

SPECIAL NOTE FOR SPRAY APPLIED THERMOPLASTIC PAVEMENT MARKING MATERIALS

I. DESCRIPTION

Except as provided herein, all work shall be performed in accordance with the Department's Standard Specifications, Interim Supplemental Specifications, applicable Standard and Sepia Drawings, applicable Special Provisions and Special Notes, current editions. Article references are to the Standard Specifications. This project shall consist of furnishing all labor, equipment, materials and incidentals for the following:

- (1) Spray applied thermoplastic pavement marking materials with reflectorized glass beads for permanent applications

II. MATERIALS

- A. **DROP ON BEADS.** Use beads that will ensure the pavement marking material will meet retroreflectivity requirements. The Department will evaluate the beads as part of the marking system through retroreflectivity readings.
- B. **APPROVAL.** Select materials that conform to the composition and physical characteristic requirements below when evaluated in accordance with AASHTO T-250 or other test methods as cited. The Department will sample and evaluate for approval each lot of thermoplastic material delivered for use per contract prior to installation of the thermoplastic material. Do not allow the installation of thermoplastic material until it has been approved by the Division of Materials. Allow the Department a minimum of 10 working days to evaluate and approve thermoplastic material from the date sampled.
- C. **Composition.** Use a maleic-modified glycerol ester resin (alkyd binder) to formulate the thermoplastic material. Ensure the pigment, pre-mix beads, and filler are uniformly dispersed in the resin. Use material that is free from all dirt and foreign material. Provide independent analysis data and certification for each formulation stating the total concentration of each heavy metal present, the test method used for each determination, and compliance to 40 CFR 261 for leachable heavy metals content.

COMPOSITION (Percentage by Weight)		
Component	White	Yellow
Binder, ⁽¹⁾	26.0 min.	26.0 min.
Glass Beads (Premixed)	30 - 40	30 - 40
Titanium Dioxide (Rutile, Type II)	10.0 min.	—
Calcium Carbonate & Inert Fillers ⁽²⁾	42.0 max.	50.0 max.
Heavy Metals Content	Comply with 40 CFR 261	Comply with 40 CFR 261

⁽¹⁾Use a binder that consists of a mixture of synthetic resins, at least one being solid at room temperature, and high boiling point plasticizers. Ensure that at least one-third of the binder composition is solid maleic-modified glycerol ester resin and is not less than 8 percent by weight of the entire material formulation. Do not use alkyd binder that contains petroleum based hydrocarbon resins.

⁽²⁾The manufacturer may choose the amount of calcium carbonate and inert fillers, providing all other requirements of this section are met.

D. Physical Characteristics. For thermoplastic material heated for 4 hours at 425°F under agitation, conform to the following requirements.

- a) **Color.** As determined with a spectrophotometer using D65 illuminant with a 45 degree entrance angle and 0 degree observation angle geometry.

CIELAB Color Coordinates		
	Yellow	White
Daytime Color (CIELAB) Spectrophotometer using illuminant D65 at 45° illumination and 0° viewing with a 2° observer	L* 81.76 a* 19.79 b* 89.89 Maximum allowable variation 6.0ΔE*	L* 93.51 a* -1.01 b* 0.70 Maximum allowable variation 6.0ΔE*
Nighttime Color (CIELAB) Spectrophotometer using illuminant A at 45° illumination and 0° viewing with a 2° observer	L* 86.90 a* 24.80 b* 95.45 Maximum allowable variation 6.0ΔE*	L* 93.45 a* -0.79 b* 0.43 Maximum allowable variation 6.0ΔE*

- b) **Set Time.** Use material that, when applied at a temperature range of 375 ± 25 °F and thickness of 60 ± 10 mils, sets to bear traffic in not more than 2 minutes when the air and road surface temperature is approximately ≥ 50 ± 3 °F, and not more than 10 minutes when the air and road surface temperature is approximately < 50 ± 3 °F.
- c) **Softening Point.** Ensure that the thermoplastic material has a softening point of 180 ± 15 °F.
- d) **Bond Strength.** Ensure that the bond strength of the thermoplastic material to concrete exceeds 180 psi.
- e) **Cracking Resistance at Low Temperature.** Ensure that the thermoplastic material shows no cracks when observed from a distance exceeding one foot.
- f) **Impact Resistance.** Ensure the impact resistance of the thermoplastic material is a minimum of 50 inch-pounds.
- g) **Flash Point.** Use thermoplastic material that has a flash point not less than 475 °F.

E. PACKAGING. Package thermoplastic material in suitable 50 pound containers to which the material shall not adhere during shipment or storage. Include a label stating that the thermoplastic material is to be maintained with a temperature range of 350 – 400°F during application. Provide the thermoplastic material in granular form.

F. SHELF LIFE. Ensure that the thermoplastic material conforms to this section for a period of one year. Replace any thermoplastic material not conforming to the above requirements.

G. MANUFACTURER'S TESTING. Perform testing in accordance with AASHTO T-250 on a minimum of one composite sample per 10,000 pounds, or portion thereof, per lot of thermoplastic produced.

H. CERTIFICATION. Submit manufacturer's certification stating conformance to the requirements of this section for each lot of extruded thermoplastic delivered for use on projects. Clearly state the manufacture, formulation identification, product name, color, date of manufacturer, total quantity of lot produced, actual quantity of thermoplastic material represented, sampling method utilized to obtain the samples, and required manufacturer's testing data for each composite sample tested to represent each lot produced.

III. CONSTRUCTION METHODS

- A. SURFACE PREPARATION.** The contractor will be required to sweep all pavement surfaces prior to striping and maintain the cleaning operation far enough in advance of the striping operation to prevent any dust from the cleaning operation from mixing with the paint. The sweeper must maintain contact with the roadway. When the Engineer determines abnormal amounts of debris or other material have accumulated beyond the capability of the required sweeping unit which will require shoveling or other means to remove, the Engineer will make arrangements, prior to painting, to have the material removed by the Department.
- B. INSTALLATION.** Install thermoplastic materials in accordance with Section 714, Durable Pavement Striping, and the following exceptions:
- Install the thermoplastic materials at a minimum thickness of 60 mils.
 - Ensure the material temperature is maintained between 350 and 400°F.
 - Do not allow the material temperature to exceed 400°F.
 - Removal of existing stripe on asphalt surfaces is not required.
- C. RETROREFLECTIVITY.** The Department will evaluate installed markings in accordance with Section 714.03.06, Proving Period for Durable Markings.

IV. METHOD OF MEASUREMENT

- A. ACCEPTANCE AND PAYMENT.** The Department will accept spray applied thermoplastic materials based on compliance of the manufacturer's certification and conformance of test results obtained by the Department to the requirements of this special note.

Contrary to Section 714.03.08, Acceptance of Non-Specification Thermoplastic Markings, the Department will not accept non-specification compliant markings. Remove non-specification compliant markings by water blasting. The Department will perform random thickness tests on applied markings to determine compliance to thickness requirements

IV. BASIS OF PAYMENT

The Department will make payment for the completed and accepted quantities under the following:

<u>Code</u>	<u>Pav Item</u>	<u>Pav Unit</u>
24995EC	PAVE STRIPING-SPRAY THERMO-6 IN W	LF
24996EC	PAVE STRIPING-SPRAY THERMO-6 IN Y	LF

The Department will consider payment as full compensation for furnishing all labor, materials, equipment, and incidentals required to construct spray applied thermoplastic pavement markings.