

SPECIAL NOTE FOR FIBER REINFORCEMENT OF ASPHALT

PART 1 – GENERAL

1.1 DESCRIPTION

This Section includes specifications for furnishing all materials, equipment, labor, and incidentals for mixing aramid fiber reinforcements to hot mix asphalt.

1.2 DEFINITIONS

- A. HMA- hot mix asphalt, without aramid fiber.
- B. WMA- warm mix asphalt, without aramid fiber.
- C. Reinforced HMA - hot mix asphalt including aramid fibers properly proportioned, uniformly mixed and coated with asphalt.
- D. Aramid fiber - pure aramid fiber meeting the material properties of this specification, without additive materials.
- E. Delivery material(s) - the material(s) combined with the pure aramid fiber to facilitate Aramid fiber and HMA/WMA proportioning, uniform mixing with the HMA/WMA, and asphalt coating of the aramid fibers.
- F. Aramid product - the aramid supplier's mixture of pure aramid fiber and delivery material(s).
- G. Manufacturer - the company that produces the aramid fiber from raw materials.
- H. Supplier - the company that offers an aramid product.

PART 2 – PRODUCT

2.1 MATERIALS

Meet the following aramid fiber properties.

Property	Measure	Standard
Material	Aramid	ASTM D276
Form	Monofilament fibers	Manufacturer Certification
Length	0.75-1.50 inches (+/- 10%)	Manufacturer Cert.
Specific Gravity	1.44	ASTM D276
Minimum Tensile Strength	400,000 psi	ASTM D3379
Maximum Tensile Elongation	1.8 %	ASTM D3379
Degradation Temperature	800 degrees F	ASTM D276
Acid and Alkali Resistance	Inert	Manufacturer Cert.

2.2 SUBMITTALS

Submit the following.

- A. Identify the mixing plant.
- B. Provide a specification sheet from the aramid fiber manufacturer.
- C. Provide the following from the aramid product supplier at least three weeks prior to HMA/WMA production.
 1. The supplier's specified mix rate for the aramid product.
 2. Certification that the amount of aramid fiber in the aramid product will be between 2.1 and 4.0

ounces of pure aramid fiber for each ton of hot mix asphalt.

3. Evidence showing how many times, if any, the supplier's fiber product has been successfully produced at the asphalt plant to be used for the project.
4. Proven method of introducing the aramid fibers into the hot mix asphalt which will not cause the aramid fibers to become airborne.

2.3 JOB MIX FORMULA

When aramid fiber is required as a mixture ingredient, modification to the job mix formula is not required.

PART 3 – EXECUTION

3.1 CONSTRUCTION REQUIREMENTS

Store aramid product in a dry environment and do not allow them to be in contact with moisture.

Mix 3.0 ounces (+/- 1.0 ounces) of aramid fibers per ton of asphalt. The weight applied is for pure aramid fibers only, weight of any delivery materials is not considered.

Have a fiber supplier's representative on site during the first day of production mixing. This requirement can be waived if fiber supplier and HMA/WMA producer can supply evidence of supplier's brand of fiber product being successfully produced by the HMA/WMA producer. The fiber supplier's representative may be on site for additional days as requested by the Engineer.

Introduce the aramid product as follows:

1. Batch Plant

When a batch type plant is used, add the aramid product dosage to the aggregate in the weigh hopper. This may be done with loose fibers and a fiber metering device, or may be done by using manual dosing equipment. If necessary, increase the batch dry mixing time to ensure the aramid fibers are uniformly distributed prior to the injection of asphalt cement into the mixer.

2. Drum Plant

When a continuous or drier-drum type plant is used, add the aramid product to the RAP material to uniformly disperse with the aggregate and injected asphalt. Use a separate aramid product metering device feed system to proportion by weight of total mix, the required percentage of fiber reinforcement into the mixture. Control the aramid product metering system with a proportioning device to meet the dosing requirements.

When a continuous or drier-drum type plant is used for limited production volumes, the addition of the aramid product may be done by using manual measuring tools or equipment and adding them directly onto the RAP belt or into the RAP opening on the plant. Because this is not an automated process, a written protocol must be supplied by the producer to demonstrate how they will attain the dosage requirement, and documentation must be supplied by the

material manufacturer assuring this method will produce the desired uniform aramid fiber distribution.

Mix the aramid fiber with the aggregate longer, if needed, to allow thorough distribution of aramid fibers at the end of the mixing process and to promote asphalt coating of individual strands of aramid fiber. At the start of any fiber mixing, visually observe the reinforced HMA/WMA at the plant and in first three trucks at the point of discharge and prior to delivery to the job site. Observation shall include using a shovel or other device. Look for proper distribution of aramid fibers and make mixing adjustments if needed.

WMA: Use of a feeder system will be required for both Drum and Batch plants when producing Warm Mix Asphalt to ensure correct distribution and coating of the aramid fibers. This requirement maybe waved if the asphalt producer can demonstrate complete melting of the delivery material and proper incorporation of the aramid fibers into the WMA.

3.2 ACCEPTANCE

Acceptance of the reinforced HMA/WMA will include the following factors:

1. Aramid fiber is properly proportioned based on documentation comparing fiber feed to HMA/WMA mix production. A log of the total amount of aramid fibers applied certified by fiber manufacturer/supplier shall be required daily.
2. By visual inspection at the end of the mixing process, there is no clumping of aramid fiber or aramid delivery product and the aramid fibers are uniformly distributed.
3. All other mixture and density requirement of the asphalt as detailed in the Standard Specifications, current edition, shall apply.

PART 4 - MEASUREMENT AND PAYMENT

The Department will measure the quantity of Fiber Reinforcement for HMA/WMA as ton of asphalt placed with fibers. Each ton of asphalt placed with the aramid fibers according to this special note will be measured and paid for at the contract unit bid price per ton, and shall include full compensation for furnishing all labor, tools, equipment, and incidentals for doing all the work involved in adding the fibers to HMA/WMA.

<u>Code</u>	<u>Pay Item</u>	<u>Pay Unit</u>
24785EC	Fiber Reinforcement for HMA	Tons