ARKANSAS DEPARTMENT OF TRANSPORTATION
SUPPLEMENTAL SPECIFICATION
RECYCLED ASPHALT PAVEMENT

Division 400 of the Standard Specifications for Highway Construction, Edition of 2014, is hereby amended as follows:

The fourth paragraph of **Subsection 416.03, Materials and Composition,** is hereby deleted and the following substituted therefor:

To ensure the "production" stockpile is distinguishable to anyone involved in the production of asphalt at the plant and no "unprocessed" materials are introduced into the process of ACHM mix manufacturing, the following shall be required for the use of Recycled Asphalt Pavement (RAP):

- Only processed RAP shall be introduced into asphalt mixes. Unprocessed RAP and processed RAP stockpiles shall be separated by distance and signed accordingly. Processed is defined as efforts to create a uniform stockpile of material and may include, but is not limited to, crushing and/or fractionating.

- RAP stockpiles should have only binder covered aggregates. There shall be no virgin aggregate or deleterious materials present in any RAP stockpile. Plant startup and shut down materials will be considered binder covered and are allowed. Aggregate not fully coated from asphalt plant produced material is not considered virgin aggregate.

- The maximum size of the reclaimed material shall be 3 inches when introduced into the mixer.

- Quality control testing for asphalt binder content and gradation of RAP shall be the contractor's responsibility and conducted as follows:

    - Tested as part of the field verification process. Field verification test results may be transferred from another ARDOT job given they are from the same mix design and were completed within 120 days of the current job's field verification process.

    - Minimum of one set of tests per job for jobs that contain at least 1,000 tons of ACHM.

    - One set of tests for every 10,000 tons of asphalt mix produced.

    - The first tests on the job must be performed within the first 3 days of production on the job.

- If testing determines the properties of the RAP have deviated significantly from the test results provided from field verification, as determined by the Engineer, changes to virgin binder content and/or aggregate proportions will be required before production of the ACHM mix continues. Once adjustments are made and the plant produced mix

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has the desired properties, the Contractor may request that a field mix design be accepted by the Engineer.

- In an effort to create uniform, repeatable testing for RAP binder content, asphalt binder content of the RAP shall be determined using AASHTO T308 with the specific requirements as follows:
    - Sample shall be dried to a constant mass as per AASHTO T 329 using a drying temperature of 230°F ± 9°F.
    - Preheat and burn sample in an ignition oven at a temperature of 482℃.
    - Asphalt Binder Content = % loss – Aggregate Correction Factor.
- An Aggregate Correction Factor for each ignition oven per asphalt mix design shall be submitted to the Resident Engineer before the start of production. Determination of the Aggregate Correction Factor may be based on regional historical data at the time of the change. This will ensure all parties involved are aware of the correction factor and therefore avoiding disagreements pertaining to manipulation/fluctuation in aggregate correction factors that could be used to adjust binder content data. Any change to the Aggregate Correction Factor must be shared with the Resident Engineer