

PART R24**CONSTRUCTION OF FOAMED BITUMEN STABILISED PAVEMENT****CONTENTS**

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1. GENERAL

This Part specifies the requirements for the construction of Insitu and Plant Mixed Foamed Bitumen Stabilised Pavement.

The pavement must be placed in the configuration specified in **Contract Specific Requirements** "Pavement Work". Any additional information regarding the project works is included in the Project Brief.

"Supplementary Binder" means any non-bituminous binder such as lime or cement.

Documents referenced in this Part are listed below:

AS 1289	Methods of Testing Soils for Engineering Purposes
AS 3972	GP & GB Cement
AS 1672	Building Limes

2. QUALITY REQUIREMENTS

The Contractor must prepare and implement a Quality Plan that includes the following documentation:

- (a) Details of any supplementary binder to be used;
- (b) Details of all plant types proposed and method of controlling binder content and moisture content (including methods to ensure uniformity);
- (c) Procedures for calibration of plant (including frequency);
- (d) Procedure for verifying binder content, including evidence of reliability of the procedure;
- (e) Procedures for material handling, including mixing and control of segregation;
- (f) Detailed procedures for pavement construction, including sequence of operations, from initial production through final placement, compaction and trim (including stabilisation depth and achieving surface finish where used with a spray seal); and
- (g) Detailed procedures for ceasing operations in the event of rain or strong wind.

If not provided beforehand, the documentation must be submitted at least 28 days prior to the commencement of site work. Provision of the documentation listed in this Clause shall constitute a HOLD POINT.

3. MATERIALS

3.1 General

Prior to the incorporation of any material in the works, the Contractor must provide evidence of compliance with this clause. Provision of this documentation shall constitute a HOLD POINT.

3.2 Bitumen

Binder must be Class 170 Bitumen in compliance with Part R25 "Supply of Bituminous Materials". The Contractor must provide evidence of the quality and age of the binder.

3.3 Supplementary Binders and Additives

Lime must be Hydrated Lime conforming to AS 1672. Cement must conform to AS 3972. Supplementary binders must not be older than three months from time of manufacture. Any foaming agents used must not constitute more than 2% of the bitumen by mass.

3.4 Water

Water must be potable. Where the water is drawn from natural sources, an efficient filter is to be provided on the suction pipe to ensure freedom from weeds, roots, etc., which could cause blockage of jets in the stabiliser or stationary plant mixer.

3.5 Granular Materials

If additional granular pavement material is required to improve the existing pavement material or to correct levels, this material must be spread (insitu process) or introduced at the rate required (stationary plant-mix process) so as to produce a homogeneously blended mix. The material must comply with Part R15 "Supply of Pavement Materials".

3.6 Recycled Asphalt Profilings

If reclaimed asphalt pavement (RAP) is to be used as additional pavement material, it must be pulverised asphalt obtained from the profiling of asphalt pavements or by crushing to a graded material with a maximum particle size of 40 mm. Materials must be free flowing and capable of uniform spreading and incorporation into the recycled pavement or for addition through the stationary plant-mix. It must be spread by the Contractor at the rate and/or to the levels specified in the mix design or schedule of job details.

4. CONSTRAINTS TO WORK

4.1 Traffic

The length of run must be determined to avoid delays to traffic in excess of 10 minutes. Sections of pavement opened to traffic during daylight hours must be monitored by the Contractor. The Contractor must implement appropriate action to ensure that traffic does not damage the freshly stabilised pavement.

Refer to Part CH20 "Provision for Traffic" for other constraints relating to traffic control.

4.2 Sealing

A bituminous wearing course must be placed not later than 7 days after stabilisation. A primer seal must cure for a minimum of 3 days and a maximum of 21 days prior to the application of a spray seal or asphalt layer.

4.3 Excavation Adjacent to Retained Existing Pavement

Excavation adjacent to an existing pavement to be retained must be carried out such that it does not damage the existing pavement.

4.4 Climatic Restraints

Stabilisation (including plant-mix operations, spreading, compacting and finishing) must not proceed:

- (a) during rain;
- (b) during periods when the wind is sufficiently strong to cause particles of the supplementary binder to become air-borne, unless effective mitigation procedures are adopted;
- (c) during conditions that may cause nuisance or danger to people, property or the environment;
- (d) when the temperature (measured at a depth of 50 mm in the pavement for insitu work) is below 10⁰ C; or
- (e) when the air temperature measured in the shade exceeds 40⁰ C.

5. PLANT

5.1 General

The insitu stabiliser or plant-mix mixer must comply with the following requirements:

- (a) have bitumen temperature gauges to verify bitumen temperature,
- (b) have computer controlled bitumen flow meter for verification of bitumen content;
- (c) have an inspection or test jet fitted to ensure the flow of bitumen and that the required expansion and half life qualities of the bitumen are being achieved; and
- (d) have self cleansing bitumen jets.

The Contractor must provide a copy of the certificate of calibration for the binder measuring device (for both insitu and plant-mix operations). Provision of the certificate shall constitute a **HOLD POINT**.

5.2 Insitu Stabilisation

The insitu stabiliser must:

- (a) have an engine power of greater than 375kW;
- (b) have bitumen injection systems linked to ground speed to ensure an accurate application throughout runs – irrespective of the speed of the plant; and
- (c) be capable of supplying both water and binder to the pavement and mixing to the specified depth; supply both water and the binder such that incorporation rates can be varied across the full width of the stabilising box and incrementally across the box.

5.3 Plant-Mix

The plant must comply with the following requirements:

- (a) be purpose built for the process of producing foamed bitumen stabilised road making materials and must be maintained and calibrated so as to provide a uniformly mixed product without segregation of the aggregate material;
- (b) have a fully computerised control system associated with weigh-cells on the variable feed rate for constituent materials, with read out meters to allow continuous monitoring and control of bitumen, supplementary binder, foaming water, added moisture and other additives, (e.g. wetting agents or dispersants). This monitoring at the operation control station is recorded by percentage by weight of pavement material; and
- (c) have a minimum continuous production capacity of 100 tonnes per hour.

5.4 Compaction Equipment

Compaction must be undertaken with the following minimum equipment requirements:

- (a) a vibrating padfoot roller of a minimum mass of 18t for compacting thicknesses of up to 250mm, and a minimum mass of 21t for compacting thicknesses of up to 300mm;
- (b) a vibrating smooth drum roller with a minimum mass of 18 t; and
- (c) a multi-tyre roller with a minimum mass of 12t.

6. TRIAL PAVEMENT

Prior to the commencement of construction of the Foamed Bitumen Stabilised Pavement, the Contractor must verify: the effectiveness of the construction plant; the number of passes of the stabilisation machine necessary to achieve uniform pulverisation and mixing (insitu process); and the field moisture content required to achieve specified compaction requirements.

This must be undertaken by either constructing a trial pavement or providing documented evidence from a previous project using the same plant, materials and construction methodology. The Contractor must provide 14 days prior notice of the construction of a trial pavement. Any trial pavement must be located within the works area and must be between 50 and 100 metres in length over the full width proposed to be stabilised.

Submission of the above notification and test results or evidence from a previous project shall constitute a **HOLD POINT**.

7. CONSTRUCTION PROCESS

7.1 Initial Preparation and Milling

For insitu stabilisation, the pavement must firstly be pulverised to 50mm above the depth to be stabilised. If thick in-fill layers of asphalt are present, the Contractor must mill the asphalt and evenly spread the milled asphalt onto the surface of the existing pavement to avoid creating discontinuities in the stabilised pavement.

Additional material required for shape correction must be added after the preliminary pulverisation. It must be spread onto the surface to a shape suitable for stabilisation and compacted and trimmed to the alignment, heights and shapes specified. Prior to spreading the secondary binder, the existing surface must be shaped, compacted and trimmed to the required shape to a degree that is sufficient to facilitate stabilisation, compaction and trimming to the alignment, heights and shapes specified.

7.2 Mixing and Placement

7.2.1 General

Mixing uniformity must be continuously inspected visually by the Contractor and work must stop when bitumen streaks or blotches are observed. The resultant material must have no lenses, pockets, lumps or granules of either incompletely mixed material, or incompletely mixed stabilising agent.

The sprayed bitumen must exhibit a minimum expansion ratio of 10 and a half-life of 20 seconds at the time of incorporation. The bitumen must be sprayed at a temperature of between 170°C and 190°C. The expansion ratio and half-life of every tanker load of bitumen must be checked using the inspection nozzle onboard the mixing chamber. The bituminous binder must not be incorporated into the pavement material where the foaming properties of the bitumen load supplied is less than that specified above. The construction tolerance for the application rate for the binder and supplementary binder is $\pm 10\%$ of the specified values.

The Contractor must complete a Daily Record Sheet, which must then be certified correct by the Contractor and forwarded within 18 hours of the completion of a day's work. Details of all materials applied must be recorded immediately after completion of each activity.

7.2.2 Insitu Stabilisation

The mixing of the binder and the mixing of the supplementary binder must be undertaken in two separate passes and the pulverised material must be stabilised to the depth specified. Cutting, pulverising and mixing must continue until all material passes a 37.5mm AS sieve and the lime, water, and foamed bitumen are evenly distributed through the mass to produce a mixture of unchanging appearance. The stabilisation machine must be equipped with a variable depth of cut control and an accurate gauge of depth of cut readily visible to the operator. Stabilisation work undertaken each day must be to the full width of the lane.

Bituminous Binders must be uniformly incorporated by a controlled device that provides calibration to the application rate of bitumen. The mixing chamber must be equipped with a spray system to allow variable widths of binder to be incorporated into the pavement material. Supplementary binders must be uniformly spread with the use of a spreader equipped with calibrated electronic load cells to ensure that a controlled mass is spread across the pavement. The spreader should be equipped with gates to allow variable width of supplementary binder.

The Contractor must record the tonnage of supplementary binder used per run and mat or tray results at regular (at least daily) intervals. Once the supplementary binder has been spread, the only traffic that may travel over the area to be stabilised must be construction plant employed for the stabilisation work.

The stabilising equipment must have provision for adding water to the mixture automatically at a variable controlled rate to bring the material to the moisture content necessary to achieve compaction. The equipment must be capable of including other additives, e.g. wetting agents or dispersants.

7.2.3 Plant – Mix Stabilisation

The binder must be uniformly incorporated by a controlled device that provides calibration to the application rate of bitumen. The inspection nozzle must be used to verify the foaming characteristics for every bitumen tanker load.

Application rate checks/reconciliation measured in kilograms per tonne of product must be monitored and recorded for every 100 tonnes of production, via the onboard weigh-cell computerised accumulator system. Regular calibration of all weigh cells within the plant must be undertaken and recorded, in line with the manufacturer's published guidelines.

The material produced by the stationary plant-mix must be transferred and spread in one concurrent operation, and after compaction, the finished surface levels on the base (and/or subbase) courses must be within the permitted tolerances without subsequent addition of material. The thickness of each compacted layer must be neither less than 100mm nor more than 200mm. The mix is to be placed without visual signs of segregation and any such areas are to be removed and replaced with fresh mix.

Initial Compaction and Trimming

Immediately after stabilisation, the stabilised area must be initially compacted to eliminate the height differential between the bulked stabilised material and any wheel ruts left by the stabiliser in the stabilised layer. This may be achieved with two passes of a vibrating roller immediately after the completion of stabilisation.

After the initial compaction and before final compaction commences, the surface must be trimmed to approximately the alignment, heights and shapes specified for the completed work. Any depressions must be filled with excess, complying, mixed (stabilised) material that is placed and compacted within three hours of bituminous stabilisation.

Trimming After Final Compaction

After final trimming, the surface must be free from loose pockets, holes, bumps, lenses of material and marks caused by a pad foot roller. Final trimming must be carried out as soon as practicable after the rollers have completed the compaction of the pavement. All trimming must be cut to waste and the material disposed of. Any treatment necessary to rectify localised depressions and rises must be subject to prior approval.

7.5 Joints**7.5.1 General**

Prior to commencing the next day's work, and where the stabilisation operation, including compaction, has been halted for any reason for a period exceeding 4 hours, the Contractor must provide construction joints at each discontinuity in the operation.

Where necessary for traffic safety, the Contractor must temporarily ramp longitudinal and transverse joints. Temporary ramping must be formed with hot asphalt or premix such that the slope of the ramp is not less than 10 horizontal: 1 vertical. Ramps must be removed prior to the application of the primer seal, spray seal or asphalt surfacing. A construction joint must be deemed fresh when the material on each side of the joint has been placed and compacted within 4 hours.

7.5.2 Longitudinal Joints

Longitudinal joints must not be located in the wheelpaths. Where a fresh longitudinal joint between adjacent runs is to be compacted, the outside 300mm of material from the first run must be left uncompacted until the adjacent material is ready for compaction. Overlaps of joints that are not fresh must not be less than 75mm and not greater than 150mm. The overlap of stabilising agent of all longitudinal joints must not exceed 150mm.

7.5.3 Transverse Joints

Where transverse joints are not made within 4 hours, the adjoining section previously stabilised must be cut back by at least 1.5m. The cutback material must be removed, disposed of and replaced in accordance with this specification.

For the insitu process, after this material has been replaced with complying material, the secondary binder must be spread over the 1.5m cutback length and it must be included in the stabilisation process of the adjoining section to be stabilised.

8. CURING

The water curing operation must commence immediately after the completion of compaction. Water curing is generally used for foamed bitumen stabilised pavements prior to the bituminous curing coat being applied. The stabilised layer surface and edges must be maintained in a slightly damp condition, via an occasional application of uniformly applied fine mist, until the layer is sealed with a bituminous wearing course.

Water must be applied in a manner such that slurring of the surface, pavement instability and erosion and / or flushing of the pavement surface are all avoided.

9. SURFACE FINISH

The surface of the pavement layers must be uniformly tight and free of loose uncompacted material, segregated or 'bony' material or soft, over wet areas and free of roller indentations. Where a spray seal is to be used on a foam bitumen base course, the Contractor must include in the procedures for the placement of base, a minimum of 6 passes with a Class PR22 multi-wheel roller to achieve a uniformly tight surface.

The surface level of the stabilised base must not vary by more than 5 mm in any direction when tested with a 3 m straight edge. The crossfall must not depart from the corresponding crossfall shown in the documents by more than 0.5% absolute.

The finished wearing course and any lower layers constructed must have a smooth transverse and longitudinal profile. If Part R36 "Surface Characteristics" is included in this Specification, the measured roughness values in NAASRA roughness counts per kilometre must not exceed those specified in the **Contract Specific Requirements** "Pavement Work".

The crossfall must be measured:

- (a) between any two points more than 2 metres apart except where a pavement verge is less than 2 metres wide. For pavement verges less than 2 metres wide, the measurement must be made between the extreme edges of the pavement verge on each side of the pavement;
- (b) transverse to the centre line of the carriageway;
- (c) within the boundaries of a cross-section element which has a constant crossfall.

The Contractor must maintain the stabilised layer during curing and until it has been overlaid with another pavement layer or surfaced with the final wearing course.

10. SAMPLING AND TESTING

10.1 Lots

Acceptance of the quality of the stabilised layer must be based on an analysis of a set of random sited tests taken from each Lot of the works.

The Contractor must determine the proportion of the works that will constitute a single Lot in accordance with Part G20 "Quality System Requirements". Compliance will apply to the whole of the Lot of the works from which the set of tests is taken.

Any area which is deemed unsuitable must be excluded from the Lot before testing commences. Excluded areas must be rectified prior to testing.

This provision applies particularly to, but is not limited by, any of the following:

- (a) segregated of “boney” areas;
- (b) soft, overwet or “fatty” areas;
- (c) ravelling and loose material; compaction planes; or
- (d) surface cracking, shoving and ruts.

10.2 Depth

The depth of stabilisation must be verified by measuring the depth of the cutting (insitu) or placed material (plant-mix) adjacent to an existing pavement material in at least two locations within the lot and measured to the nearest 5 mm for conformation against the requirements of **Contract Specific Requirements** “Pavement Work”.

Achieving the specified stabilised layer thickness shall constitute a **HOLD POINT**.

10.3 Compaction

Stabilised pavement layers must be compacted uniformly to the full depth and over the full width. Unless otherwise stated in **Contract Specific Requirements** “Pavement Work”, compaction must not be less than that specified in Table 13.1. “Test Records”

The location of the tests must be on a stratified random basis in accordance with TP061. Acceptance must be based on discrete results. Where a result fails, the stratum represented by that result must be the subject of a Non-Conformance Report.

Laboratory compaction testing must be performed on a “one to one” basis with the field density testing unless it can be demonstrated that an assigned MDD can be consistently established in accordance with TP166. Sampling sites must be determined by the stratified random method and the MDD bulk samples removed and the compaction points completed within an hour and a half of the binder being applied. The field compaction test must be performed at the same location that the related laboratory compaction sample was derived.

Achieving the specified compaction standard shall constitute a **HOLD POINT**.

11. TEST PROCEDURES

The Contractor must use the following test procedures (refer http://www.dpti.sa.gov.au/contractor_documents) to verify conformance with the Specification:

TEST	TEST PROCEDURE
SITE SELECTION BY STRATIFIED RANDOM TECHNIQUE	TP 061
SAMPLING OF SOIL, AGGREGATES AND ROCKS	TP 226
PREPARATION OF SAMPLES	AS 1289.1
MOISTURE CONTENT: Oven Drying Method	AS 1289.2.1.1
Microwave Method	AS 1289.2.1.4
FIELD DENSITY:	
Sand Replacement Method	AS 1289.5.3.1
Nuclear Method	AS 1289.5.8.1
DETERMINATION OF THE DRY DENSITY/MOISTURE CONTENT RELATION OF A SOIL – 3 POINT METHOD	TP 164
ASSIGNMENT OF MAXIMUM DRY DENSITY AND OPTIMUM MOISTURE CONTENT VALUES	TP 166
COMPACTION CONTROL TEST – DRY DENSITY RATIO AND MOISTURE RATIO	TP 320
BINDER CONTENT:	
Pressure Filtration Method	TP 470
Ignition Oven Method	AST 04:1999

12. HOLD POINTS

The following is a summary of Hold Points referenced in this Part:

CLAUSE REF.	HOLD POINT	RESPONSE TIME
2	Submission of Procedures (if not in Post Tender Submission)	7 days
2	Submission of Program (if not in Post Tender Submission)	7 days
3	Evidence of materials compliance	1 day
5.1	Certificate of calibration of binder measuring device	1 day
6	Trial Pavement	1 day
10.2	Achieving Stabilised Layer Thickness Requirement	1 day
10.3	Achieving Compaction Requirement	1 day

13. VERIFICATION REQUIREMENTS AND RECORDS

13.1 Test Records

The Contractor must undertake the testing specified in this Clause and supply written evidence of compliance with the lot package.

CLAUSE REF.	SUBJECT	PROPERTY	TEST PROCEDURE	TEST FREQUENCY	ACCEPTANCE LIMITS
7	Pavement Material properties	Insitu Work: Binder Application Rate	Determined by "on-board" measuring devices	each 100 m linear interval	within $\pm 10\%$ of that specified
		Plant Mix : Binder Application Rate	Determined by calibrated plant measuring devices	each continuous production run or 100 tonnes of pavement material	within $\pm 10\%$ of that specified
9*	Ride Quality	NAASRA Roughness Counts	Refer Part R36	Refer Part R36	Refer Contract Specific Requirements
11	Pavement Construction	Dry Density Ratio	TP 320	1 test per 400m ² per layer with a minimum of 3 tests per Lot.	not less than 96%
11	Pavement Construction	Stabilisation Depth	Direct Measurement	2 locations per lot	Refer Contract Specific Requirements "Pavement Work".

*If Part R36 "Surface Characteristics - Roughness" is included in this Specification.

13.2 Other Records

The Contractor must supply the following records:

CLAUSE REF.	SUBJECT	RECORD TO BE PROVIDED
7.2	Daily Record of Work	Details of each days work, including quantities on materials used, i.e.: <ul style="list-style-type: none"> • records of tanker dippings for runs or plant use, • binder temperature records, • records of weighing / measuring cell readouts, • records of mat / tray spread rate assessment, • binder and supplementary binder rate calculations, • assumptions made in determining application rates.