a temperature above freezing for the remainder of the curing period as defined in paragraph Protection of Concrete. Remove pavement slabs, full depth by full width, damaged by freezing or falling below freezing temperature to the nearest planned joint, and replace as specified in paragraph REPAIR, REMOVAL AND REPLACEMENT OF NEWLY CONSTRUCTED SLABS, at no expense to the Government.

3.4 CONCRETE PRODUCTION

****

NOTE: Coordinate these paragraphs with paragraph EQUIPMENT. Delete item in brackets if truck mixers are not permitted.

****

Maintain a continuous, uniform forward movement of the paver of not less than 0.8 m 2.5 feet per minute. Provide batching, mixing, and transporting equipment with a capacity sufficient to meet this production rate. Deposit concrete transported in non-agitating equipment in front of the paver within 45 minutes from the time cement has been charged into the mixing drum, except that if the ambient temperature is above 32 degrees C 90

degrees F, the time is reduced to 30 minutes. Deposit concrete transported in truck mixers in front of the paver within 90 minutes from the time cement has been charged into the mixer drum of the plant or truck mixer. Truck mixers are not allowed for mixing or transporting slipformed paving concrete. If the ambient temperature is above 32 degrees C 90 degrees F, the time is reduced to 60 minutes. Accompany every load of concrete delivered to the paving site with a batch ticket from the operator of the batching plant. Provide batch ticket information required by ASTM C94/C94M on approved forms. In addition provide design quantities in mass or volume for all materials, batching tolerances of all materials, mixture batching time, and design and actual water cementitious materials ratio on each batch delivered, [the water meter and revolution meter reading on truck mixers]and the time of day on all batch tickets. Provide batch tickets for each truck delivered as part of the lot acceptance package to the placing foreman to maintain on file and deliver them to the Government weekly.

3.4.1 Batching and Mixing Concrete

Remove any equipment which fails to perform as specified immediately from use until properly repaired and adjusted or replaced.

3.4.2 Transporting and Transfer - Spreading Operations

Operate non-agitating equipment only on smooth roads and for haul time less than 30 minutes. Deposit concrete as close as possible to its final position in the paving lane[using a transfer-spreader]. Operate all equipment to discharge and transfer concrete without segregation. Dumping of concrete in discrete piles is not permitted. No transfer or spreading operation which requires the use of front-end loaders, dozers, or similar equipment to distribute the concrete is permitted. No equipment is permitted to operate on the grade in front of the paver.

3.5 PAVING

****
NOTE: Coordinate these paragraphs with paragraph EQUIPMENT.
****

3.5.1 General Requirements

Construct pavement with paving and finishing equipment utilizing rigid fixed forms or by use of slipform paving equipment. Provide paving and finishing equipment and procedures resulting in paving lanes of the required width at a rate of at least 0.8 m 2.5 feet of paving lane per minute on a routine basis. Control paving equipment and its operation, and coordinate with all other operations, such that the paver-finisher has a continuous forward movement at a reasonably uniform speed from beginning to end of each paving lane, except for inadvertent equipment breakdown. Backing the paver and refinishing a lane is not permitted. Remove and replace concrete refinished in this manner. Failure to achieve a continuous forward motion requires halting operations, and modifying procedures, equipment, or mix proportions to achieve this requirement. Personnel are not permitted to walk or operate in the plastic concrete at any time. Select paving equipment and procedures which operate properly on the underlying material without causing displacement or other damage.

3.5.2 Consolidation

Consolidate concrete with the specified type of lane-spanning, gang-mounted, mechanical, immersion type vibrating equipment mounted in front of the paver, supplemented, in rare instances as specified, by hand-operated vibrators. Insert vibrators into the concrete to a depth that provides the best full-depth consolidation but not closer to the underlying material than 50 mm 2 inches. Excessive vibration is not permitted. If vibrators cause visible tracking in the paving lane, discontinue paving operations until equipment and operations have been modified to prevent it. Consolidate concrete in small, odd-shaped slabs or in isolated locations inaccessible to the gang-mounted vibration equipment with an approved hand-operated immersion vibrator operated from a bridge spanning the area. Do not use vibrators to transport or spread the concrete. Do not operate hand-operated vibrators in the concrete at one location for more than 20 seconds. Insert hand-operated vibrators between 150 to 400 mm 6 to 15 inches on centers. For each paving train, provide at least one additional vibrator spud, or sufficient parts for rapid replacement and repair of vibrators at the paving site at all times. Any evidence of inadequate consolidation (honeycomb along the edges, large air pockets, or any other evidence) requires the immediate stopping of the paving operation and approved adjustment of the equipment or procedures.

3.5.3 Operation

When the paver approaches a header at the end of a paving lane, maintain a sufficient amount of concrete ahead of the paver to provide a roll of concrete which spills over the header. Provide a sufficient amount of extra concrete to prevent any grout that is formed and carried along ahead of the paver from being deposited adjacent to the header. Maintain the spud vibrators in front of the paver at the desired depth as close to the header as possible before they are lifted. Provide additional consolidation adjacent to the headers by hand-manipulated vibrators. When the paver is operated between or adjacent to previously constructed pavement (fill-in lanes), provide provisions to prevent damage to the adjacent pavement. Electronically control screeds or extrusion plates so as to prevent them from applying pressure to the existing pavement and to prevent abrasion of the pavement surface. Maintain the overlapping area of existing pavement surface completely free of any loose or bonded foreign material as the paver-finisher operates across it. Pavers using transversely oscillating screeds are not allowed to form fill-in lanes that have widths less than a full width for which the paver was designed or adjusted.

3.5.4 Required Results

Adjust and coordinate the paver-finisher, its gang-mounted vibrators, and operating procedures with the concrete mixture being used, to produce a thoroughly consolidated slab throughout that is true to line and grade within specified tolerances. Provide a paver-finishing operation that produces a surface finish with a minimum, isolated amount of irregularities, tears, voids of any kind, and any other discontinuities in a single pass across the pavement; multiple passes are not permitted. Provide equipment and its operation that produce a finished surface requiring no hand finishing other than the use of cutting straightedges, except in very infrequent instances. Stop paving if any equipment or operation fails to produce the above results. Prior to recommencing paving, properly adjust or replace the equipment, modify the operation, or

modify the mixture proportions, in order to produce the required results. No water, other than fog sprays (mist) as specified in paragraph Prevention Of Plastic Shrinkage Cracking above, is allowed to be applied to the concrete or the concrete surface during paving and finishing.

3.5.5 Fixed Form Paving

****
NOTE: Include fixed-form paving as an option or mandatory item as appropriate. Edit bracketed items in subparagraph a. Keys are only permitted for roads and streets with a thickness of 230 mm 9 inches or greater. Do not permit keys for airfield pavements.
****

Provide paving equipment for fixed-form paving and operation that conforms to the requirements of paragraph EQUIPMENT, and all requirements specified herein.

3.5.5.1 Forms for Fixed-Form Paving

****
NOTE: Delete subparagraph e. when overlay pavements are not required.
****

a. Provide straight forms made of steel and in sections not less than 3 m 10 feet in length that are clean and free of rust or other contaminants. Seal any holes or perforations in forms prior to paving unless otherwise permitted. Maintain forms in place and passable by all equipment necessary to complete the entire paving operation without need to remove horizontal form supports. Provide flexible or curved forms of proper radius for curves of 31 m 100-foot radius or less. Provide wood forms for curves and fillets made of well-seasoned, surfaced plank or plywood, straight, and free from warp or bend that have adequate strength and are rigidly braced. Provide forms with a depth equal to the pavement thickness at the edge. Where the project requires several different slab thicknesses, build up forms by bolting or welding a tubular metal section or by bolting wood planks to the bottom of the form to completely cover the underside of the base of the form and provide an increase in depth of not more than 25 percent. Provide forms with the base width of the one-piece or built-up form not less than eight-tenths of the vertical height of the form, except provide forms 200 mm 8 inches or less in vertical height with a base width not less than the vertical height of the form. Provide forms with maximum vertical deviation of top of any side form, including joints, not varying from a true plane more than 3 mm 1/8 inch in 3 m 10 feet, and the upstanding leg not varying more than 6 mm 1/4 inch. [Where keyway forms are required, rigidly attach the keyway form to the main form so no displacement can take place. Tack-weld metal keyway forms to steel forms. Align keyway forms so that there is no variation over 6 mm 1/4 inch either vertically or horizontally, when tested with a 4 m 12 foot template after forms are set, including tests across form joints.]

b. Provide form sections that are tightly locked and free from play or movement in any direction. Provide forms with adequate devices for secure settings so that when in place they withstand, without visible

spring or settlement, the impact and vibration of the consolidating and finishing equipment.

c. Set forms for full bearing on foundation for entire length and width and in alignment with edge of finished pavement. Support forms during entire operation of placing, consolidation, and finishing so that forms do not deviate vertically more than 3 mm 0.01 foot from required grade and elevations indicated. Check conformity to the alignment and grade elevations shown on the drawings and make necessary corrections immediately prior to placing the concrete. Clean and oil the forms each time before concrete is placed. Concrete placement is not allowed until setting of forms has been checked and approved by the CQC team.

d. Do not anchor guide rails for fixed form pavers into new concrete or existing concrete to remain.

[e. Use stakes or other approved methods to securely hold forms for overlay pavements and for other locations where forms are set on existing pavements. Carefully drill holes in existing pavements for form stakes by methods which do not crack or spall the existing pavement. After use, fill the holes flush with the surrounding surface using approved material, prior to overlying materials being placed. Immediately discontinue any method which does not hold the form securely or which damages the existing pavement. Prior to setting forms for paving operations, demonstrate the proposed form setting procedures at an approved location without proceeding further until the proposed method is approved.]

3.5.5.2 Form Removal

Keep forms in place at least 12 hours after the concrete has been placed. When conditions are such that the early strength gain of the concrete is delayed, leave the forms in place for a longer time. Remove forms by procedures that do not damage the concrete. Do not use bars or heavy metal tools directly against the concrete in removing the forms. Promptly repair any concrete found to be defective after form removal, using procedures specified or as directed.

3.5.6 Slipform Paving

****

NOTE: Retain slipform paving as an option unless there are specific, valid reasons for deleting it. Be sure all other paragraphs correspond with choice made here.

****

3.5.6.1 General

Provide paving equipment for slipform paving and the operation thereof that conforms to the requirement of paragraph EQUIPMENT, and all requirements specified herein. Provide a slipform paver capable of shaping the concrete in one pass to the specified and indicated cross section, meeting all tolerances, with a surface finish and edges that require only a very minimum isolated amount of hand finishing. If the paving operation does not meet the above requirements and the specified tolerances, immediately stop the operation and modify any equipment, paving procedures, or the concrete mix in order to resolve the problem.

Provide a slipform paver that is automatically electronically controlled from a taut guideline for horizontal alignment and on both sides from a taut guideline for vertical alignment, except that electronic control from a ski operating on a previously constructed adjoining lane is required where applicable for either or both sides. Automatic, electronic controls are required for vertical alignment on both sides of the lane. Control from a slope-adjustment control or control operating from the underlying material is not allowed. Properly adjust side forms on slipform pavers so that the finished edge of the paving lane meets all specified tolerances. Install dowels in longitudinal construction joints as specified below. The installation of these dowels by dowel inserters attached to the paver or by any other means of inserting the dowels into the plastic concrete is not permitted. [If a keyway is required, install a 0.45 to 0.55 mm 26 gauge thick metal keyway liner as the keyway is extruded. Provide keyway forms that do not vary more than plus or minus 3 mm 1/8 inch from the dimensions indicated and do not deviate more than plus or minus 6 mm 1/4 inch from the mid-depth of the pavement. An abrupt offset either horizontally or vertically in the completed keyway is not allowed. Maintain the keyway liner to remain in place and become part of the joint.]

3.5.6.2 Guideline for Slipform Paving

Accurately and securely install guidelines well in advance of concrete placement. Provide supports at necessary intervals to eliminate all sag in the guideline when properly tightened. Provide guideline consisting of high strength material designed for use as a paving guideline with sufficient tension to remove all sag between supports. Provide supports that are securely staked to the underlying material or make other provisions to keep the supports from displacing when the guideline is tightened or when the guideline or supports are accidentally touched by workmen or equipment during construction. Provide appliances for attaching the guideline to the supports that are capable of easy adjustment in both the horizontal and vertical directions. When it is necessary to leave gaps in the guideline to permit equipment to use or cross underlying material, provide provisions for quickly and accurately replacing the guideline without any delay to the forward progress of the paver. Provide supports on either side of the gap that are secured in such a manner as to avoid disturbing the remainder of the guideline when the portion across the gap is positioned and tightened. Check the guideline across the gap and adjacent to the gap for a distance of 60 m 200 feet for horizontal and vertical alignment after the guideline across the gap is tightened. Provide vertical and horizontal positioning of the guideline such that the finished pavement conforms to the alignment and grade elevations shown on the drawings within the specified tolerances for grade and smoothness. The specified tolerances are intended to cover only the normal deviations in the finished pavement that occur under good supervision and do not apply to setting of the guideline. Set the guideline true to line and grade.

3.5.6.3 Stringless Technology

If the use of any type of stringless technology is proposed, submit a detailed description of the system and perform a trial field demonstration at least one week prior to start of paving. Approval of the control system will be based on the results of the demonstration and on continuing satisfactory operation during paving.

3.5.7 Placing Reinforcing Steel

****
NOTE: Delete bracketed item if CRCP is not being constructed.
****

Provide the type and amount of steel reinforcement indicated. Regardless of placement procedure, provide reinforcing steel free from coatings which could impair bond between the steel and concrete, with reinforcement laps as indicated. Regardless of the equipment or procedures used for installing reinforcement, adequately consolidate the entire depth of concrete. Install steel reinforcement at the required elevation within a tolerance of plus of minus 13 mm1/2 inch. [If reinforcing for Continuously Reinforced Concrete Pavement (CRCP) is required, submit the entire operating procedure and equipment proposed for approval at least 30 days prior to proposed start of paving.]

3.5.7.1 Pavement Thickness Greater Than 300 mm 12 inches

For pavement thickness of 300 mm 12 inches or more, place an initial lift of concrete on the underlying material to the required elevation of the steel reinforcement, consolidate the initial lift of concrete, place the steel reinforcement upon the surface of the initial lift, place a second lift of concrete to final grade, consolidate, and finish in the required manner. When placement of the second lift causes the steel reinforcement to be displaced horizontally from its original position, provide provisions for increasing the thickness of the initial lift and depressing the steel reinforcement into the unhardened concrete to the required elevation. Limit the increase in thickness only as necessary to permit correct horizontal alignment to be maintained. Remove and replace any portions of the initial lift of concrete that have been placed more than 30 minutes without being covered with the second lift with newly mixed concrete without additional cost to the Government.

3.5.7.2 Pavement Thickness Less Than 300 mm 12 Inches

For pavements less than 300 mm 12 inches thick, position the reinforcement on suitable chairs or continuous mesh support devices securely fastened to the subgrade prior to concrete placement. Consolidate concrete after the steel has been placed.

3.5.8 Placing Dowels[and Tie Bars]

****
NOTE: Delete references to installation in contraction joints if not required. Tie bars are not permitted in airfield pavements. Use tie bars only for roads and streets projects.
****

Provide a method to install and hold dowels in position that meets the tolerances for location, alignment, and spacing of Table 15. Do not place longitudinal dowels [and tie bars]closer than 0.6 times the dowel bar [tie bar]length to the planned joint line. If the last regularly spaced longitudinal dowel [tie bar]is closer than that dimension, move it away from the joint to a location 0.6 times the dowel bar [tie bar]length, but not closer than 150 mm 6 inches to its nearest neighbor. Resolve dowel [tie bar] interference at a transverse joint-longitudinal joint

intersection by deleting the closest transverse dowel [tie bar]. Do not position the end of a transverse dowel closer than 300 mm 12 inches from the end of the nearest longitudinal dowel. Install dowels as specified in the following subparagraphs.

TABLE 15	
DOWEL ALIGNMENT TOLERANCES	
Dowel Measurement	Tolerance
Horizontal alignment (a)	Maximum of 3 mm per 300 mm 1/8 inch per foot after the pavement has been completed
Vertical alignment (b)	Maximum of 3 mm per 300 mm 1/8 inch per foot after the pavement has been completed
Horizontal spacing	plus or minus 15 mm 5/8 inch, except as otherwise specified above
Vertical location on the face of the slab	plus or minus 13 mm 1/2 inch
(a) Check horizontal alignment perpendicular to the joint edge with a framing square.	
(b) Measure the vertical alignment of the dowels parallel to the designated top surface of the pavement, except for those across the crown or other grade change joints. Measure dowels across crowns and other joints at grade changes to a level surface.	

3.5.8.1 Contraction Joints

Securely hold dowels [and tie bars]in longitudinal and transverse contraction joints within the paving lane in place, as indicated, by means of rigid metal frames or basket assemblies of an approved type. Securely hold the basket assemblies in the proper location by means of suitable pins or anchors. Do not cut or crimp the dowel basket tie wires.

3.5.8.2 Construction Joints-Fixed Form Paving

Install dowels [and tie bars]by the bonded-in-place method or the drill-and-dowel method. Installation by removing and replacing in preformed holes is not permitted. Prepare and place dowels [and tie bars] across joints where indicated, correctly aligned, and securely held in the proper horizontal and vertical position during placing and finishing operations, by means of devices fastened to the forms. Provide the spacing of dowels [and tie bars] in construction joints as indicated, except that, where the planned spacing cannot be maintained because of form length or interference with form braces, provide closer spacing with additional dowels[or tie bars].

3.5.8.3 Dowels Installed in Hardened Concrete

****

NOTE: The first Tailoring Option is for "Cylinders/Beams" and the second option is for "Beams".

****

Install dowels in hardened concrete by bonding the dowels into holes drilled into the hardened concrete. Before drilling commences, cure the concrete for 7 days or until it has reached a minimum field cured compressive strength of 17 MPa 2500 psi flexural strength of 3.1 MPa 450 psi. Drill holes 3 mm 1/8 inch greater in diameter than the dowels into the hardened concrete using rotary-core drills. Rotary-percussion drills are permitted, provided that excessive spalling does not occur at the concrete joint face. Excessive spalling is defined as spalling deeper than 6 mm 1/4 inch from the joint face or 12 mm 1/2 inch radially from the outside of the drilled hole. Continuing damage requires modification of the equipment and operation. Drill depth of dowel hole within a tolerance of plus or minus 13 mm 1/2 inch of the half length of the embedded dowel. Upon completion of the drilling operation, blow out the dowel hole with oil-free, compressed air. Bond dowels in the drilled holes using epoxy resin. Inject epoxy resin at the back of the hole before installing the dowel and extrude 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 grout hardens, by means of a suitable metal or plastic grout retention ring fitted around the dowel. Provide dowels required between new and existing concrete in holes drilled in the existing concrete, all as specified above. 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. Do not install tie bars in preformed holes. Construct a standard keyway, with the bent tie bars inserted into the plastic concrete through a 0.45 to 0.55 mm 26 gauge thick metal keyway liner. Protect and maintain the keyway liner to remain in place and become part of the joint. When bending tie bars, provide the radius of bend not greater than the minimum recommended for the particular grade of steel in the appropriate material standard. Before placement of the adjoining paving lane, straighten the tie bars using procedures which do not spall the concrete around the bar.

3.5.8.4 Lubricating Dowel Bars

Wipe clean the portion of each dowel intended to move within the concrete and coat with a thin, even film of lubricating oil or light grease before the concrete is placed. Form oil is not acceptable.

3.6 FINISHING

****

NOTE: Edit bracketed items as appropriate. Retain slipform paving subparagraph except when it is prohibited elsewhere. Delete Other Types of Finishing Equipment here and in PART 2, if not wanted. Hand finishing is allowed only for isolated, small, odd-shaped slabs or places inaccessible to the paver.

****

Provide finishing operations as a continuing part of placing operations starting immediately behind the paver. Provide finishing by the machine method. Hand finishing requirements are specifed in paragraph HAND

FINISHING. Provide the sequence of operations consisting of transverse finishing, longitudinal machine floating if used, straightedge finishing, texturing, and then edging of joints. Provide a work bridge as necessary for consolidation and hand finishing operations. Use the hand method only on isolated areas of odd slab widths or shapes and in the event of a breakdown of the mechanical finishing equipment. Keep supplemental hand finishing for machine finished pavement to an absolute minimum. Immediately stop any machine finishing operation which requires appreciable hand finishing, other than a moderate amount of straightedge finishing. Prior to recommencing machine finishing, properly adjust or replace the equipment. Immediately halt any operations which produce more than 3 mm 1/8 inch of mortar-rich surface (defined in paragraph Weak Surfaces) and modify the equipment, mixture, or procedures as necessary. Compensate for surging behind the screeds or extrusion plate and settlement during hardening and adjust the paving and finishing machines so that the finished surface of the concrete (not just the cutting edges of the screeds) is at the required line and grade. Maintain finishing equipment and tools clean and in an approved condition. Water is not allowed to be added to the surface of the slab with the finishing equipment or tools, or in any other way, except for fog (mist) sprays specified to prevent plastic shrinkage cracking.

3.6.1 Machine Finishing With Fixed Forms

Replace machines that cause displacement of the forms. Only one pass of the fixed form finishing machine is allowed over each area of pavement. If the equipment and procedures do not produce a surface of uniform texture, true to grade, in one pass, immediately stop the operation and adjust the equipment, mixture, and procedures as necessary.

3.6.2 Machine Finishing with Slipform Pavers

Operate the slipform paver so that only a very minimum of additional finishing work is required to produce pavement surfaces and edges meeting the specified tolerances. Immediately modify or replace any equipment or procedure that fails to meet these specified requirements as necessary. A non-rotating pipe float can be used while the concrete is still plastic, to remove minor irregularities and score marks. Only one pass of the pipe float is allowed. If there is concrete slurry or fluid paste on the surface that runs over the edge of the pavement, immediately stop the paving operation and modify the equipment, mixture, or operation to prevent formation of such slurry. Immediately remove any slurry which runs down the vertical edges by hand, using stiff brushes or scrapers. Slurry, concrete or concrete mortar is not allowed to build up along the edges of the pavement to compensate for excessive edge slump, either while the concrete is plastic or after it hardens.

3.6.3 Surface Correction and Testing

After all other finishing is completed but while the concrete is still plastic, eliminate minor irregularities and score marks in the pavement surface by means of cutting straightedges. Provide cutting straightedges with a minimum length of 4 m 12 feet that are operated from the sides of the pavement or from bridges. Provide cutting straightedges operated from the side of the pavement equipped with a handle 1 m 3 feet longer than one-half the width of the pavement. Test the surface for trueness with a straightedge held in successive positions parallel and at right angles to the center line of the pavement, and cover the whole area to detect variations. Advance the straightedge along the pavement in successive

stages of not more than one-half the length of the straightedge. Immediately fill depressions with freshly mixed concrete, strike off, consolidate with an internal vibrator, and refinish. Strike off projections above the required elevation and refinish. Continue the straightedge testing and finishing until the entire surface of the concrete is free from observable departure from the straightedge and conforms to the surface requirements specified in paragraph SURFACE SMOOTHNESS. This straightedging is not allowed to be used as a replacement for the straightedge testing of paragraph SURFACE SMOOTHNESS. Use long-handled, flat bull floats very sparingly and only as necessary to correct minor, scattered surface defects. If frequent use of bull floats is necessary, stop the paving operation and adjust the equipment, mixture or procedures to eliminate the surface defects. Keep finishing with hand floats and trowels to the absolute minimum necessary. Take extreme care to prevent overfinishing joints and edges. Produce the surface finish of the pavement essentially by the finishing machine and not by subsequent hand finishing operations. All hand finishing operations are subject to approval.

3.6.4 Hand Finishing

Use hand finishing operations only as specified below. Provide a work bridge to be used as necessary for consolidation and placement operations to avoid standing in concrete.

3.6.4.1 Equipment and Template

In addition to approved mechanical internal vibrators for consolidating the concrete, provide a strike-off and tamping template and a longitudinal float for hand finishing. Provide a template at least 300 mm 1 foot longer than the width of pavement being finished, of an approved design, and sufficiently rigid to retain its shape, that is constructed of metal or other suitable material shod with metal. Provide a longitudinal float at least 3 m 10 feet long, of approved design, that is rigid and substantially braced to maintain a plane surface on the bottom. Grate tampers (jitterbugs) are not allowed.

3.6.4.2 Finishing and Floating

As soon as the plastic concrete is placed and consolidated, strike off the concrete and screed to the cross section and to such elevation above grade that when consolidated and finished, the surface of the pavement is at the required elevation. Immediately following the final tamping of the surface, float the pavement longitudinally from bridges resting on the side forms and spanning but not touching the concrete. Do not advance the floating operation more than half the length of the float and continue over the new and previously floated surfaces.

3.6.5 Texturing

****

NOTE: Select type of texturing desired, retain that subparagraph, and delete the others. Determine the type of texturing, if any, desired by the using service. If no guidance is given, the usual default method is a burlap drag.

For Army airfield paving projects, specify a burlap drag texture.

For Air Force airfield paving projects, do not specify artificial turf, wire comb, or surface grooving textures.

For Navy airfield paving projects, do not specify wire comb or surface grooving textures.

Use Section 32 01 18.71 GROOVING OF AIRFIELD PAVING to specify saw-cut grooves.

Spring tine grooving is limited to use on roads and streets only.

****

Before the surface sheen has disappeared and before the concrete hardens or curing compound is applied, texture the surface of the pavement as described herein. After the curing period is complete, thoroughly power broom all textured surfaces to remove all debris.

3.6.5.1 Burlap Drag Surface

Apply surface texture by dragging the surface of the pavement, in the direction of the concrete placement, with an approved burlap drag. Operate the drag with the fabric moist, and maintain the fabric clean. Change as required to keep clean. Perform the dragging so as to produce a uniform finished surface having a fine sandy texture without disfiguring marks.

3.6.5.2 Broom Texturing

Complete brooming before the concrete has hardened to the point where the surface is unduly torn or roughened, but after hardening has progressed enough so that the mortar does not flow and reduce the sharpness of the scores. Overlap successive passes of the broom the minimum necessary to obtain a uniformly textured surface. Wash brooms thoroughly at frequent intervals during use. Remove worn or damaged brooms from the job site. Hand brooming is permitted only on isolated odd shaped slabs or slabs where hand finishing is permitted. For hand brooming, provide brooms with handles longer than half the width of slab to be finished. Transversely draw the hand brooms across the surface from the center line to each edge with slight overlapping strokes.

3.6.5.3 Artificial Turf Drag Surface

[Apply artificial turf texture by dragging the surface of the pavement in the direction of concrete placement with an approved, full-width, artificial turf drag.]

3.6.5.4 Wire-Comb Texturing

[Apply surface texture using an approved mechanical wire comb drag operated to comb the surface transverse to the pavement centerline. Provide a comb 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. Complete texturing before the concrete has hardened to the point where the surface and edges are unduly torn, but after hardening has progressed to the point where the serrations do not

close up. Provide serrations 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 9.5 mm 3/8 inch apart. Produce transverse texturing grooves in straight lines across each lane within a tolerance of plus or minus 13 mm 1/2 inch of a true line.]

3.6.5.5 Surface Grooving

[Groove the areas indicated on the drawings as required in 32 01 18.71 GROOVING OF AIRFIELD PAVEMENTS.][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 37 mm 1-1/2 inches. Cut grooves perpendicular to the centerline. Before grooving begins, allow the concrete to attain sufficient strength to prevent aggregate spalling. Do not cut grooves within 150 mm 6 inches of a runway centerline, transverse joint, or crack; or through neoprene compression seals. Produce transverse texturing grooves in straight lines across each lane within a tolerance of plus or minus 13 mm 1/2 inch of a true line.]

3.6.6 Edging

Before texturing has been completed, carefully finish the edge of the slabs along the forms, along the edges of slipformed lanes, and at the joints with an edging tool to form a smooth rounded surface of 3 mm 1/8 inch radius. Eliminate tool marks, and provide edges that are smooth and true to line. Water is not allowed to be added to the surface during edging. Take extreme care to prevent overworking the concrete.

3.6.7 Pavement Penetrations

Construct recesses for the tie-down anchors, lighting fixtures, and other outlets in the pavement to conform to the details and dimensions shown. Carefully finish the concrete in these areas to provide a surface of the same texture as the surrounding area that is within the requirements for plan grade and surface smoothness.

3.7 CURING

****
NOTE: Retain bracketed item at end of first paragraph mandating 24 hour moist cure only where locally required and only where approved in writing by the using service. Include membrane curing as a choice of curing methods.
****

3.7.1 Protection of Concrete

Continuously protect concrete against loss of moisture and rapid temperature changes for at least 7 days from the completion of finishing operations. Have all equipment needed for adequate curing and protection of the concrete on hand and ready for use before actual concrete placement begins. If any selected method of curing does not afford the proper curing and protection against concrete cracking, remove or replace the damaged pavement, and provide another method of curing as directed. Accomplish curing by one of the following methods [except use only moist curing for the first 24 hours].

3.7.2 Membrane Curing

****
NOTE: Retain the first set of bracketed sentences for Army and Air Force jobs; retain the the second set of bracketed sentences for Navy projects only.
****

Apply a uniform coating of white-pigmented, membrane-forming, curing compound to the entire exposed surface of the concrete as soon as the free water has disappeared from the surface after [finishing] [moist curing ceases]. Apply immediately along the formed edge faces after the forms are removed. Do not allow the concrete to dry before the application of the membrane. If any drying has occurred, moisten the surface of the concrete with a fine spray of water, and apply the curing compound as soon as the free water disappears. Apply the curing compound to the finished surfaces by means of an approved automatic spraying machine. [Apply the curing compound with an overlapping coverage that provides a two-coat application at a coverage of 10 square meters per L 400 square feet per gallon, plus or minus 5.0 percent for each coat. A one-coat application is allowed provided it is applied in a uniform application and coverage of 5 square meters per L 200 square feet per gallon, plus or minus 5.0 percent is obtained.][Apply the curing compound with a single overlapping application that provides a uniform coverage of 3.7 square meters per L 150 square feet per gallon.] 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. If pinholes, abrasions, or other discontinuities exist, apply an additional coat to the affected areas within 30 minutes. Respray curing compound to concrete surfaces that are subjected to heavy rainfall within 3 hours after the curing compound has been applied. Within the curing period, immediately respray areas where the curing compound is damaged by subsequent construction operations. During the entire curing period, adequately protect membrane-cured concrete surfaces from pedestrian and vehicular traffic, except as required for joint-sawing operations and surface tests, and from any other possible damage to the continuity of the membrane.

3.7.3 Moist Curing

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

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 system to provide continuous moist curing 24 hours per day and such that the entire surface is wet.

3.8 JOINTS

****

NOTE: Edit bracketed items in following subparagraphs to conform to design requirements. Retain dowels for construction joints.

For roads and streets, analyze the effect of tie bars on the pavement action and potential cracking before requiring or permitting their use. Remove joint types not required in the project.

****

3.8.1 General Requirements for Joints

Construct joints that conform to the locations and details indicated and are perpendicular to the finished grade of the pavement. Provide joints that are straight and continuous from edge to edge or end to end of the pavement with no abrupt offset and no gradual deviation greater than 13 mm 1/2 inch. Where any joint fails to meet these tolerances, remove and replace the slabs adjacent to the joint at no additional cost to the Government. Changes from the jointing pattern shown on the drawings are not allowed without written approval. Seal joints immediately following curing of the concrete or as soon thereafter as weather conditions permit as specified in Section 32 01 19.61 SEALING OF JOINTS IN RIGID PAVEMENT or 32 13 73.19 COMPRESSION CONCRETE PAVING JOINT SEALANT.

3.8.2 Longitudinal Construction Joints

Install dowels [or keys] [or tie bars] in the longitudinal construction joints, or thicken the edges as indicated. Install [dowels] [tie bars] as specified above. [If any length of completed keyway of 1.5 m 5 feet or more fails to meet the previously specified tolerances, install dowels in that part of the joint by drilling holes in the hardened concrete and grouting the dowels in place with epoxy resin.] After the end of the curing period, saw longitudinal construction joints to provide a reservoir at the top for sealant conforming to the details and dimensions indicated.

3.8.3 Transverse Construction Joints

Install transverse construction joints at the end of each day's placing operations and at any other points within a paving lane when concrete placement is interrupted for 30 minutes or longer. Provide transverse construction joints by utilizing headers or by paving through the joint, then full-depth sawcutting the excess concrete. Construct pavement with the paver as close to the header as possible, with the paver run out completely past the header. Provide transverse construction joints at a planned transverse joint constructed as shown or, if not shown otherwise, dowelled in accordance with paragraph DOWELS INSTALLED IN HARDENED CONCRETE, or paragraph FIXED FORM PAVING above.

3.8.4 Expansion Joints

Provide expansion joints where indicated, and about any structures and features that project through or into the pavement, using joint filler of the type, thickness, and width indicated, and installed to form a complete, uniform separation between the structure and the pavement or between two pavements. Attach the filler to the original concrete

placement with adhesive and mechanical fasteners and extending to the full slab depth. Tightly fit adjacent sections of filler together, with the filler extending across the full width of the paving lane or other complete distance in order to prevent entrance of concrete into the expansion space. Finish edges of the concrete at the joint face with an edger with a radius of 3 mm 1/8 inch. After placement and curing of the adjacent slab, sawcut the sealant reservoir depth from the filler.

3.8.5 Slip Joints

Install slip joints where indicated using the specified materials. Attach preformed joint filler material to the face of the original concrete placement with adhesive and mechanical fasteners. Sawcut a 19 mm 3/4 inch deep reservoir for joint sealant at the top of the joint. Finish edges of the joint face with an edger with a radius of 3 mm 1/8 inch.

3.8.6 Contraction Joints

Construct transverse and longitudinal contraction joints by an initial sawcut in the concrete with a 3 mm 1/8 inch blade to the indicated depth. During sawing of joints, and again 24 hours later, inspect all exposed lane edges for development of cracks below the saw cut, and immediately report results. If there are more than six consecutive uncracked joints after 48 hours, saw succeeding joints 25 percent deeper than originally indicated at no additional cost to the Government. Vary the time of initial sawing depending on existing and anticipated weather conditions to prevent uncontrolled cracking of the pavement. Commence sawing of the joints as soon as the concrete has hardened sufficiently to permit cutting the concrete without chipping, spalling, or tearing. Inspect the sawed faces of joints for undercutting or washing of the concrete due to the early sawing, and delay sawing if undercutting is sufficiently deep to cause structural weakness or excessive roughness in the joint. Continue the sawing operation as required during both day and night regardless of weather conditions. Saw the joints in the sequence of the concrete placement. Provide adequate lighting for night work. Illumination using vehicle headlights is not permitted. Provide a chalk line or other suitable guide to mark the alignment of the joint. Before sawing a joint, examine the concrete closely for cracks, and do not saw the joint if a crack has occurred near the planned joint location. Discontinue sawing if a crack develops ahead of the saw cut. Immediately after the joint is sawed, thoroughly flush the saw cut and adjacent concrete surface with water and vacuum until all waste from sawing is removed from the joint and adjacent concrete surface. Properly protect the concrete from damage and cure at sawed joints. Tightly seal the top of the joint opening and the joint groove at exposed edges with cord backer rod before the concrete in the region of the joint is resprayed with curing compound, and maintain until removed immediately before sawing the joint sealant reservoir. Respray the surface with curing compound as soon as free water disappears. Seal the exposed saw cuts on the vertical faces of pilot lanes with bituminous mastic or masking tape. After expiration of the curing period, widen the upper portion of the groove by sawing with ganged diamond saw blades to the width and depth indicated for the joint sealer. Center the reservoir over the initial sawcut.

3.8.7 Thickened Edge Joints

Construct thickened edge joints as indicated on the drawings. Grade the underlying material in the transition area as shown and meet the requirements for smoothness and compaction specified for all other areas

of the underlying material.

3.9 REPAIR, REMOVAL AND REPLACEMENT OF NEWLY CONSTRUCTED SLABS

3.9.1 General Criteria

Repair or remove and replace new pavement slabs as specified at no cost to the Government. Removal of partial slabs is not permitted. Prior to any repairs, submit a Repair Recommendations Plan detailing areas exceeding the specified limits as well as repair recommendations required to bring these areas within specified tolerances.

3.9.2 Repair of Free Edge Lane Vertical Faces

Repair excessive edge slump and joint face deformation while concrete is in a plastic state by approved methods using forms in accordance with paragraph Forms for Fixed-Form Paving.

3.9.3 Slabs with Cracks

The Government may require cores to be taken over cracks to determine depth of cracking. Drill cores with a minimum diameter of 150 mm 6 inches, and backfill with an approved concrete mixture. Perform drilling of cores and filling of holes at no expense to the Government. Clean cracks that do not exceed 50 mm 2 inches in depth; then pressure inject full depth with epoxy resin, Type IV, Grade 1. Remove and replace slabs containing cracks deeper than 50 mm 2 inches.

3.9.4 Removal and Replacement of Full Slabs

Remove new or existing slabs damaged during construction that contain more than 15.0 percent of each longitudinal or transverse joint edge spalled. Where it is necessary to remove full slabs, remove in accordance with paragraph Removal Of Existing Pavement Slab below. Remove and replace full depth, by full width of the slab, and extend to each original joint. Compact and shape the underlying material as specified in the appropriate section of these specifications, clean the surfaces of all four joint faces of all loose material and contaminants, and coat with a double application of membrane forming curing compound as a bond breaker and to protect concrete that has not been cured for at least 7 days. Install dowels of the size and spacing as specified for other joints in similar pavement by epoxy grouting them into holes drilled into the existing concrete using procedures as specified in paragraph PLACING DOWELS[AND TIE BARS], above. Provide dowels for all four edges of the new slab. Cut off original damaged dowels[or tie bars] flush with the joint face. Lightly oil or grease protruding portions of new dowels. Place concrete as specified for original construction. Take care to prevent any curing compound from contacting dowels[or tie bars]. Prepare and seal the resulting joints around the new slab as specified for original construction.

3.9.5 Repairing Spalls Along Joints

Repair spalls along joints to be sealed to a depth to restore the full joint-face support prior to placing adjacent pavement. Where directed, repair spalls along joints of new slabs, along edges of adjacent existing concrete, and along parallel cracks by first making a vertical saw cut at least 75 mm 3 inches outside the spalled area and to a depth of at least 50 mm 2 inches. Provide saw cuts consisting of straight lines forming

rectangular areas without sawing beyond the intersecting saw cut. Chip out the concrete between the saw cut and the joint, or crack, to remove all unsound concrete and into at least 13 mm 1/2 inch of visually sound concrete. Thoroughly clean the cavity thus formed with high pressure water jets supplemented with oil-free compressed air to remove all loose material. Immediately before filling the cavity, apply a prime coat to the dry cleaned surface of all sides and bottom of the cavity, except any joint face. Apply the prime coat in a thin coating and scrub into the surface with a stiff-bristle brush. Provide prime coat for portland cement repairs consisting of a neat cement grout and for epoxy resin repairs consisting of epoxy resin, Type III, Grade 1. Fill the prepared cavity with material identified in Table 16 based on the cavity volume.

TABLE 16	
SPALL REPAIRS	
Volume of Prepared Cavity After Removal Operations	Material
less than 0.00085 cubic meter 0.03 cubic foot	epoxy resin mortar or epoxy resin or latex modified mortar
0.00085 cubic meter 0.03 cubic foot and 0.009 cubic meter 1/3 cubic foot	portland cement mortar
more than 0.009 cubic meter 1/3 cubic foot	portland cement concrete or latex modified mortar

Provide portland cement concretes and mortars that consist of very low slump mixtures, 13 mm 1/2 inch slump or less, proportioned, mixed, placed, consolidated by tamping, and cured, all as directed. Provide epoxy resin mortars made with Type III, Grade 1, epoxy resin, using proportions and mixing and placing procedures as recommended by the manufacturer and approved. Proprietary patching materials may be used, subject to Government approval. Place the epoxy resin materials in the cavity in layers with a maximum thickness of 50 mm 2 inches. Provide adequate time between placement of additional layers such that the temperature of the epoxy resin material does not exceed 60 degrees C 140 degrees F at any time during hardening. Provide mechanical vibrators and hand tampers to consolidate the concrete or mortar. Remove any repair material on the surrounding surfaces of the existing concrete before it hardens. Where the spalled area abuts a joint, provide an insert or other bond-breaking medium to prevent bond at the joint face. For existing joints, seal the bottom contraction crack with backer rod to prevent instrusion of primer or mortar. Saw a reservoir for the joint sealant to the dimensions required for other joints. Thoroughly clean the reservoir and then seal with the sealer specified for the joints. In lieu of sawing, spalls and popouts, less than 150 mm 6 inches in maximum dimension and not adjacent to a joint, may be prepared by drilling a core 50 mm 2 inches in diameter greater than the size of the defect, centered over the defect, and 50 mm 2 inches deep or 13 mm 1/2 inch into sound concrete, whichever is greater. Repair the core hole as specified above for other spalls.

3.9.6 Weak Surfaces

Weak surfaces are defined as mortar-rich, rain-damaged, uncured, or containing exposed voids or deleterious materials. Rain damaged pavement is pavement with coarse aggregate exposed at the surface. Cores evaluated

by a qualified petrographer to contain carbonation to a depth greater than 3 mm 1/8 inch or Mohs hardness of less than 2, when tested in accordance with ASTM C1895, are also considered rain damaged. A mortar-rich surface is defined as pavement deficient in plus 4.75 mm U.S. No. 4 sieve size aggregate. Diamond grind slabs containing weak surfaces less than 6 mm 1/4 inch thick to remove the weak surface. Diamond grind in accordance with paragraph Diamond Grinding Of PCC Surfaces. All diamond ground areas are required to meet the thickness, smoothness and plan grade criteria specified in PART 1 GENERAL. Remove and replace slabs containing weak surfaces greater than 6 mm 1/4 inch thick.

3.9.7 Repair of Pilot Lane Vertical Faces

Repair excessive edge slump and joint face deformation while concrete is in a plastic state by approved methods.

3.10 EXISTING CONCRETE PAVEMENT REMOVAL AND REPAIR

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NOTE: Make sufficient exploration (not just reference to as-built drawings) to know exactly what the in-place existing pavement thickness and load-transfer are at the jointing area--such as dowels, keys, tie bars--and its condition. Normally, the joint between the new pavement and existing pavement is made at an existing joint in the old pavement. Coordinate with Section 02 41 00 DEMOLITION.

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Demolition of existing operational pavement is not allowed prior to approval of the Proportioning Studies. Remove existing concrete pavement at locations indicated on the drawings. Prior to commencing pavement removal operations, inventory the pavement distresses (cracks, spalls, and corner breaks) along the pavement edge to remain. After pavement removal, survey the remaining edge again to quantify any damage caused by removal operations. Perform both surveys in the presence of the Government. Perform repairs as indicated and as specified herein. Carefully control all operations to prevent damage to the concrete pavement and to the underlying material to remain in place. Perform all saw cuts perpendicular to the slab surface, forming rectangular areas. Perform all existing concrete pavement repairs prior to paving adjacent lanes.

3.10.1 Removal of Existing Pavement Slab

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NOTE: Make the second saw cut at a distance from the joint with a wheel saw which produces a 38 mm 1-1/2 inches or wider kerf and better prevents stress from propagating across the saw cut. Specify wheel saw for Army and Air Force projects. Specify diamond saw for Navy projects.

****

When existing concrete pavement is to be removed and adjacent concrete is to be left in place, perform the first full depth saw cut on the joint between the removal area and adjoining pavement to stay in place with a standard diamond-type concrete saw. Next, perform a full depth saw cut parallel to the joint that is at least 600 mm 24 inches from the joint and

at least 150 mm 6 inches from the end of any dowels with a [wheel saw] [diamond saw] as specified in paragraph SAWING EQUIPMENT. Remove all pavement beyond this last saw cut in accordance with the approved demolition work plan. Remove all pavement between this last saw cut and the joint line by carefully pulling pieces and blocks away from the joint face with suitable equipment and then picking them up for removal. In lieu of this method, this strip of concrete may be carefully broken up and removed using hand-held jackhammers, 14 kg 30 lb or less, or other approved light-duty equipment which does not cause stress to propagate across the joint saw cut and cause distress in the pavement which is to remain in place. In lieu of the above specified removal method, the slab may be sawcut full depth to divide it into several pieces and each piece lifted out and removed. Use suitable equipment to provide a truly vertical lift, and safe lifting devices used for attachment to the slab.

3.10.2 Edge Repair

Protect the edge of existing concrete pavement against which new pavement abuts from damage at all times. Remove and replace slabs which are damaged during construction as directed at no cost to the Government. Repair of previously existing damaged areas is considered a subsidiary part of concrete pavement construction. Saw off all exposed keys and keyways full depth.

3.10.2.1 Spall Repair

Repair spalls caused by construction activities if less than 15.0 percent of any slab's edge. Provide repair materials and procedures as previously specified in paragraph, Repairing Spalls Along Joints. Remove and replace full slabs if spalls exceed 15.0 percent of any slab's edge as specified in paragraph, Removal and Replacement of Full Slabs.

3.10.2.2 Underbreak and Underlying Material

Repair all underbreak by removal and replacement of the damaged slabs in accordance with paragraph REMOVAL AND REPLACEMENT OF FULL SLABS above. Protect the underlying material adjacent to the edge of and under the existing pavement which is to remain from damage or disturbance during removal operations and until placement of new concrete, and shape as directed. Maintain sufficient underlying material in place outside the joint line to completely prevent disturbance of material under the pavement which is to remain in place. Remove and replace any slab with underlying material that is disturbed or loses its compaction.

3.11 PAVEMENT PROTECTION

Exclude traffic from the new pavement by erecting and maintaining barricades and signs until the concrete is at least 14 days old, or for a longer period if so directed. As a construction expedient in paving intermediate lanes between newly paved pilot lanes, operation of the hauling and paving equipment is permitted on the new pavement after the pavement has been cured for 7 days, the joints have been sealed or otherwise protected, the concrete has attained a minimum field cured flexural beam strength of 3.8 MPa 550 psi and approved means are provided to prevent damage to the slab edge. Fabricate and field cure specimens in accordance with ASTM C31/C31M. Continuously maintain all new and existing pavement carrying construction traffic or equipment completely clean, and clean up spillage of concrete or other materials immediately upon occurrence. Take special care in areas where traffic uses or crosses

active airfield pavement. Power broom other existing pavements at least daily when traffic operates. For fill-in lanes, provide equipment that does not damage or spall the edges or joints of the previously constructed pavement. Protect the pavement against all damage prior to final acceptance of the work by the Government. Placement of aggregates, rubble, or other similar construction materials on airfield pavements is not allowed.

3.12 TESTING AND INSPECTION FOR CONTRACTOR QUALITY CONTROL DURING CONSTRUCTION

3.12.1 Testing and Inspection by Contractor

During construction, perform sampling and testing of aggregates, cementitious materials (cement, slag cement, and pozzolan), and concrete to determine compliance with the specifications. Provide facilities and labor for procurement of representative test samples. Furnish sampling platforms and belt templates to obtain representative samples of aggregates from charging belts at the concrete plant. Obtain samples of concrete at the point of delivery to the paver. Testing by the Government in no way relieves the specified testing requirements. Perform the inspection and tests described below, and based upon the results of these inspections and tests, take the action required and submit reports as required. Perform this testing regardless of any other testing performed by the Government, either for pay adjustment purposes or for any other reason. Include stationing for all sampling and testing.

3.12.2 Testing and Inspection Requirements

Perform CQC sampling, testing, inspection and reporting in accordance with the following Table. Retest aggregate sources and stockpiles in accordance with Table 17 if not used within the previous 3 months.

TABLE 17			
TESTING AND INSPECTION REQUIREMENTS			
Frequency	Test Method	Control Limit	Corrective Action
Fine Aggregate Gradation and Fineness Modulus			
2 per lot	ASTM C136/C136M sample at belt	9 of 10 tests vary less than 0.15 from average	Retest, resolve, retest
		Outside limits on any sieve	Retest
		2nd gradation failure	Stop, resolve, retest
1 per 10 gradations	ASTM C117	Outside limits on any sieve	Retest
		2nd gradation failure	Stop, repair, retest

TABLE 17			
TESTING AND INSPECTION REQUIREMENTS			
Frequency	Test Method	Control Limit	Corrective Action
Coarse Aggregate Gradation (each aggregate size)			
2 per lot	ASTM C136/C136M sample at belt	Outside limits on any sieve	Retest
		2nd gradation failure	report to COR, correct
		2 consecutive averages of 5 tests outside limits	report to COR, stop ops, repair, retest
1 per 10 gradations	ASTM C117	Outside limits on any sieve	Retest
		2nd gradation failure	report to COR, correct
		2 consecutive averages of 5 tests outside limits	report to COR, stop ops, repair, reverify all operations
Workability Factor and Coarseness Factor Computation			

TABLE 17			
TESTING AND INSPECTION REQUIREMENTS			
Frequency	Test Method	Control Limit	Corrective Action
Same as C.A. and F.A.	see paragraph AGGREGATES	Use individual C.A. and F.A. gradations. Combine using batch ticket percentages (average of aggregate percentages from 3 before and 3 after sampling). Tolerances: plus or minus 3 points on WF; plus or minus 5 points on CF from approved adjusted mix design values; only the portion of the tolerance box within the parallelogram is available for use	Check batching tolerances, recalibrate scales
		2 consecutive averages of 5 tests outside limits	Stop production paving, report to COR, and revise materials and operations to be in compliance prior to restarting production paving
Aggregate Deleterious, Quality, and ASR Tests			
Every 30 days of concrete production	see paragraph AGGREGATES		Stop production, retest, replace aggregate. Increase testing interval to 90 days if previous 2 tests pass
Plant - Scales, Weighing Accuracy			
Monthly	NRMCA QC 3		Stop plant ops, repair, recalibrate
Plant - Batching and Recording Accuracy			

TABLE 17			
TESTING AND INSPECTION REQUIREMENTS			
Frequency	Test Method	Control Limit	Corrective Action
Weekly	Record/Report	Record required/recorded/actual batch mass	Stop plant ops, repair, recalibrate
Plant - Batch Plant Control			
Every lot	Record/Report		Record type and amount of each material per lot
Plant - Mixer Uniformity - Stationary Mixers			
Every 4 months during paving	COE CRD-C 55	After initial approval, use abbreviated method	Increase mixing time, change batching sequence, reduce batch size to bring into compliance. Retest
Plant - Mixer Uniformity - Truck Mixers			
Every 4 months during paving	ASTM C94/C94M	Random selection of truck.	Increase mixing time, change batching sequence, reduce batch size to bring into compliance. Retest
Concrete Mixture - Air Content			
When test specimens prepared plus 2 random per lot	ASTM C231/C231M sample at point of discharge within the paving lane	Individual test control chart: Warning plus or minus 1.0	Adjust AEA, retest
		Individual test control chart: Action plus or minus 1.5	Halt operations, repair, retest
		Range between 2 consecutive tests: Warning plus 2.0	Recalibrate AEA dispenser
		Range between 2 consecutive tests: Action plus 3.0	Halt operations, repair, retest
Concrete Mixture - Unit Weight and Yield			

TABLE 17			
TESTING AND INSPECTION REQUIREMENTS			
Frequency	Test Method	Control Limit	Corrective Action
Same as Air Content	ASTM C138/C138M sample at point of discharge within the paving lane	Individual test basis: Warning Yield minus 0 or plus 1 percent	Check batching tolerances
		Individual test basis: Action Yield minus 0 or plus 5 percent	Halt operations
Concrete Mixture - Slump			
When test specimens prepared plus 4 random per lot	ASTM C143/C143M sample at point of discharge within the paving lane	Individual test control chart: Upper Warning slipform minus 13 mm 1/2 inch below max fixed form 37 mm 1.5 inches hand placement 64 mm 2.5 inches	Adjust batch masses within max W/C ratio
		Individual test control chart: Upper Action at maximum allowable slump	Stop operations, adjust, retest
		Range between each consecutive test: 38 mm 1-1/2 inches	Stop operations, repair, retest
Concrete Mixture - Temperature			
When test specimens prepared	ASTM C1064/C1064M sample at point of discharge within the paving lane	See paragraph WEATHER LIMITATIONS	
Concrete Mixture - Strength			
8 per lot	ASTM C31/C31M sample at point of discharge within the paving lane	See paragraph CONCRETE STRENGTH TESTING for CQC Perform fabrication of strength specimens and initial cure outside the paving lane and within 300 m 1,000 feet of the sampling point.	
Paving - Inspection Before Paving			

TABLE 17			
TESTING AND INSPECTION REQUIREMENTS			
Frequency	Test Method	Control Limit	Corrective Action
Prior to each paving operation	Report	Inspect underlying materials, construction joint faces, forms, reinforcing, dowels, and embedded items	
Paving - Inspection During Paving			
During paving operation		Monitor and control paving operation, including placement, consolidation, finishing, texturing, curing, and joint sawing.	
Paving - Vibrators			
Weekly during paving	COE CRD-C 521	Test frequency (in concrete), and amplitude (in air), average measurement at tip and head.	Repair or replace defective vibrators.
Moist Curing			
2 per lot, min 4 per day	Visual		Repair defects, extend curing by 1 day
Membrane Compound Curing			
Daily	Visual	Calculate coverage based on quantity/area	Respray areas where coverage defective. Recalibrate equipment
Cold Weather Protection			

TABLE 17			
TESTING AND INSPECTION REQUIREMENTS			
Frequency	Test Method	Control Limit	Corrective Action
Once per day	Visual		Repair defects, report conditions to COR

3.12.3 Control Charts

Maintain linear control charts for fine and coarse aggregate gradation, combined gradation coarseness factor/workability factor, slump, air content, unit weight, yeld, and 7 and 14 day flexural strengths.

Post the control charts as directed and maintain current at all times. Identify the following on the control charts: the project number, the test parameter being plotted, the individual sample numbers, the Warning and Action Limits listed in Table 17 applicable to the test parameter being plotted, and the test results. Use the control charts as part of the process control system for identifying trends so that potential problems can be corrected before they occur. Make decisions concerning mix modifications based on analysis of the results provided in the control charts.

3.12.4 Concrete Strength Testing for CQC

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NOTE: If paragraph FLEXURAL STRENGTH AND THICKNESS is based on 28-day flexural strength for acceptance, modify this subparagraph to match it. The first option "Cylinders/Beams" includes items a through g; the second option "Beams" includes listing a through f.
****

Perform Contractor Quality Control operations for concrete strength consisting of the following steps:

[a. Take samples for strength tests at the paving site. Fabricate and cure test cylinders in accordance with ASTM C31/C31M; test them in accordance with ASTM C39/C39M.

b. Fabricate and cure 2 test cylinders per sublot from the same batch or truckload and at the same time acceptance cylinders are fabricated and test them for compressive strength at 7-day age.

c. Average all 8 compressive tests per lot. Convert this average 7-day compressive strength per lot to equivalent [28] [90]-day flexural strength using the Correlation Ratio determined during mixture proportioning studies.

d. Compare the equivalent [28] [90]-day flexural strength from the conversion to the required average CQC flexural strength, Ra.

e. If the equivalent average [28][90]-day strength for the lot is below the required average CQC flexural strength, Ra, by 138 kPa 20 psi flexural strength or more, at any time, adjust the mixture to increase the strength, as approved.

f. Fabricate and cure two beams for every 1500 cubic meters 2000 cubic yards of concrete placed. Fabricate and cure in accordance with ASTM C31/C31M; test at 14-days of age in accordance with ASTM C78/C78M. Use the flexural strength results to verify the cylinder-beam acceptance correlation ratio.

g. Maintain up-to-date control charts for strength, showing the 7-day CQC compressive strength, the 14-day compressive strength (from acceptance tests) and the [28] [90]-day equivalent flexural strength of each of these for each lot.]

[a. Take samples for strength tests at the paving site. Fabricate and cure test beams in accordance with ASTM C31/C31M; test them in accordance with ASTM C78/C78M.

b. Fabricate and cure 2 test beams per sublot from the same batch or truckload and at the same time acceptance beams are fabricated and test them for flexural strength at 7-day age.

c. Average all 8 flexural tests per lot. Convert this average 7-day flexural strength per lot to equivalent [28] [90]-day flexural strength using the Correlation Ratio determined during mixture proportioning studies.

d. Compare the equivalent [28] [90]-day flexural strength from the conversion to the required average CQC flexural strength, Ra.

e. If the equivalent average [28] [90]-day strength for the lot is below the required average CQC flexural strength, Ra, by 490 kPa 69 psi flexural strength or more, at any time, adjust the mixture to increase the strength, as approved.

f. Maintain up-to-date control charts for strength, showing the 7-day CQC flexural strength, the Ratio of the 14-day flexural strength to the [28] [90]-day flexural strength (from acceptance tests), and the [28] [90]-day flexural strength (from acceptance tests) of each of these for each lot.]

3.12.5 Reports

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NOTE: SSelect UFGS Section 01 45 00 for Army, Air Force, and Navy Projects, and 01 45 00.00 40 for NASA projects. Delete the others.
****

Report all results of tests or inspections conducted as they are completed and in writing daily. Post updated control charts and identify accepted paving lots on the detailed paving sequence paving plan covering the entire period from the start of paving through the current week. These requirements do not relieve the obligation to report failures immediately as required in preceding paragraphs and Section [01 45 00][01 45 00.00 40] QUALITY CONTROL. Confirm reports of failures and the corrective action taken in writing in the daily Quality Control reports and within each respective Paving Lot Report. Compile, reduce, analyze and compute pay adjustment factors for all associated test data collected on each paving lot.

At a minimum, include a narrative in each Paving Lot Report addressing success, failures, and process control changes necessary to meet specified tolerances. Identify subject paving lot on the detailed paving sequence plan and label lots and sublots and their stationing. Provide a summary of payment adjustment factors and pass/fail test for each paving lot constructed. Submit complete and comprehensive Paving Lot Reports for the test section and production paving within 16 days after the completion of the placement. Do not place adjacent or contiguous lane/lot prior to receiving approval for the placed pavement. Organize each Paving Lot Report by the following specific items. The list below is not all inclusive. Add tests and inspections as appropriate for each specific paving lot constructed.

a. Underlying material test results reference to previous submittal numbers.
b. Batch Plant stockpile management and constituent tolerances.
c. Batching and Paving Equipment Issues.
d. Reinforcing, embeds and block-outs.
e. Actual Conditions, and Protection Means: Rain, Cold, Hot and/or windy conditions including evaporation rates, high/low ambient temperature.
f. PCC Plastic Mixture Properties.
g. Batch tickets. Provide legible copies.
h. Strength specimens initial cure: location, temperatures.
i. Aggregate gradation test results.
j. Finishing: cutting straight-edge, automatic longitudinal float, edging tool, minimal hand work and excess paste.
k. Texturing operation.
l. Curing operation: equipment calibration, wet cure, membrane cure or both.
m. Initial saw cutting (early entry or wet diamond, flushing and vacuuming, backer rod installation and reapplication of curing compound).
n. Dowel installation and alignment results .
o. Surface Smoothness in both longitudinal and transverse directions (if diamond grinding occurs, retest and include results).
p. Edge Slump (excessive, lost and rebuilt edge).
q. Joint Face Deformation (cutting or diamond grinding).
r. Plan Grade: table providing x, y, and elevation values versus design values.
s. Strength: beam/cylinder strength results (with updated correlation ratios and control chart).
t. Evaluation of cores.
u. Post-Production Pavement Protection Measures: protection and traffic control.
v. Fixed Forms (as applicable).

-- End of Section --