Item 341M Municipal Dense-Graded Hot-Mix Asphalt

1. DESCRIPTION

Construct a hot-mix asphalt (HMA) pavement layer composed of a compacted, dense-graded mixture of aggregate, asphalt binder, and additives mixed hot in a mixing plant.

Furnish uncontaminated materials of uniform quality that meet the requirements of the plans and specifications.

2. MATERIALS

Notify the Engineer of all material sources and before changing any material source or formulation. The Engineer will verify that the specification requirements are met and document all material source changes when the Contractor makes a source or formulation change. The Engineer may sample and test project materials anytime during the project to verify specification compliance.

Substitution: An TxDOT approved existing dense graded (341/3076) or Superpave (344/3077) mix design is considered an equal or better substitution and may be substituted for this item.

2.1 **Aggregate**. Furnish aggregates from sources that conform to the requirements shown in Table 1 and this Section. Aggregate requirements in this Section, including those shown in Table 1, may be modified or eliminated when shown on the plans. Additional aggregate requirements may be specified when shown on the plans. Provide aggregate stockpiles that meet the definitions in this Section for coarse, intermediate, or fine aggregate. Aggregate from reclaimed asphalt pavement (RAP) is not required to meet Table 1 requirements unless otherwise shown on the plans. Supply aggregates that meet the definitions in Tex-100-E for crushed gravel or crushed stone. The Engineer will designate the plant or the quarry as the sampling location. Provide samples from materials produced for the project. The Engineer will establish the Surface Aggregate Classification (SAC) and perform Los Angeles abrasion, magnesium sulfate soundness, and Micro-Deval tests. Perform all other aggregate quality tests shown in Table 1. Document all test results in the mixture design report. The Engineer may perform tests on independent or split samples to verify Contractor test results. Stockpile aggregates for each source and type separately. Determine aggregate gradations for mixture design and production testing based on the washed sieve analysis in accordance with Tex-200-F, Part II.

2.1.0. **Coarse Aggregate**. Coarse aggregate stockpiles must have no more than 20% material passing the No. 8 sieve. Aggregates from sources listed in the TxDOT's Department's *Bituminous Rated Source Quality Catalog* (BRSQC) are preapproved for use. Use only the rated values for HMA listed in the BRSQC. Rated values for surface treatment (ST) do not apply to coarse aggregate sources used in HMA.

For sources not listed in the TxDOT's BRSQC:

- build an individual stockpile for each material;
- test the stockpile for specification compliance;
- use only when tested and approved; and
- once approved, do not add additional material to the stockpile unless otherwise allowed by the Engineer.

Provide coarse aggregate with at least the minimum SAC shown on the plans. SAC requirements apply only to aggregates used on the surface of travel lanes, unless otherwise shown on the plans. The SAC for sources in the TxDOT's *Aggregate Quality Monitoring Program* (AQMP) (Tex-499-A) is listed in the BRSQC.

2.1.0.1. **Blending Class A and Class B Aggregates**. Class B aggregate meeting all other requirements shown in Table 1 may be blended with a Class A aggregate to meet requirements for Class A materials, unless otherwise shown on the plans. When blending Class A and Class B aggregates to meet a Class A requirement, ensure that at least 50% by weight, or volume if required, of the material retained on the No. 4 sieve comes from the Class A aggregate source, unless otherwise shown on the plans. Blend by volume if the bulk specific gravities of the Class A and Class B aggregates differ by more than 0.300. Coarse aggregate from RAP will be considered as Class B aggregate for blending purposes.

The Engineer may perform tests anytime during production, when the Contractor blends Class A and Class B aggregates to meet a Class A requirement. The Engineer will use TxDOT's mix design template, when electing to verify conformance, to calculate the percent of Class A aggregate retained on the No. 4 sieve by inputting the bin percentages shown from readouts in the control room at the time of production and stockpile gradations measured at the time of production. The Engineer may determine the gradations based on either washed or dry sieve analysis from samples obtained from individual aggregate cold feed bins or aggregate stockpiles. The Engineer may perform spot checks to verify the percent of Class A aggregate retained on the No. 4 sieve. The Engineer will use the gradations supplied by the Contractor in the mixture design report as an input for the template. A failing spot check will require confirmation with a stockpile gradation determined by the Engineer.

2.1.0.2. **Micro-Deval Abrasion**. The Engineer may perform at least one Micro-Deval abrasion test in accordance with Tex-461-A for each coarse aggregate source used in the mixture design that has a rated source soundness magnesium (RSSM) loss value greater than 15 as listed in the BRSQC. The Engineer may perform testing before the start of production and may perform additional testing anytime during production. The Engineer may obtain the coarse aggregate samples from each coarse aggregate source or may require the Contractor to obtain the samples. The Engineer may waive all Micro-Deval testing based on a satisfactory test history of the same aggregate source.

The Engineer will estimate the magnesium sulfate soundness loss for each coarse aggregate source, when tested, using the following formula:

$$Mg_{est.} = (RSSM)(MD_{act.}/RSMD)$$

where:
$Mg_{est.}$ = magnesium sulfate soundness loss
$RSSM$ = rated source soundness magnesium
$MD_{act.}$ = actual Micro-Deval percent loss
$RSMD$ = rated source Micro-Deval

When the estimated magnesium sulfate soundness loss is greater than the maximum magnesium sulfate soundness loss specified, the coarse aggregate source will not be allowed for use unless otherwise approved.

2.1.1. **Intermediate Aggregate**. Aggregates not meeting the definition of coarse or fine aggregate will be defined as intermediate aggregate. Supply intermediate aggregates, when used, that are free of organic impurities. Supply intermediate aggregate from coarse aggregate sources, when used, that meet the requirements shown in Table 1, unless otherwise approved.

Test the stockpile if 10% or more of the stockpile is retained on the No. 4 sieve, and verify that it meets the requirements in Table 1 for crushed face count (Tex-460-A) and flat and elongated particles (Tex-280-F).

2.1.2. **Fine Aggregate**. Fine aggregates consist of manufactured sands, screenings, and field sands. Fine aggregate stockpiles must meet the fine aggregate properties in accordance with Table 1 and the gradation requirements in accordance with Table 2. Supply fine aggregates that are free of organic impurities. The Engineer may test the fine aggregate in accordance with Tex-408-A to verify the material is free of organic

impurities. Unless otherwise shown on the plans, at most 10% of the total aggregate may be field sand or other uncrushed fine aggregate. Use fine aggregate, except field sand, from coarse aggregate sources that meet the requirements shown in Table 1, unless otherwise approved.

Test the stockpile if 10% or more of the stockpile is retained on the No. 4 sieve and verify that it meets the requirements in Table 1 for crushed face count (Tex-460-A) and flat and elongated particles (Tex-280-F).

Table 1
Aggregate Quality Requirements

Property	Test Method	Requirement
Coarse Aggregate		
Surface Aggregate Classification SAC	Tex-499-A (AQMP)	As shown on the plans
Deleterious material, %, Max	Tex-217-F, Part I	1.5
Decantation, %, Max	Tex-217-F, Part II	1.5
Micro-Deval abrasion, %	Tex-461-A	Note [1]
Los Angeles abrasion, %, Max	Tex-410-A	40
Magnesium sulfate soundness, 5 cycles, %, Max	Tex-411-A	30
Crushed face count,[2] %, Min	Tex-460-A, Part I	85
Flat and elongated particles @ 5:1, %, Max	Tex-280-F	10
Fine Aggregate		
Linear shrinkage, %, Max	Tex-107-E	3
Sand equivalent, %, Min	Tex-203-F	45[3]
Organic impurities	Tex-408-A	Note [4]

1. Used to estimate the magnesium sulfate soundness loss in accordance with Section 341.2.1.1.2., "Micro-Deval Abrasion."
2. Only applies to crushed gravel.
3. The Engineer may perform Tex-252-F on fine aggregates not meeting this minimum requirement. Fine aggregates with a methylene blue value of 10.0 mg/g or less may be used.
4. Optional test.

Table 2
Gradation Requirements for Fine Aggregate

Sieve Size	% Passing by Wt. Or Volume
3/8"	100
#8	70–100
#200	0–30

2.2. **Mineral Filler**. Mineral filler consists of finely divided mineral matter such as agricultural lime, crusher fines, hydrated lime, or fly ash. Mineral filler is allowed unless otherwise shown on the plans. Use no more than 2% hydrated lime or fly ash, unless otherwise shown on the plans. Use no more than 1% hydrated lime if a substitute binder is used, unless otherwise shown on the plans or allowed. Test all mineral fillers except hydrated lime and fly ash in accordance with Tex-107-E to ensure specification compliance. The plans may require or disallow specific mineral fillers. Provide mineral filler, when used, that:

- is dry enough, free-flowing, and free of clumps and foreign matter as determined by the Engineer;
- does not exceed 3% linear shrinkage when tested in accordance with Tex-107-E; and
- meets the gradation requirements shown in Table 3, unless otherwise shown on the plans.

Table 3
Gradation Requirements for Mineral Filler

Sieve Size	% Passing by Wt. or Volume
#8	100
#200	55–100

2.3. **Baghouse Fines**. Fines collected by the baghouse or other dust-collecting equipment may be reintroduced into the mixing drum.

2.4. **Asphalt Binder**. Furnish the type and grade of performance-graded (PG) asphalt binder shown on the plans that meets the requirements of Item 300, "Asphalts, Oils, and Emulsions."

2.5. **Tack Coat**. Furnish CSS-1H, SS-1H, EBL, or a PG binder with a minimum high-temperature grade of PG 58 for tack coat binder in accordance with Item 300. Specialized tack coat materials on TxDOT's Material Producer List (MPL) for *Tracking Resistant Asphalt Interlayer* (TRAIL) will be allowed or required when shown on the plans. Do not dilute emulsified asphalt at the terminal, in the field, or at any other location before use, unless required in conformance with the manufacturer's recommendation for approved TRAIL products on the MPL.

2.6. **Additives**. Use the type of additive specified when shown on the plans. Use the rate of additive specified in conformance with the manufacturer's recommendation. Additives that facilitate mixing and compaction, or improve the quality of the mixture are allowed when approved. Provide the Engineer with documentation such as the bill of lading showing the quantity of additives used in the project unless otherwise directed.

2.6.0. **Lime and Liquid Antistripping Agent**. Lime or liquid antistripping agent is required when shown on the plans. When lime or a liquid antistripping agent is used, add in accordance with Item 301, "Asphalt Antistripping Agents." Do not add lime directly into the mixing drum of any plant where lime is removed through the exhaust stream unless the plant has a baghouse or dust collection system that reintroduces the lime into the drum.

2.6.1. **Warm-Mix Asphalt (WMA)**. WMA is defined as HMA that is produced within a target temperature discharge range of 215°F and 275°F using approved WMA additives or processes from the MPL.

WMA is allowed for use on all projects and is required when shown on the plans. When WMA is required, the maximum placement or target discharge temperature for WMA will be set at a value at or below 275°F.

MPL-approved WMA additives or processes may be used to facilitate mixing and compaction of HMA produced at target discharge temperatures above 275°F; however, such mixtures will not be defined as WMA.

2.6.2. **Compaction Aid**. Compaction aid is defined as a MPL-approved chemical warm-mix additive, denoted as "chemical additive" on the MPL, that is used to facilitate mixing and compaction of HMA at a discharge temperature greater than 275°F.

Compaction aid is allowed for use on all projects. Compaction aid is required when shown on the plans or as required in Section 341.4.7.1., "Weather Conditions."

Warm-mix foaming processes, denoted as "foaming process" on the MPL, may be used to facilitate mixing and compaction of HMA at target discharge temperatures greater than 275°F; however, warm-mix foaming processes are not defined as a compaction aid.

2.7. **Recycled Materials**. Use of RAP is permitted unless otherwise shown on the plans. Do not exceed the maximum allowable percentages of RAP in accordance with Table 4. The allowable percentages in accordance with Table 4 may be decreased or increased when shown on the plans. Determine the asphalt

binder content and gradation of the RAP stockpiles for mixture design purposes in accordance with Tex-236-F, Part I. The Engineer may verify the asphalt binder content of the stockpiles anytime during production. Perform other tests on RAP when shown on the plans. Use a separate cold feed bin for each stockpile of RAP during HMA production.

Surface, intermediate, and base mixes referenced in Table 4 and Table 5 are defined as follows, unless otherwise shown on the plans.

- **Surface**. The final HMA lift placed at the top of the pavement structure.
- **Intermediate**. Mixtures placed below an HMA surface mix and less than or equal to 8.0 in. below the riding surface.
- **Base**. Mixtures placed greater than 8.0 in. below the riding surface. Unless otherwise shown on the plans, mixtures used for bond breaker are defined as base mixtures.

2.7.0. **RAP**. RAP is salvaged, milled, pulverized, broken, or crushed asphalt pavement. Fractionated RAP is defined as a stockpile that contains RAP material with at least 95.0% passing the 1/2-in. sieve, before burning in the ignition oven, unless otherwise approved. The Engineer may allow the Contractor to use an alternate to the 1/2-in. screen to fractionate the RAP.

Use of Contractor-owned RAP, including HMA plant waste, is permitted unless otherwise shown on the plans. Perform any necessary tests to ensure RAP is appropriate for use. The Contractor will retain ownership of RAP generated on the project unless otherwise shown on the plans.

Do not use RAP contaminated with dirt or other objectionable materials. Do not use RAP if the decantation value exceeds 5% and the plasticity index is greater than 8. Test the stockpiled RAP for decantation in accordance with Tex-406-A, Part I. Determine the plasticity index in accordance with Tex-106-E if the decantation value exceeds 5%. The decantation and plasticity index requirements do not apply to RAP samples with asphalt removed by extraction or ignition.

Remove unused Contractor-owned RAP material from the project site upon completion of the project.

Table 4
Max Allowable Amounts of Fractionated RAP

Max Allowable Fractionated RAP (%)		
Surface	**Intermediate**	**Base**
20.0	30.0	35.0

2.8. **Substitute Binders**. No binder substitution will be allowed when shown on the plans. The Contractor may use a substitute PG binder shown in Table 5 instead of the PG binder originally specified, if using recycled materials, and if the substitute PG binder and mixture made with the substitute PG binder meet the following.

- The substitute binder meets the specification requirements for the substitute binder grade in accordance with Section 300.2.10., "Performance-Graded (PG) Binders."
- The mixture has less than 10.0 mm of rutting on the Hamburg wheel test (Tex-242-F) after the number of passes required for the originally specified binder. Use of substitute PG binders may be allowed only at the discretion of the Engineer if the Hamburg wheel test results are between 10.0 mm and 12.5 mm.

Table 5
Allowable PG Binders

Originally Specified PG Binder	Allowable Substitute PG Binder for Surface Mixes	Allowable Substitute PG Binder for Intermediate and Base Mixes
76-22	70-22	70-22
70-22	N/A	64-22
64-22	N/A	N/A
76-28	70-28	70-28
70-28	N/A	64-28
64-28	N/A	N/A

3. EQUIPMENT

Provide required or necessary equipment in accordance with TxDOT Item 320, "Equipment for Asphalt Concrete Pavement."

4. CONSTRUCTION

Produce, haul, place, and compact the specified paving mixture. In addition to tests required in accordance with the Specification, the Contractor may perform other QC tests as necessary. Anytime during the project, the Engineer may perform production and placement tests as necessary. Schedule and participate in a mandatory pre-paving meeting with the Engineer on or before the first day of paving unless otherwise shown on the plans.

4.1. **Certification**. Personnel certified by the TxDOT-approved HMA certification program (www.TXHMAC.org) must conduct all mixture designs, sampling, and testing in accordance with Table 6. Supply the Engineer with a list of certified personnel and copies of their current certificates before beginning production and when personnel changes are made. Provide a mixture design developed and signed by a Level 2-certified specialist. Provide Level 1A-certified specialists at the plant during production operations. Provide Level 1B-certified specialists to conduct placement tests. Provide Level AGG101-certified specialists for aggregate testing.

Table 6
Test Methods, Test Responsibility, and Min Certification Levels

Test Description	Test Method	Contractor	Engineer	Level[1]
Aggregate and Recycled Material Testing				
Sampling	Tex-221-F	✓	✓	1A/AGG101
Dry sieve	Tex-200-F, Part I	✓	✓	1A/AGG101
Washed sieve	Tex-200-F, Part II	✓	✓	1A/AGG101
Deleterious material	Tex-217-F, Part I and Part III	✓	✓	AGG101
Decantation	Tex-217-F, Part II	✓	✓	AGG101
Los Angeles abrasion	Tex-410-A		✓	Engineer
Magnesium sulfate soundness	Tex-411-A		✓	Engineer
Micro-Deval abrasion	Tex-461-A		✓	AGG101
Crushed face count	Tex-460-A	✓	✓	AGG101
Flat and elongated particles	Tex-280-F	✓	✓	AGG101
Linear shrinkage	Tex-107-E	✓	✓	AGG101
Sand equivalent	Tex-203-F	✓	✓	AGG101
Bulk-specific gravity	Tex-201-F	✓	✓	AGG101

Test Description	Test Method	Contractor	Engineer	Level[1]
Asphalt Binder and Tack Coat Sampling				
Asphalt binder sampling	Tex-500-C, Part II	✓	✓	1A/1B
Tack coat sampling	Tex-500-C, Part III	✓	✓	1A/1B
Mix Design and Verification				
Design and job-mix formula (JMF) changes	Tex-204-F	✓	✓	2
Mixing	Tex-205-F	✓	✓	2
Molding (Superpave gyratory compactor [SGC])	Tex-241-F	✓	✓	1A
Laboratory-molded density	Tex-207-F, Part I and Part VI	✓	✓	1A
Rice gravity	Tex-227-F, Part II	✓	✓	1A
Indirect tensile strength	Tex-226-F	✓	✓	1A
Hamburg wheel test	Tex-242-F	✓	✓	1A
Production Testing				
Selecting production random numbers	Tex-225-F, Part I		✓	1A
Mixture sampling	Tex-222-F	✓	✓	1A/1B
Molding (SGC)	Tex-241-F	✓	✓	1A
Laboratory-molded density	Tex-207-F, Part I and Part VI	✓	✓	1A
Rice gravity	Tex-227-F, Part II	✓	✓	1A
Gradation and asphalt binder content[2]	Tex-236-F, Part I	✓	✓	1A
Control charts	Tex-233-F	✓	✓	1A
Moisture content	Tex-212-F, Part II	✓	✓	1A/AGG101
Hamburg wheel test	Tex-242-F	✓	✓	1A
Micro-Deval abrasion	Tex-461-A		✓	AGG101
Abson recovery	Tex-211-F		✓	Engineer
Placement Testing				
Selecting placement random numbers	Tex-225-F, Part II		✓	1B
Trimming roadway cores	Tex-251-F, Part I and Part II	✓	✓	1A/1B
In-place air voids	Tex-207-F, Part I and Part VI	✓	✓	1A
In-place density (gauge method)	Tex-207-F, Part III	✓		1B
Establish rolling pattern	Tex-207-F, Part IV	✓		1B
Control charts	Tex-233-F	✓	✓	1A
Ride quality measurement	Tex-1001-S	✓	✓	Note[2]

1. Levels 1A, 1B, AGG101, and 2 are certification levels provided by the Hot Mix Asphalt Center certification program. www.TXHMAC.org
2. Profiler and operator are required to be certified at the Texas A&M Transportation Institute facility when surface test Type B is specified.

4.2. **Reporting and Responsibilities**. Use TxDOT-provided or approved templates to record and calculate all test data, including mixture design, production and placement QC and QA, control charts, The Engineer and the Contractor will provide any available test results to the other party when requested. The maximum allowable time for the Contractor and Engineer to exchange test data is as shown in Table 7, unless otherwise approved. The Engineer and the Contractor will immediately report to the other party any test result that requires suspension of production or placement, or that fails to meet the specification requirements. Record and electronically submit all test results and pertinent information on TxDOT-provided templates.

Subsequent sublots placed after test results are available to the Contractor, which require suspension of operations, may be considered unauthorized work. Unauthorized work will be accepted or rejected at the discretion of the Engineer in accordance with Article 5.3., "Conformity with Plans, Specifications, and Special Provisions."

Table 7
Reporting Schedule

Description	Reported By	Reported To	To Be Reported Within
Quality Control			
Gradation	Contractor	Engineer	1 working day of completion of the lot
Asphalt binder content			
Laboratory-molded density			
In-place air voids			
Quality Assurance			
Gradation	Engineer	Contractor	1 working day of completion of the lot
Asphalt binder content			
Laboratory-molded density			
In-place air voids			
Hamburg wheel test[1]			

1. Optional Test.

Use the procedures described in Tex-233-F to plot the results of all QC and QA testing. Update the control charts as soon as test results for each sublot become available. Make the control charts readily accessible at the field laboratory. The Engineer may suspend production for failure to update control charts.

4.3 Quality Control Plan (QCP). Develop and follow the QCP in detail. Obtain approval for changes to the QCP made during the project. The Engineer may suspend operations if the Contractor fails to comply with the QCP.

Submit a written QCP before the mandatory pre-paving meeting. Receive approval of the QCP before beginning production. Include the following items in the QCP.

4.3.1 Project Personnel. For project personnel, include:

- a list of individuals responsible for QC with authority to take corrective action,
- current contact information for each individual listed, and
- current copies of certification documents for individuals performing specified QC functions.

4.3.2 Material Delivery and Storage. For material delivery and storage, include:

- the sequence of material processing, delivery, and minimum quantities to assure continuous plant operations;
- aggregate stockpiling procedures to avoid contamination and segregation;
- frequency, type, and timing of aggregate stockpile testing to assure conformance with material requirements before mixture production; and
- procedure for monitoring the quality and variability of asphalt binder.

4.3.3 Production. For production, include:

- loader operation procedures to avoid contamination in cold bins;
- procedures for calibrating and controlling cold feeds;

- procedures to eliminate debris or oversized material;
- procedures for adding and verifying rates of each applicable mixture component (e.g., aggregate, asphalt binder, RAP, lime, liquid antistrip, compaction aid, foaming process, and WMA);
- procedures for reporting job control test results; and
- procedures to avoid segregation and drain-down in the silo.

4.3.4 Loading and Transporting. For loading and transporting, include:

- type and application method for release agents, and
- truck-loading procedures to avoid segregation.

4.3.5 Placement and Compaction. For placement and compaction, include:

- proposed agenda for mandatory pre-paving meeting, including date and location;
- proposed paving plan (e.g., production rate, paving widths, joint offsets, and lift thicknesses);
- type and application method for release agents in the paver and on rollers, shovels, lutes, and other utensils;
- procedures for the transfer of mixture into the paver while avoiding segregation and preventing material spillage;
- process to balance production, delivery, paving, and compaction to achieve continuous placement operations and good ride quality;
- paver operations (e.g., speed, operation of wings, and height of mixture in auger chamber) to avoid segregation and other surface irregularities; and
- procedures to construct quality longitudinal and transverse joints.

4.4 Mixture Design.

4.4.1. Design Requirements. Use the dense-graded design procedure provided in Tex-204-F, unless otherwise shown on the plans. Design the mixture to meet the requirements shown in Tables 1, 2, 3, 4, 5, 8, 9, and 10.

Design the mixture using an SGC, and 50 gyrations as the design number of gyrations (Ndesign). Use a target laboratory-molded density of 96.0% to design the mixture; however, adjustments can be made to the Ndesign value as shown in Table 9. The Ndesign level may be reduced to at least 35 gyrations at the Contractor's discretion.

Provide the Engineer with a mixture design report that meets the specifications. Include the following items in the report:

- the combined aggregate gradation, source, specific gravity, and percent of each material used;
- the binder source and optimum design asphalt content;
- asphalt binder content and aggregate gradation of RAP stockpiles;
- the Ndesign level used on the SGC);
- results of all applicable tests;
- the mixing and molding temperatures;
- the signature of the Level 2 person or persons who performed the design;
- the date the mixture design was performed; and
- a unique identification number for the mixture design.

Table 8
Master Gradation Limits (% Passing by Wt. or Volume) and Void in Mineral Aggregate (VMA) Requirements

Sieve Size	DG-B Fine Base	DG-C Coarse Surface	DG-D Fine Surface	DG-F Fine Mixture
2"	–	–	–	–
1-1/2"	100.0[1]	–	–	–
1"	98.0–100.0	100.0[1]	–	–
3/4"	84.0–98.0	95.0–100.0	100.0[1]	–
1/2"	–	–	98.0–100.0	100.0[1]
3/8"	60.0–80.0	70.0–85.0	85.0–100.0	98.0–100.0
#4	40.0–60.0	43.0–63.0	50.0–70.0	70.0–90.0
#8	29.0–43.0	32.0–44.0	35.0–46.0	38.0–48.0
#30	13.0–28.0	14.0–28.0	15.0–29.0	12.0–27.0
#50	6.0–20.0	7.0–21.0	7.0–20.0	6.0–19.0
#200	2.0–7.0	2.0–7.0	2.0–7.0	2.0–7.0
Design VMA), % Min				
–	13.0	14.0	15.0	16.0
Production (Plant-Produced) VMA), % Min				
–	12.5	13.5	14.5	15.5

1. Defined as Max sieve size. No tolerance allowed.

Table 9
Laboratory Mixture Design Properties

Mixture Property	Test Method	Requirement
Target laboratory-molded density, %	Tex-207-F	96.0
Design gyrations (Ndesign)	Tex-241-F	50[1]
Indirect tensile strength (dry), psi	Tex-226-F	85–200[2]
		–

1. Adjust within a range of 35–100 gyrations when shown on the plans, in accordance with the specification, or when mutually agreed between the Engineer and Contractor.
2. The Engineer may allow the indirect tensile test strength to exceed 200 psi if the corresponding Hamburg wheel rut depth is >2.5 mm and <12.5 mm.

Table 10
Hamburg Wheel Test Requirements

High-Temperature Binder Grade	Test Method	Min # of Passes at 12.5-mm[1,2] Rut Depth, Tested at 50°C
PG 64 or lower	Tex-242-F	5,000
PG 70		10,000
PG 76 or higher		20,000

1. The Hamburg wheel test will have a minimum rut depth of 2.5 mm.
2. The Engineer may elect to use the Contractor's Hamburg Test Results

4.4.2 **Job-Mix Formula Approval**. The JMF is the combined aggregate gradation, Ndesign level, and target asphalt percentage used to establish target values for hot-mix production. JMF1 is the original laboratory mixture design used to produce the trial batch. When WMA is used, JMF1 may be designed and submitted to the Engineer without including the WMA additive, foaming process, or compaction aid. When WMA or a compaction aid is used, document the additive or process used and recommended rate in the JMF1 submittal. The Engineer and the Contractor will verify JMF1 based on plant-produced mixture from the trial batch, unless otherwise approved. The Engineer may accept an existing mixture design previously used on a project and may waive the trial batch to verify JMF1.

4.4.1.1. Contractor's Responsibilities.

4.4.1.1.1. Providing Superpave Gyratory Compactor. Provide an SGC in accordance with Item 504, "Field Office and Laboratory," and make the SGC available to the Engineer for use in molding production samples.

4.4.1.1.2. Gyratory Compactor Correlation Factors. Use Tex-206-F, Part II, to perform a gyratory compactor correlation when the Engineer uses a different SGC. Apply the correlation factor to all subsequent production test results.

4.4.1.1.3. Ignition Oven Correction Factors. Notify the Engineer before performing Tex-236-F, Part II. Allow the Engineer to witness the mixing of ignition oven correction factor sample. Determine the aggregate and asphalt correction factors from the ignition oven in accordance with Tex-236-F, Part II.

Correction factors established from a previously approved mixture design may be used for the current mixture design if the mixture design and ignition oven are the same as previously used, unless otherwise directed. Correction factors must be performed every 12 mo.

4.4.1.1.4. Trial Batch Produce a trial batch (JMF2) as necessary to obtain a mixture that meets the specification requirements. The Engineer may accept test results from recent production of the same mixture instead of a new trial batch.

4.4.1.1.5. Trial Batch/JMF2 Sampling. After the Engineer grants full approval of JMF1, Obtain a representative sample of the trial batch/JMF2 and split it into three equal portions in accordance with Tex-222-F. Label these portions as "Contractor," "Engineer," and "Referee." Deliver samples to the appropriate laboratory as directed. Referee testing process shall be agreed to by Contractor and Engineer. Evaluate the trial batch test results, determine the optimum mixture proportions, and submit as JMF2 Adjust the asphalt binder content or gradation to achieve the specified target laboratory-molded density. The asphalt binder content established for JMF2 is not required to be within any tolerance of the optimum asphalt binder content established for JMF1; however, mixture produced using JMF2 must meet the VMA requirements for production shown in Table 8. If the optimum asphalt binder content for JMF2 is more than 0.5% lower than the optimum asphalt binder content for JMF1, the Engineer may perform or require the Contractor to perform Tex 226 F on Lot 1 production to confirm the indirect tensile strength does not exceed 200 psi. Verify that JMF2 meets the mixture requirements shown in Table 4 and Table 5.

4.4.1.1.6. Development of JMF2.

4.4.1.1.7. Mixture Production. Use JMF2 to produce Lot 1 in accordance with Section 341.4.9.1.3, "Lot 1 Placement," after receiving approval for JMF2 and a passing Hamburg wheel result on the trial batch from a laboratory listed on the MPL. Once JMF2 is approved, and without receiving the results from the Engineer's Hamburg wheel test on the trial batch, the Contractor may proceed to Lot 1 production at their own risk. The Engineer may elect to use the Contractor's Hamburg results.

4.4.1.1.8. Development of JMF3. Evaluate the test results from Lot 1, determine the optimum mixture proportions, and submit as JMF3 for use in Lot 2.

4.4.1.1.9. JMF Adjustments. If JMF adjustments are necessary to achieve the specified requirements, make the adjustments before beginning a new lot. The adjusted JMF must:

- be provided to the Engineer in writing before the start of a new lot,
- be numbered in sequence to the previous JMF,
- meet the mixture requirements in accordance with Table 4 and Table 5,
- meet the master gradation limits in accordance with Table 8, and
- be within the operational tolerances of JMF2 in accordance with Table 11.

4.4.1.1.10. Requesting Referee Testing. Use referee testing, if needed, in accordance with Section 341.4.9.1., "Referee Testing," to resolve testing differences with the Engineer. Referee testing process shall be agreed to by Contractor and Engineer.

Table 11
Operational Tolerances

Description	Test Method	Allowable Difference Between JMF2 and JMF1 Target[1]	Allowable Difference Between Current JMF and JMF2[2]	Allowable Difference Between Contractor and Engineer[3]
Individual % retained on #8 sieve and larger	Tex-200-F or Tex-236-F	Must be Within Master Gradation Limits in Table 8	±5.0[4]	±5.0
Individual % retained on sieves smaller than #8 and larger than #200			±3.0[4]	±3.0
% passing the #200 sieve			±2.0[4]	±1.6
Asphalt binder content, %	Tex-236-F	±0.5	±0.3	±0.3
Laboratory-molded density, %	Tex-207-F	±1.0	±1.0	±1.0
In-place air voids, %		N/A	N/A	±1.0
Laboratory-molded bulk specific gravity		N/A	N/A	±0.020
VMA, %, Min	Tex-204-F	Note 5	Note[5]	N/A
Theoretical maximum specific (Rice) gravity	Tex-227-F	N/A	N/A	±0.020

1. JMF1 is the approved laboratory mixture design used for producing the trial batch. JMF2 is the approved mixture design developed from the trial batch used to produce Lot 1.
2. Current JMF is JMF3 or higher. JMF3 is the approved mixture design used to produce Lot 2.
3. Contractor will take corrective action to bring test results back within tolerances.
4. When within these tolerances, mixture production gradations may fall outside the master gradation limits; however, the % passing the #200 will be considered out of tolerance when outside the master gradation limits.
5. Verify that Table 8 requirements are met for VMA.

4.4.2. Engineer's Responsibilities.

4.4.2.1.1. Superpave Gyratory Compactor. The Engineer will use a SGC, calibrated in accordance with Tex-241-F, to mold samples for laboratory mixture design verification. For molding trial batch and production specimens, the Engineer will use the Contractor-provided SGC at the field laboratory or provide and use a SGC at an alternate location.

4.5. Production Operations. Perform a new trial batch when the plant or plant location is changed. All source changes for asphalt will require a passing Hamburg wheel test result from a laboratory listed on the MPL. The Contractor may proceed at their own risk with Lot 1 production without the results from the Hamburg wheel test on the trial batch. All aggregate source changes will require a new laboratory mixture design and trial batch. Take corrective action and receive approval to proceed after any production suspension for noncompliance with the specification. Submit a new mix design and perform a new trial batch when the asphalt binder content of any RAP stockpile used in the mix is more than 0.5% higher than the value shown in the mixture design report.

4.5.1. Storage and Heating of Materials. Do not heat the asphalt binder above the temperatures specified in Item 300, or outside the manufacturer's recommended values. Provide the Engineer with daily records of asphalt binder and HMA discharge temperatures (in legible and discernible increments) in accordance with Item 320, unless otherwise directed. Do not store mixture for a period long enough to affect the quality of the mixture, nor in any case longer than 12 hr. unless otherwise approved.

4.5.2. Mixing and Discharge of Materials. Notify the Engineer of the target discharge temperature and produce the mixture within 25°F of the target. Monitor the temperature of the material in the truck before shipping to ensure that it does not exceed the maximum production temperatures shown in Table 12. The Engineer will not pay for or allow placement of any mixture produced above the maximum production temperatures shown in Table 12.

Table 12
Max Production Temperature

High-Temperature Binder Grade[1]	Max Production Temperature (°F)
PG 64	325[2]
PG 70	335[2]
PG 76	345[2]

1. The high-temperature binder grade refers to the high-temperature grade of the virgin asphalt binder used to produce the mixture.
2. The Maximum production temperature of WMA is 275°F. The contractor may elect to run the first few loads warmer than the maximum WMA temp to pre-heat construction equipment.

Produce WMA within the target discharge temperature range of 215–275°F when WMA is required. Take corrective action anytime the discharge temperature of the WMA exceeds the target discharge range. As an exception when running Warm Mix, the contractor may run the first 1-4 loads at normal temperatures to allow the mix to preheat the construction equipment. The Engineer may suspend production operations if the Contractor's corrective action is not successful at controlling the production temperature within the target discharge range. Note that when WMA is produced, it may be necessary to adjust burners to ensure complete combustion such that no burner fuel residue remains in the mixture.

Control the mixing time and temperature so that substantially all moisture is removed from the mixture before discharging from the plant. Determine the moisture content, if requested, by oven-drying in accordance with Tex-212-F, Part II, and verify that the mixture contains no more than 0.2% of moisture by weight. Obtain the sample immediately after discharging the mixture into the truck and perform the test promptly.

4.6. Hauling Operations. Use belly dump, live-bottom, or end dump trucks to haul and transfer mixture. Use other hauling equipment only when allowed.

Clean all truck beds before use to ensure that mixture is not contaminated. Use a release agent listed on the TxDOT Materials Producer List MPL to coat the inside bed of the truck when necessary. Do not use diesel or any release agent not listed on the MPL. Use a solid tarp of watertight construction to cover the load.

4.7. Placement Operations. Collect haul tickets from each load of mixture delivered to the project and provide the Agency's copy to the Engineer approximately every hour, or as directed. Use a handheld thermal camera or infrared thermometer, or probe-type thermometer to measure and record the internal temperature of the mixture as discharged from the truck or material transfer device (MTD) before or as the mix enters the paver. To obtain windrow internal temperature, remove surface asphalt to a depth of at least 6 inches. Measure the mixture temperature at a minimum frequency of one per ten trucks, or as approved. Include an approximate station number or Global Positioning System coordinates of the location where the temperature was taken on each ticket. Ensure the mixture meets the temperature requirements shown in Table 12. Calculate the daily yield and cumulative yield for the specified lift and provide to the Engineer at the end of paving operations for each day unless otherwise directed. The Engineer may suspend production if the Contractor fails to produce and provide haul tickets and yield calculations by the end of paving operations for each day.

Prepare the surface by removing raised pavement markers and objectionable material such as moisture, dirt, sand, leaves, and other loose impediments from the surface before placing mixture. Remove vegetation from pavement edges. Place the mixture to meet the typical section requirements and produce a smooth, finished surface with a uniform appearance and texture. Offset longitudinal joints of successive courses of hot mix by at least 6 in. Place mixture so that longitudinal joints on the surface course coincide within 6 in. of lane lines, are not placed in the wheel path, or will not be covered with pavement markings, or as directed. Ensure that all finished surfaces will drain properly. Place the mixture at the rate or thickness shown on the plans. The Engineer will use the guidelines shown in Table 13 to determine the compacted lift thickness of each layer

when multiple lifts are required.

Table 13
Compacted Lift Thickness and Required Core Height

Mixture Type	Compacted Lift Thickness Guidelines		Min Untrimmed Core Height Eligible for Testing (in.)
	Min (in.)	Max (in.)	
DG-B	2.50	5.00	1.75
DG-C	2.00	4.00	1.50
DG-D	1.50	3.00	1.25
DG-F	1.25	2.50	1.25

4.7.1. Weather Conditions.

4.7.1.1. Pavement Surface. Place mixture when the roadway surface is dry and the roadway surface temperature is at or above the temperatures shown in Table 14 unless otherwise approved or as shown on the plans. Place mixtures only when weather conditions and moisture conditions of the roadway surface are suitable as determined by the Engineer. The Contractor may pave at temperatures 10°F lower than these values when a chemical WMA additive is used as a compaction aid in the mixture, when using WMA, or when using a paving process with equipment that eliminates thermal segregation.

Table 14
Minimum Pavement Surface Temperatures

High-Temperature Binder Grade[1]	Min Pavement Surface Temperatures (°F)	
	Subsurface Layers	Surface Layers
PG 64	45	50
PG 70	55	60
PG 76	60	60

1. The high-temperature binder grade refers to the high-temperature grade of the virgin asphalt binder used to produce the mixture.

4.7.2. Tack Coat.

4.7.2.1. Application. Clean the surface before placing the tack coat. The Engineer will set the rate between 0.04 and 0.10 gal. of residual asphalt per square yard of surface area. Apply a uniform tack coat at the specified rate unless otherwise directed. Apply the tack coat in a uniform manner to avoid streaks and other irregular patterns. Apply the tack coat to all surfaces that will come in contact with the subsequent HMA placement, unless otherwise directed. Apply adequate overlap of the tack coat in the longitudinal direction during placement of the mat to ensure bond of adjacent mats, unless otherwise directed. Allow adequate time for emulsion to break completely before placing any material. Prevent splattering of tack coat when placed adjacent to curb, gutter, and structures. Do not dilute emulsified asphalts at the terminal, in the field, or at any other location before use, unless required in conformance with the manufacturer's recommendation for approved TRAIL product use, or when shown on the plans.

4.7.2.2. Sampling. The Engineer may obtain at least one sample of the tack coat binder per project per source in accordance with Tex-500-C, Part III, and test it to verify compliance with Item 300. The Engineer will notify the Contractor when the sampling will occur and will witness the collection of the immediately before use. For emulsions, the Engineer may test as often as necessary to ensure the residual of the emulsion is greater than or equal to the specification requirement in Item 300.

4.7.3. Lay-Down Operations. Use the placement temperatures shown in Table 15 to establish the minimum placement temperature of the mixture delivered to the paving operation.

Table 15
Minimum Mixture Placement Temperature

High-Temperature Binder Grade[1]	Min Placement Temperature[2,3,4] (°F)
PG 64	260
PG 70	270
PG 76	280

1. The high-temperature binder grade refers to the high-temperature grade of the virgin asphalt binder used to produce the mixture.
2. The mixture temperature must be measured using a handheld thermal camera, probe thermometer, or infrared thermometer immediately before entering MTD or paver.
3. Minimum placement temperatures may be reduced 20°F if using a chemical WMA additive as a compaction aid, MTD with remixing capabilities, or paver hopper insert with remixing capabilities.
4. When using WMA, the minimum placement temperature is 215°F.

4.7.3.1. Windrow Operations. Operate windrow pickup equipment so that when hot mix is placed in windrows, substantially all the mixture deposited on the roadbed is picked up and loaded into the paver.

4.7.3.2. Screed Heaters. Turn off screed heaters to prevent overheating of the mat if the paver stops for more than 5 min.

4.8. Compaction. Compact the pavement uniformly to contain between 3.8% and 8.5% in-place air voids. Take immediate corrective action to bring the operation within 3.8% and 8.5% when the in-place air voids exceed the range of these tolerances. If the in-place air voids are less 2.7% or more than 9.9%, the Engineer may suspend operations or require removal and replacement. The Engineer will allow paving to resume when the proposed corrective action is likely to yield between 3.8% and 8.5% in-place air voids.

In lieu of cores, a calibrated and correlated density gauge may be used to measure in place air voids. Take one density core per day to correlate the density gauge reading.

Areas defined in Section 341.4.9.2.3. “Miscellaneous Areas,” are not subject to in-place air void determination.

Furnish the type, size, and number of rollers necessary to ensure desired compaction. Use additional rollers as required to remove any roller marks. Use only water or an approved release agent on rollers, tamps, and other compaction equipment unless otherwise directed.

Use the control strip method shown in Tex-207-F, Part IV, on the first day of production to establish the rolling pattern that will produce the desired in-place air voids, unless otherwise directed.

Use tamps to thoroughly compact the edges of the pavement along curbs, headers, and similar structures and in locations that will not allow thorough compaction using rollers. The Engineer may require rolling using a trench roller on widened areas, in trenches, and in other limited areas.

Complete all compaction operations using breakdown rollers before the pavement temperature drops below 180°F, unless otherwise allowed. Compaction using a pneumatic or light finish roller operated in static mode is allowed for pavement temperatures above 160°F.

Allow the compacted pavement to cool to 160°F or lower before opening to traffic, unless otherwise directed. Sprinkle the finished mat with water or limewater, when directed, to expedite opening the roadway to traffic.

4.9. Acceptance Plan. Payment adjustments for the material will be in accordance with Article 341.6., “Payment.”

Sample and test the hot mix on a lot and sublot basis. Mixture meeting specification requirements will be paid for a pay factor of 1.0.

Referee Testing. The referee testing process shall be agreed to by Contractor and Engineer. The Contractor may request referee testing if a "remove and replace" condition is determined based on the Engineer's test results, or if the differences between Contractor and Engineer test results exceed the maximum allowable difference in accordance with Table 11 and the differences cannot be resolved. The Contractor may also request referee testing if the Engineer's test results require suspension of production and the Contractor's test results are within specification limits. Make the request within 5 working days after receiving test results and cores from the Engineer. Referee tests will be performed only on the sublot in question and only for the tests in question. Allow 10 working days from the time the referee laboratory receives the samples for test results to be reported.

Determine the laboratory-molded density based on the molded specific gravity and the maximum theoretical specific gravity of the referee sample. The in-place air voids will be determined based on the bulk specific gravity of the cores, as determined by the referee laboratory, and the Engineer's average maximum theoretical specific gravity for the lot. Except for "remove and replace" conditions, referee test results are final.

4.9.1. Production Acceptance.

4.9.1.1. Production Lot. A Production Lot is defined as a minimum of one test per 500 tons.

4.9.1.2. Production Sampling.

4.9.1.2.1. Random Sample. Determine random sample locations in accordance with Tex-225-F. Take one sample for each lot at the randomly selected location. The Contractor will perform all sampling and the Engineer may witness the sampling of production lots.

4.9.1.2.2. Mixture Sampling. The Contractor will perform the sampling of production lots from trucks at the plant in accordance with Tex-222-F The sampler will split each sample into three equal portions in accordance with Tex-200-F and label these portions as "Contractor," "Engineer," and "Referee." The Engineer may witness the sample splitting and may take immediate possession of the samples labeled "Engineer" and "Referee."

4.9.1.2.3. Asphalt Binder Sampling. The Engineer may elect to test the sample by a TxDOT qualified binder laboratory to verify compliance with Item 300.

4.9.1.3. Production Testing. The Contractor will perform production tests on each lot as shown in Table 16. Determine compliance with operational tolerances shown in Table 11 for all lots. The Engineer may use the Contractor's test results as acceptance tests, in lieu or performing tests. No testing is required when less than 100 tons per day is produced.

Take immediate corrective action if the Engineer's laboratory-molded density on any sublot is less than 95.0% or greater than 97.0% to bring the mixture within these tolerances. The Engineer may suspend operations if the Contractor's corrective actions do not produce acceptable results. The Engineer will allow production to resume when the proposed corrective action is likely to yield acceptable results.

Table 16
Production and Placement Testing Frequency

Description	Test Method	Min Contractor Testing Frequency	Min Engineer Testing Frequency
Individual % retained on #8 sieve and larger	Tex-200-F or Tex-236-F	1 per lot	1 per day
Individual % retained on sieves smaller than #8 and larger than #200			
% passing #200 sieve			
Laboratory-molded density	Tex-207-F	1 per lot	1 day
Laboratory-molded bulk specific gravity			
In-place air voids[3]			
VMA	Tex-204-F		
Theoretical maximum specific (Rice) gravity	Tex-227-F	1 per lot	1 per day
Asphalt binder content	Tex-236-F	1 per lot	1 per day
Hamburg wheel test	Tex-242-F	–	
Asphalt binder sampling and testing[1,2]	Tex-500-C, Part II	–	
Tack coat sampling and testing	Tex-500-C, Part III	–	

1. Sampling performed by the Contractor. The Engineer will witness sampling and retain the samples for 1 yr.
2. Testing performed by accredited laboratory.
3. Placement Lot is defined in 4.9.2.1.

4.9.1.4. Operational Tolerances. Control the production process within the operational tolerances shown in Table 11. When production is suspended, the Engineer will allow production to resume when test results or other information indicates the next mixture produced will be within the operational tolerances.

4.9.1.4.1. Gradation. Suspend operation and take corrective action if any aggregate is retained on the maximum sieve size shown in Table 8. A sublot is defined as out of tolerance if either the Engineer's or the Contractor's test results are out of operational tolerance. Suspend production when test results for gradation exceed the operational tolerances shown in Table 11 for three consecutive sublots on the same sieve or four consecutive sublots on any sieve, unless otherwise directed. The consecutive sublots may be from more than one lot.

4.9.1.4.2. Asphalt Binder Content. A lot is defined as out of operational tolerance if either the Engineer's or the Contractor's test results exceed the values shown in Table 11. No production or placement payment adjustments greater than 1.000 will be paid for any lot that is out of operational tolerance for asphalt binder content. Suspend production and shipment of the mixture if the Engineer's or the Contractor's asphalt binder content deviates from the current JMF by more than 0.5% for any lot.

4.9.1.4.3. VMA. The Contractor will determine the VMA for every lot. Take immediate corrective action if the VMA value for any sublot is less than the minimum VMA requirement for production shown in Table 8. Suspend production and shipment of the mixture if the Contractor's VMA results on two consecutive lots are below the minimum VMA requirement for production shown in Table 8.

4.9.1.4.4. Hamburg Wheel Test. The Engineer may perform a Hamburg wheel test on plant-produced mixture anytime during production. Suspend production until further Hamburg wheel tests meet the specified values when the production samples fail the Hamburg wheel test criteria shown in Table 10.

4.9.1.5. Individual Loads of Hot Mix. The Engineer may reject individual truckloads of hot mix. When a load of hot mix is rejected for reasons other than temperature, contamination, or excessive uncoated particles, the Contractor may request that the rejected load be tested. Make this request within 4 hr. of rejection. The Engineer will sample and test the mixture. If test results are within the operational tolerances shown in Table 11, payment will be made for the load. If test results are not within operational tolerances, no payment will be made for the load.

4.9.2. Placement Acceptance.

4.9.2.1. Placement Lot. A Placement Lot is defined as a minimum of one density core per 250 tons or as approved by the Engineer. If a density gauge is used for acceptance, a minimum of one density test is required per 500 feet of paving.

4.9.2.2. Shoulders, Ramps, Etc. Shoulders, ramps, intersections, acceleration lanes, deceleration lanes, and turn lanes are subject to in-place air void determination. Intersections may be considered miscellaneous areas when determined by the Engineer.

4.9.2.3. Miscellaneous Areas. Miscellaneous areas include areas that typically involve significant handwork or discontinuous paving operations, such as temporary detours, driveways, mailbox turnouts, crossovers, gores, spot level-up areas, pavement repair sections less than 300 ft., and other similar areas. Temporary detours are subject to in-place air void determination when shown on the plans. Miscellaneous areas also include level-ups and thin overlays when the layer thickness shown on the plans is less than the minimum untrimmed core height eligible for testing in accordance with Table 13. Miscellaneous areas are not eligible for random placement sampling locations. Compact miscellaneous areas in accordance with Section 341.4.8., "Compaction." Miscellaneous areas are not subject to in-place air void determination.

4.9.2.4. Placement Sampling. The Engineer will provide the Contractor with the placement random numbers only immediately after the lot is completed. Mark the roadway location at the completion of each lot and record the station number. Determine one random sample location for each placement lot in accordance with Tex-225-F. Adjust the random sample location by no more than necessary to achieve a 2-ft. clearance if the location is within 2 ft. of a joint or pavement edge.

Shoulders, ramps, intersections, acceleration lanes, deceleration lanes, and turn lanes are always eligible for selection as a random sample location; however, if a random sample location falls on one of these areas and the area is shown on the plans as not subject to in-place air void determination, cores will not be taken for the sublot and a 1.000 pay factor will be assigned to that sublot. In lieu of cores, use of a calibrated and correlated density gauge is acceptable.

Dry the core holes and tack the sides and bottom immediately after obtaining the cores. Fill the hole with the same type of mixture and properly compact the mixture. Repair core holes using other methods when approved.

4.9.2.5. Placement Testing. Perform placement tests in accordance with Table 16. After the Engineer returns the cores, the Contractor may test the cores to verify the Engineer's test results for in-place air voids. The allowable differences between the Contractor's and Engineer's test results are shown in Table 11.

4.9.2.5.1. In-Place Air Voids. The Engineer will measure in-place air voids in accordance with Tex-207-F and Tex-227-F. In lieu of cores, use of a calibrated and correlated density gauge is acceptable. Before drying to a constant weight, cores may be pre-dried using a CoreDry or similar vacuum device to remove excess moisture. The Engineer will average the values obtained for all sublots in the production lot to determine the theoretical maximum specific gravity. The Engineer will use the average air void content for in-place air voids.

4.9.2.5.2. Irregularities. Identify and correct irregularities, including segregation, rutting, raveling, flushing, fat spots, mat slippage, irregular color, irregular texture, roller marks, tears, gouges, streaks, uncoated aggregate particles, or broken aggregate particles. The Engineer may also identify irregularities, and in such cases, the Engineer will promptly notify the Contractor. If the Engineer determines that the irregularity will adversely affect pavement performance, the Engineer may require the Contractor to remove and replace (at the Contractor's expense) areas of the pavement that contain irregularities. The Engineer may also require the Contractor to remove and replace (at the Contractor's expense) areas where the mixture does not bond to the existing pavement.

If irregularities are detected, the Engineer may require the Contractor to immediately suspend operations or may allow the Contractor to continue operations for no more than 1 day while the Contractor is taking appropriate corrective action.

4.9.3. **Ride Quality**. Measure ride quality in accordance with Item 585, "Ride Quality for Pavement Surfaces," unless otherwise shown on the plans.

5. MEASUREMENT

5.1. **Dense-Graded HMA**. Hot mix will be measured by the ton of composite hot mix, which includes asphalt, aggregate, and additives. Measure the weight on scales in accordance with TxDOT Item 520, "Weighing and Measuring Equipment."

5.2. **Tack Coat**.Tack coat will be measured at the applied temperature by strapping the tank before and after road application and determining the net volume in gallons from the calibrated distributor. The Engineer will witness all strapping operations for volume determination. All tack, including emulsions, will be measured by the gallon applied. The Engineer may allow the use of a metering device to determine asphalt volume used and application rate if the device is accurate within 1.5% of the strapped volume.

6. PAYMENT

The work performed and materials furnished in accordance with this Item and measured as provided under Section 341.5.1., "Dense-Graded HMA," will be paid for at the unit price bid for "341M Municipal Dense-Graded Hot-Mix Asphalt" of the mixture type, SAC, and binder specified. These prices are full compensation for surface preparation, materials, placement, equipment, labor, tools, and incidentals.

The work performed and materials furnished in accordance with this Item and measured as provided under Section 341.5.2., "Tack Coat," will be paid for at the unit price bid for "Tack Coat" of the tack coat provided. These prices are full compensation for materials, placement, equipment, labor, tools, and incidentals.