

PART R15**SUPPLY OF PAVEMENT MATERIALS****CONTENTS**

1.	GENERAL
2.	QUALITY REQUIREMENTS
3.	ACCEPTANCE OF MATERIAL
4.	QUALITY OF MATERIALS
5.	SAMPLING AND TESTING
6.	RECYCLED MATERIALS AND BLAST FURNACE SLAG
7.	PERFORMANCE BASED PAVEMENT MATERIALS
8.	STABILISED AND WET-MIXED MATERIALS (Plant Mixed)
9.	RAIL BALLAST
10.	ASPHALT AGGREGATES AND SAND
11.	HOLD POINTS
12.	VERIFICATION REQUIREMENTS AND RECORDS

ATTACHMENT R15A: PAVEMENT MATERIAL SPECIFICATION

1. GENERAL

.1 This Part specifies the requirements for the supply and delivery of materials (including crushed quarry products, natural gravel, sand and recycled pavement materials) to be used in the construction of roadworks, bridgeworks, railways and other applications associated with construction.

.2 The following definitions apply to this Contract:

"Pavement Materials" include:

- Spalls
- Road Ballast
- Rail Ballast
- Class 3 Recycled Pavement Material
- Class 3 Quarried Pavement Material
- Class 2 Recycled Pavement Material
- Class 2 Quarried Pavement Material
- Class 1 Recycled Pavement Material
- Class 1 Quarried Pavement Material
- Stabilised Pavement Material
- Sealing Aggregate
- Sand
- Asphalt Aggregate
- Mineral Filler for Asphalt, other than Hydrated Lime
- Arrestor Bed Material

"Process Control" means a controlled documented system of practices and procedures used to monitor and control the product inputs, equipment and manufacturing processes to ensure the product replicates the product design.

"Secondary Mineral" means a mineral which has formed as a consequence of the alteration or replacement (other than by the conditions of normal weathering) of a pre-existing material and without alteration to the form of the rock.

.3 The following abbreviations apply to this Contract:

AS 1141	Sampling and Testing Aggregates.
AS 1289	Methods for Testing Soils for Engineering Purposes.
AS 2758	Aggregates and Rock for Engineering Purposes.
AS 2891	Methods of Sampling and Testing Asphalt
AS 1152	Specification for Test Sieves
NATA	National Association of Testing Authorities, Australia.
RMS Txxx	Roads and Maritime Services NSW Test Procedure xxx.
TP	Department of Planning, Transport and Infrastructure (DPTI) Test Procedure (refer http://www.dpti.sa.gov.au/materials_technology_documents/test_procedures2).

- .4 The products must comply with the requirements specified in Attachment R15A, available from: https://www.dit.sa.gov.au/__data/assets/pdf_file/0003/288093/Part_R15_Attachment_A_AUG_2017.pdf
- .5 If recycled materials or blast furnace slag are to be used for any purpose other than construction of DPTI roadworks, additional environmental requirements may be necessary. This Part R15 does not consider the suitability of recycled materials or blast furnace slag for any other purpose than for use in DPTI roadworks.

2. **QUALITY REQUIREMENTS**

Quality Plan, Procedures and Documentation

- .1 Further to the requirements of Part G20 "Quality System Requirements", the Contractor must develop and implement a Quality Plan that includes the following procedures at a minimum:

All materials:	<ul style="list-style-type: none"> • Random selection of sample increments (vide Clause 5 under "Sampling"). • Representative splitting of bulk samples (vide Clause 5 under "Sampling"). • Handling and storage of the product including the avoidance of intermixing, contamination or deterioration which may affect the product properties. • Inspection of bins, stockpile pads and trucks for contamination and operational efficiency • Requirements for inspection and testing of processes and products (including the Inspection and Test Plan, vide Clause G20.7 "Inspection and Testing")
Material sourced from Quarries	<ul style="list-style-type: none"> • Plant calibration and maintenance, including weighing equipment, flow meters and proportioning systems where installed • Primary, Secondary and Tertiary Crusher inspection, wear adjustment and maintenance • Screen Deck inspection, wear adjustment and maintenance • Use and handling of explosives. • Assessment of quarry face and shot rock • Moisture control of shot rock • Handling processes for shot rock • Requirements for labelling of storage bays and silos
Sealing aggregate:	<ul style="list-style-type: none"> • Stripping performance (vide Clause 4 under "Aggregate Stripping TP705").
Asphalt Aggregates	<ul style="list-style-type: none"> • Additional process control elements (vide Clauses 2 and 10).
Basic igneous source rock	<ul style="list-style-type: none"> • Control of secondary mineralisation (vide Clause 4 under "Secondary Mineralisation").
Recycled materials and Blast Furnace Slag	<ul style="list-style-type: none"> • Control of constituent materials (vide Clause 6 under "Construction and Demolition Materials" or "Blast Furnace Slag") as applicable. • Quality Control and Compliance Testing (vide Clause 6 under "Alternative Sources of Recycled Materials").
Stabilised materials	<ul style="list-style-type: none"> • Control of binder content (vide Clause 8 under "Additive Content Determination"). • Use of retarder (vide Clause 8 under "Addition of Retarder"). • Working time for other binders (vide Clause 8 under "Time Requirements").

- .2 Where the Principal does not hold a copy of the current procedures, these procedures must be submitted at least 28 days prior to the commencement of production and must generate objective evidence that the specified quality requirements have been achieved.
- .3 Provision of the documentation listed in this Clause shall constitute a **HOLD POINT**.

Asphalt Aggregates

- .4 Where asphalt aggregates are to be produced, the Contractor must develop and implement a Process Control System which includes:
 - (a) a description of the flow of materials and the processes carried out on them from input materials to the plant through to delivery of aggregates to the customer;
 - (b) a flow diagram and identification of the key elements of the manufacturing process requiring monitoring, measurement or verification; and
 - (c) constant monitoring and statistical analysis of records to verify process capability and product characteristics.

Identification

- .5 In addition to the requirements of Clause G20.6 under "Identification", the pavement materials must be produced in identifiable Lots not greater than the following:

Sealing and Asphalt Aggregates, Arrestor Bed Material:	500 tonnes
Other Pavement Materials:	1 000 tonnes.

- .6 A Lot of the material must be produced under uniform conditions from the same source material and/or the same constituent components and be essentially homogeneous with respect to composition and general appearance. Notwithstanding Clause G20.6.1 "Definition", a lot may be prepared from more than one day's production.

Dedicated Stockpiles

- .7 The Contractor must establish dedicated stockpiles conforming to the following requirements:
 - (a) The location of each Lot must be accurately identified until conformance of the Lot with the Specification requirements has been verified.
 - (b) Any non-conforming Lots placed into these stockpiles must be removed.
 - (c) Where the stockpile contains more than one Lot, the stockpile must be constructed in horizontal layers with each successive layer fully contained within the area of the upper surface of the preceding layer. Levelling of each layer must be carried out in a manner to minimise segregation and material breakdown.
 - (d) Once a dedicated stockpile has been completed, further material must not be added to the stockpile.

3. ACCEPTANCE OF MATERIAL

- .1 Acceptance of materials will be undertaken on a Lot basis and the total quantity of material in the Lot will be subject to acceptance or rejection. The material in a Lot will be accepted if the material has been produced and stockpiled in accordance with the Specification and the NATA endorsed test results for the bulk sample comply with the requirements specified.

4. QUALITY OF MATERIALS

General

- .1 All material must be clean, sound, hard and durable.
- .2 Mica, shale and similar laminated materials, adherent coatings or any foreign material must not be present in form or sufficient quantity to produce adverse effect upon the usage and performance of the material.
- .3 All products must be produced from natural rock or sand deposits, as appropriate, except where otherwise permitted in this Part.
- .4 Recycled materials and blast furnace slag must conform to the requirements detailed in Clause 6 "Recycled Materials and Blast Furnace Slag", which are specific to use in roadworks. All materials must

be free from undesirable seeds as described in the regulations under the *Natural Resource Management Act* (SA). The regulations are available from <http://www.legislation.sa.gov.au/index.aspx/>.

Properties

- .5 Additive contents must be within the tolerances stated in Clause 8 under "Additive Content Determination" in the case of Plant Mixed materials.
- .6 For all materials specifications, square aperture sieves conforming to AS 1152 "Specification for Test Sieves" must be used for the determination of grading for particle sizes 75 mm and finer. Coarser sizes must be determined by linear measurement.

Aggregate Stripping (TP 705)

- .7 The Contractor must:
 - (a) implement a design process to prevent the adverse stripping performance of sealing aggregates;
 - (b) include a procedure for determining the stripping performance of the sealing aggregates in both wet and dry states in the Quality Plan;
 - (c) include pre coating agents and adhesion agents in the testing program; and
 - (d) report the wet and dry test results.

Secondary Mineralisation

- .8 This clause applies where basic igneous source rock (as defined in AS2758) is used for the production of a Pavement Material complying with this Part R15.
- .9 Secondary mineralisation must not be present in the Pavement Material to the extent that it adversely affects the Pavement Material's durability and/or long term performance.
- .10 The Quality Plan must:
 - (a) indicate the level and nature of secondary mineralisation of the source rock, including a description of the potential of the secondary mineralisation to cause material degradation;
 - (b) include procedures for monitoring the quality of the product and component materials during quarrying and production, addressing the control and monitoring of secondary mineralisation;
 - (c) include rock type and durability classifications (ie Sound, Marginal or Unsound Rock) provided by Vicroads in accordance with Vicroads Specification 801 "Source Rock for the Production of Crushed Rock and Aggregates"; and
 - (d) address any other information reasonably requested by the Principal.
- .11 Vicroads Specifications are available from <http://webapps.vicroads.vic.gov.au/VRNE/csdspeci.nsf/>.

5. SAMPLING AND TESTING

Sampling

- .1 Unless specified otherwise, the Contractor must arrange for sampling of material to be carried out by an appropriately NATA certified laboratory in accordance with TP 226 "Sampling of Soils, Aggregates and Rock".
- .2 The Contractor must include in the Quality Plan procedures for the random selection of sample increments appropriate to the sampling method used and the process of splitting and recombining to produce two samples equally representative of the bulk sample.
- .3 Preparation of samples for testing will be undertaken in accordance with AS 1289.1.
- .4 Unless otherwise approved, the NATA laboratory must split each bulk sample to produce an audit sample to be held by the NATA certified laboratory for a period no less than 14 days after submission of test results.
- .5 Audit samples for Sealing Aggregates must be held until the end of the Defects Liability Period and the sample supplied to the Principal if requested.

Testing

- .6 Notwithstanding TP 226 "Sampling of Soils, Aggregates and Rocks" and Clause 6.1.1 "General" therein, Quality Control testing for each product must be undertaken on a sample representing each production Lot.

- .7 The Quality Control tests listed on each Product Specification Sheet (Attachment R15A) must be performed on the sample representing each Lot in accordance with the testing frequency specified in Table 5.7:

TABLE 5.7 QUALITY ASSURANCE MINIMUM TESTING FREQUENCIES		
TEST PROCEDURE	PROPERTY	MINIMUM TEST FREQUENCY *
SPALLS		
AS 1141.11	Particle Size Distribution	One test per 5 Lots
ROAD BALLASTS		
AS 1141.11	Particle Size Distribution	One test per 5 Lots
AS 1141.23	Los Angeles Value	One test per 5 Lots
RAIL BALLAST		
AS 1141.4	Bulk Density	Two tests 1st per Lot, One test per Lot thereafter
AS 1141.6.1	Particle Density	Two tests 1st per Lot, One test per Lot thereafter
AS 1141.11 & 12	Particle Size Distribution	Two tests 1st per Lot, One test per Lot thereafter
AS 1141.22	Wet/Dry Strength	Two tests 1st per Lot, One test per Lot thereafter
AS 1141.23	Los Angeles Value	Two tests 1st per Lot, One test per Lot thereafter
AS 1141.14	Mis-shapen Particles	Two tests 1st per Lot, One test per Lot thereafter
QUARRIED PAVEMENT MATERIALS		
TP134	Particle Size Distribution	One test per Lot
AS 1289 3.1.2 ,3.2.1, 3.3.1 & 3.4.1	Atterberg Limits	One test per Lot
AS 1141.23	Los Angeles Value	One test per Lot ³
TP183	Resilient Modulus/Deformation	One test per 100 Lots (Performance based only).
TP184	Triaxial Compression	One test per 100 Lots (Performance based only).
RECYCLED PAVEMENT MATERIALS		
TP134	Particle Size Distribution	One test per Lot
AS 1289 3.1.2, 3.2.1, 3.3.1 & 3.4.1	Atterberg Limits	One test per Lot
RMS T276	Foreign Materials Content	One test per Lot
AS 2891.3.3	Bitumen Content	One test per Lot ³
AS 1141.23	Los Angeles Value	One test per Lot ³
Contaminants	Metals, Organics	In accordance with Contractor's approved quality control and compliance testing procedures
TP183	Resilient Modulus/Deformation	One test per 100 Lots (Performance based only).
TP184	Triaxial Compression	One test per 100 Lots (Performance based only).
STABILISED PAVEMENT MATERIALS		
TP134	Particle Size Distribution	One test per Lot

AS 1289 3.1.2, 3.2.1, 3.3.1 & 3.4.1	Atterberg Limits	One test per Lot
AS 1141.23	Los Angeles Value	One test per Lot ³
Contractor Quality Plan	Binder Content	One test / 150 tons (refer Clause 8 under "Additive Content Determination")
AS 1141.51	UCS (Strength Control)	Two tests/150 tons (refer Clause 8 under "Strength Determination Testing")
AS 1141.51	UCS (Binder Content Control)	One test per 10 000 tons
SEALING AGGREGATES		
AS 1141.11	Particle Size Distribution	One test per Lot
AS 1141.15	Flakiness Index	One test per Lot
TP244	% Flat Particles	One test per Lot
AS 1141.14	Mis-shapen Particles	One test per Lot
AS 1141.23	Los Angeles Value	One test per Lot ³
AS 1141.42, AS 1141.40	Polished Aggregate Friction	One test annually ²
TP705	Aggregate Stripping	One test annually ²
AS 1141.20.1 or 20.2	Average Least Dimension - direct	Three tests per Lot
AS 1141.20.3	Average Least Dimension - calculated	One test per Lot
ASPHALT AGGREGATES		
AS 1141.11	Particle Size Distribution	One test per Lot
AS 1141.15	Flakiness Index	One test per Lot
TP240	Elongation Index	One test per Lot
AS 1141.23	Los Angeles Value	One test per Lot ³
AS 1141.5, AS 1141.6.1 & AS 1141.6.2	Water absorption & densities	One test per 10 Lots
AS 1141.24	Sulphate Soundness	One test per 10 Lots ³
AS 1141.30	Unsound & marginal stone contents	One test per Lot ^{1,3}
AS 1141.42, AS 1141.40	Polished Aggregate Friction	One test annually ² (refer Clause 10)
SANDS		
TP134	Particle Size Distribution	One test per Lot
AS 1289 3.1.2 , 3.2.1, 3.3.1 & 3.4.1	Atterberg Limits	One test per Lot ³
AS 1141 34	Organic Impurities	One test per Lot ³
MINERAL FILLER FOR ASPHALT, OTHER THAN HYDRATED LIME		
AS 1141.11	Particle Size Distribution	One per contract
AS 1141.17	Voids in Dry Compacted Filler	One per contract
AS 1289.B1.3	Moisture Content	One per week
AS 2350.8	Specific Surface	One per contract
AS 3583.3	Loss on Ignition	One per contract
AS 1141.8	Water Soluble Fraction	One per week
ADDITIONAL REQUIREMENTS FOR BASIC IGNEOUS SOURCE ROCK		
AS1142.6	Secondary Mineral Content	One test every two years

AS 1141.29	Accelerated Soundness Index	One test every two years
AS 1141.30	Unsound & marginal stone contents	Three tests per Lot
ARRESTOR BED MATERIAL		
TP134	Particle Size Distribution	One test per Lot
RMS T239	Fractured Faces	One test per Lot
AS 1141.14	Mis-Shapen Particles	One test per Lot
WA 223.1	Crushing and Cracking	One test per contract
AS 1141.23	Los Angeles Value	One test per Lot
WA Specification 6706/02/1312 Attachment	Slump Angle	One test per Lot
AS 1141.4	Bulk Density	One test per contract

¹ Testing for Unsound & marginal stone contents under “Additional Requirements for Basic Igneous Source Rock”, (if required) will include this test in the total number required per Lot.

² The Principal reserves the right to obtain material and undertake annual testing as necessary.

³ Refer Clause 5 under “Reduced Rate of Testing” for more information.

* Refer to the Clause listed for further information about the testing frequency.

Reduced Rate of Testing

- .8 The Contractor may adopt a reduced frequency of testing where approval has been granted under Part 4 of the Guidelines for the DPTI Prequalification Scheme for the Supply of Pavement Materials. Refer: http://www.dpti.sa.gov.au/contractor_documents/prequalification.
- .9 Subject to Part 4 of the Guidelines, the Contractor may apply for a reduced frequency of testing for this Contract. Acceptance of a reduced rate of testing does not derogate from the Contractor’s obligation to provide conforming Pavement Material.

6. RECYCLED MATERIALS AND BLAST FURNACE SLAG

- .1 Where Quarried Material has been specified in **Contract Specific Requirements**, the Contractor may submit a proposal to use Recycled Material or Blast Furnace Slag in lieu of Quarried Material in accordance with this clause.
- .2 Blast furnace slag used in lieu of quarry materials referred to in this clause must not be granulated or ground.
- .3 Submission of the proposal shall constitute a **HOLD POINT**.

Construction and Demolition Materials

- .4 Recycled products comprising blends of quarried material and/or reclaimed concrete, with or without supplementary source materials (brick, tile and asphalt) must comply with the designated quality requirements for each recycled product detailed in Attachment R15A.
- .5 No more than 20% by mass of supplementary materials may be incorporated and the constituent proportions must remain unchanged during production.

Blast Furnace Slag

- .6 Products comprising blast furnace slag or blends of quarried material and blast furnace slag must comply with the designated quality requirements for quarried Class 1, 2 or 3 pavement materials detailed in Attachment R15A.
- .7 Blast furnace slag must meet the requirements of the SA EPA Waste Derived Fill (Blast Furnace Slag) Specification 2015.
- .8 The Supplier must provide the Principal with a written statement of compliance certifying that the Blast Furnace slag complies with the chemical criteria of the SA EPA Waste Derived Fill (Blast Furnace Slag) Specification 2015.

Alternative Sources of Recycled Materials

- .9 If the Contractor proposes to supply reclaimed or industrial materials and by-products other than those described above in this Part, it must undertake a comprehensive environmental assessment of the proposed material to determine contaminant levels.
- .10 The assessment must be consistent with Department of Planning, Transport and Infrastructure Environmental Instruction 21.6 "Recycled Fill Materials for Transport Infrastructure" (available from <https://www.dit.sa.gov.au/standards> and in particular the requirements of Clause 11 "Use of Material or Soil from Non-DPTI Sources" of the Instruction. Products from alternative sources must not be supplied without project specific written approval from DPTI.
- .11 The Products must comply with the designated quality requirements for each recycled product detailed in Attachment R15A.
- .12 Suppliers of reclaimed or industrial materials and by-products must maintain quality control procedures to ensure adequate detection and management of contaminants, including procedures relating to storage and handling, processing, sampling, analysis and reporting.
- .13 The assessment of the materials must be appropriate to the physical and chemical nature of the material and its intended use. The quality control procedures must be endorsed by an appropriately qualified professional with at least 7 years experience in site contamination management.

7. PERFORMANCE BASED PAVEMENT MATERIALS

- .1 This Clause specifies the requirements for Performance Based Materials, which are designed and manufactured to meet particular levels of in-service pavement performance. Performance Based Materials may only be used where permitted in **Contract Specific Requirements**.
- .2 Where a Contractor proposes to design a pavement material to meet pavement performance criteria, the following applies:
 - (a) The Contractor must determine the Mix Design properties for the product based on the full suite of tests identified in the Mix Design Limits of the product specification. With the exception of Resilient Modulus/Deformation testing and Triaxial Compression testing, results from testing a minimum of ten samples of product must be used to determine the average test value. This value will be the nominated Mix Design value for that test property or sieve size. Each sample must be representative of a minimum of 100 tonnes of product.
 - (b) Mix Designs must comply with the limits specified in "Mix Design Limits" of each product specification.
 - (c) The Contractor must submit a reference sample of the product.
 - (d) Resilient Modulus/Deformation testing and Triaxial Compression testing must be performed in duplicate on a sample representative of the submitted mix design and reference sample.
 - (e) The Contractor may be requested to submit further evidence of conformance to Resilient Modulus and Triaxial Compression requirements on samples representative of the extremes of the permissible grading envelope for manufacturing, and/or field trial evidence of acceptable performance where the mix design is closer than one standard deviation from the Mix Design Limit for any specified sieve size.
- .3 The Contractor must submit supporting mix design and/or specification conformance documentation including results for the full suite of tests identified in the Mix Design limits of the product specification. Subject to the product meeting all requirements of the Specification, DPTI will register the mix design and apply the Manufacturing Tolerance to the Mix Design for Product Quality Control purposes.
- .4 The Contractor must not supply material under a Mix Design specification until written approval and the manufacturing tolerances have been received. Approval will remain current for a period not exceeding 2 years. The approval may be withdrawn in the event of unsatisfactory field performance of the material, or if the reference sample is no longer representative of delivered material.

8. STABILISED AND WET-MIXED MATERIALS (Plant Mixed)

General

- .1 Stabilised materials (which includes the addition of cement, fly ash, lime, bitumen, other binders or combinations of binders) and wet-mixed materials must comply with this clause 8.

- .2 Stabilised materials are specified by class of pavement material, and by either binder content or strength. Materials specified by binder content basis must be tested for binder content in accordance with Clause 8 under "Additive Content Determination".
- .3 Materials specified on a strength basis must be tested for Unconfined Compressive Strength in accordance with Clause 8 under "Strength Determination Testing".
- .4 The addition of cement, flyash, bitumen, lime, or slag and water must be described by a suffix system as given in the following examples:

SPM2/20QGC4	20 mm Class 2, 4% Cement Stabilised Quarried Pavement Material;
SPM1/30RMC4MPa	30 mm Class 1, 4 MPa Cement Stabilised Recycled Pavement Material;
SPM2/40QGB3	40 mm Class 2, 3% Bitumen Stabilised Quarried Pavement Material;
SPM2/20QGL1F2	20 mm Class 2 Stabilised Quarried Pavement Material with 1% Lime, and 2% Flyash;
SPM2/30QGL1S4	30 mm Class 2 Stabilised Quarried Pavement Material with 1% Lime and 4% Slag.

- .5 Wet-mixed material is a mixture of Class 1, 2 or 3 Pavement Material and water, produced at a central mixing plant to a controlled moisture content that is based on the modified optimum moisture content of the material. Wet-mixed materials are identified by the suffix "W" as illustrated in the following examples:

PM1/20QGW	20 mm Class 1 Quarried Pavement Material Wet-Mix (Grading Based)
PM1/20RMW	20 mm Class 1 Recycled Pavement Material Wet-Mix (Performance Based)

Recycled Products

- .6 Cement, fly ash, lime, slag, bitumen or other binders must not be added to recycled pavement material products without prior approval.
- .7 Where a Contractor proposes to produce a stabilised recycled product, the following applies:
 - (a) The Contractor must submit evidence of compliance of the product to the full suite of tests detailed in the Product Specification Sheets (Attachment R15A) for Stabilised Pavement Material.
 - (b) The Contractor must submit a reference sample of the untreated recycled material, which must be representative of a minimum of ten samples of product, and a sample of the proposed binder.
 - (c) The Contractor must undertake Unconfined Compressive Strength testing on three pairs of specimens at each binder content and curing age detailed in the Product Specification. Samples prepared for testing must be representative of the reference sample.

Strength Based Stabilised Material

- .8 Where the use of a stabilised material meeting strength based acceptance criteria is permitted under this Contract, the following applies prior to commencement of supply:
 - (a) The Contractor must submit evidence of compliance of the product to the full suite of tests detailed in the Product Specification Sheets (Attachment R15A) for Stabilised Pavement Material (Strength Control).
 - (b) The Contractor must submit a reference sample of the unstabilised material, which must be representative of a minimum of 10 samples of product, and a sample of the proposed binder.
 - (c) The Contractor must undertake Unconfined Compressive Strength testing on 3 pairs of specimens at the binder contents and curing age required to meet the full range of strength targets detailed in the Product Specification. Samples prepared for testing must be representative of the reference sample.
- .9 Strength based stabilised material must not be supplied without the prior approval of the Principal.

Binders

- .10 Binders and Additives must comply with Table 8.10 "Binder Properties".

TABLE 8.10 BINDER PROPERTIES	
Bitumen	Class 170 residual bitumen to DPTI Master Specification, Part R25 "Supply of Bituminous Materials" or other approved special foam binder
Cement	Blended cement complying with AS 3972 "Portland and Blended Cements".
Lime	Hydrated lime or quick lime complying with AS 1672 "Building Limes". Quick lime must be fully slaked
Fly ash	Fine, medium or coarse fly ash meeting the requirements of AS 3582 "Supplementary Cementitious Materials for use with Portland Cement – Part 1 Fly Ash".
Slag	Ground granulated blast furnace slag must meet the requirements of AS 3582 "Supplementary Cementitious Materials for use with Portland Cement – Part 2 Ground Granulated Blast Furnace Slag"
Chemicals	Proprietary chemical binders may be used provided documented evidence as to their suitability is submitted. Procedures for the use, dosage and handling of the binder must be included in the Contractor's Quality Plan.
Water	Water must be potable

Additive Content Determination

Bitumen

- .11 The bitumen content of the treated material must be as ordered, expressed as a target percentage of dry mass. The bitumen content may vary up to $\pm 0.25\%$ from that ordered. The bitumen content must be determined in accordance with AS 2891.3.3 "Binder Content and Aggregate Grading – Pressure Filter Method".

Powder Form Binders

- .12 The binder content of the treated material must be as ordered, expressed as a target percentage of dry mass. The binder content may vary up to $\pm 0.5\%$ from that ordered. The Contractor must identify in the Quality Plan a methodology for control, measurement and quality assurance of the specified binder content. Proposed procedures must be subject to approval prior to the supply of material.

Liquid Binders

- .13 Liquid binders must be ordered as a minimum percentage of the dry mass of untreated product or by loose volume of untreated product. The Contractor must identify in the Quality Plan a methodology for control and quality assurance of the binder content.

Combination Binders

- .14 Combination binders must be ordered as a minimum percentage of the dry mass of untreated product or by loose volume of untreated product. The Contractor must identify in the Quality Plan a methodology for control and quality assurance of the respective binder contents.

Water

- .15 The moisture content of bitumen, cement, lime and/or fly ash treated material when combined with water and water by itself ordered as a wet mixed product must be ordered expressed as a percentage of dry mass. The moisture content may vary up to $\pm 1.0\%$ from that ordered.

Test Frequency

- .16 The Contractor must include in the Quality Plan procedures for verifying the additive content for each 150 tonnes of treated material.

Strength Determination Testing

Powder Form Binders, Liquid Binders and Combination Binders

- .17 The strength of the treated material must be as ordered, expressed as a target Unconfined Compressive Strength in MPa. The average strength of the test cylinders for each test may vary up to - 0.5 MPa, + 1.0 MPa from that ordered. Strength must be determined in accordance with AS 1141.51 "Unconfined Compressive Strength of Compacted Bound Materials".
- .18 A contingency representative sample of the untreated material used in the production of plant treated material must be taken from each day's production.

Test Frequency

- .19 Samples of stabilised materials must be tested for strength at a rate not less than 2 tests (4 test cylinders) per 150 tonnes. Where Contractor developed procedures are proposed, the Contractor must include in the Quality Plan procedures for verifying the additive content for each 150 tonnes of treated material.

Addition of Retarder

- .20 A retarder must be used with blended cement binders. The proposed retarder and usage rate must be nominated in the Contractor's Quality Plan. The Contractor's mixing plant must be fitted with a measuring device to allow accurate measurement of the amount of retarder being added to the mix.

Mixing

- .21 The quarry material, selected additive (if specified) and/or water must be mixed at a central mixing plant of the pugmill type. The mixing plant may be either a batch or continuous type. The mass of charge in a batch mixer or the rate of feed to a continuous type mixer must not exceed that which will permit complete mixing of all material.
- .22 Mixing of material must be continued until the quarry material, binder, retarder and/or water are evenly distributed through the mass and a uniform mixture of unchanging appearance is obtained. Sufficient mixing capacity must be provided to produce enough mixture to permit placing up to 200 tonne of mixture on the road bed per hour.

Transporting

- .23 During transportation, the load must be completely covered with a tarpaulin or similar heavy cover to protect the material against the effect of sun and rain. The cover must not be removed until the load is about to be tipped.

Time Requirements

- .24 Cement treated material must be delivered to the road bed or construction site within a time sufficient to enable all spreading, shaping and compaction to be carried out within 2.75 hours of the introduction of cement to the untreated material.
- .25 Blends of lime and fly ash or lime treated material must be delivered to the road bed or construction site on the same day as the introduction of lime and/or fly ash to the moist material. Bitumen treated material may be stockpiled for a period not exceeding 4 weeks.
- .26 Wet mix material must be delivered to the road bed or construction site and placed/compacted in a time that ensures that the moisture content of the material remains within the specified tolerance of that at which it was ordered. Other binders must be delivered to the site within time periods detailed in the Contractor's Quality Plan.
- .27 The time of binder addition must be recorded on the cart-note for each load of stabilised material.

9. RAIL BALLAST

- .1 The production of rail ballast must comply with this clause 9.
- .2 The Contractor must undertake petrographic analyses of the source rock to the extent that all mineralogical variations of the rock are examined.
- .3 Where basic igneous source rock is used for the production of ballast, the Contractor must indicate in the Quality Plan the maximum acceptable level of secondary mineralisation of the source rock and procedures for monitoring the product during quarrying and production.
- .4 Notwithstanding that the rock may comply with other requirements of this Specification, ballast must not contain minerals in a concentration that may be detrimental to the overall performance of the ballast in service.
- .5 The ballast must be managed at all stages to prevent material contamination, segregation and degradation. Unnecessary handling must be avoided at all times, such as repeated mechanical handling and dropping of material.
- .6 Where the ballast is to be used under steel sleepers, the ballast must comply with Classification RAIL60S.

10. ASPHALT AGGREGATES AND SAND

- .1 The production of asphalt aggregates and sand must comply with this clause 10.

- .2 The production process must provide material to meet the grading requirements for the appropriate aggregate size to produce a particular asphalt type.
- .3 Once the Design has been completed, the grading of the aggregate to be supplied must be known as the "Nominated Grading". Production tolerances for the assessment of conformity to the design must comply with Attachment R15A.
- .4 The associated properties of each aggregate type complying with the property limits as shown in Attachment R15A must be determined and thereafter be referred to as the Nominated Property; for example, "LA Nominated Property".
- .5 PAFV assessment of any size product from a particular source must be undertaken on aggregates within the -9.5 mm to +6.7 mm size fraction of the same product source in accordance with AS 1141.40 Section 7.1.

11. **HOLD POINTS**

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

CLAUSE REF.	HOLD POINT	RESPONSE TIME
2	Submission of Procedures (where the Principal does not hold a copy of the current procedures)	7 days
6	Proposal to use Recycled Material or Blast Furnace Slag in lieu of Quarried Material.	14 days

12. **VERIFICATION REQUIREMENTS AND RECORDS**

- .1 The Contractor must supply written verification that the testing undertaken demonstrates compliance with the requirements of this Part and supply the verification with the lot package.
