



Florida Department of Transportation

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May 8, 2015

DCE MEMORANDUM NO. 12-15

(FHWA Approved: 5/06/2015)

TO: DISTRICT CONSTRUCTION ENGINEERS

FROM: David A. Sadler, P.E., Director, Office of Construction

A handwritten signature in blue ink, appearing to read "David A. Sadler".

**COPIES: Tom Byron, Nick Finch (FHWA), Rafiq Darji (FHWA), Bob Burleson (FTBA),
Jim Warren (ACAF)**

**SUBJECT: WINDROW PAVING - SPECIFICATION CHANGES TO SECTION 330 -
HOT MIX ASPHALT - GENERAL CONSTRUCTION REQUIREMENTS**

Currently, Specification Section 330 does not contain provisions for windrow paving.

Windrow paving is the construction process where asphalt mixture is placed by the haul trucks (typically belly-dump) in a continuous mound (windrow), onto the surface to be paved. An "elevator," attached to the paver, picks up the asphalt mix from the windrow and places the mix into the paver hopper. The remainder of the paving and compaction operations are essentially the same as for conventional paving.

This memorandum serves as blanket approval to process a \$0.00 specification change, if requested by the Contractor, and should be attached to the Work Order or Supplemental Agreement used to document the change.

The Specification language included with this memo should be attached to the Work Order or Supplemental Agreement.

If you have any questions regarding this matter, please call Richard Hewitt at 386-943-5305.

DS/rh

Windrow Paving Specification Changes

Specification 320-6.3.2, add the following at the end:

For windrow paving, perform windrow temperature measurements at a frequency of one measurement per 500 lf of windrow placed. Check the temperature of the windrow asphalt mixture using a quick-reading thermometer or infrared thermometer directly in front of the paver. Measure the temperature of the windrow beneath the exposed surface by shoveling away a portion of the windrow and then measuring the temperature. For windrow temperature measurements, the requirements of Table 320-2 and 320-3 apply, but in no case shall be below 280°F.

Specification 330-3.2.3, add the following at the end:

For windrow paving, immediately cease dumping of asphalt material when rain begins at the roadway. Stop paving operations while rain is falling or where there is water on the surface to be covered. Remove windrowed asphalt mixture exposed to rain. Once the rain has stopped, standing water has been removed from the tacked surface to the satisfaction of the Engineer, and the temperature of the mixture caught in transit still meets the requirements as specified in 320-6.3, the Contractor may then windrow the remaining material caught in transit.

Specification 330-5-2.1 add the following at the end:

When hot mix is placed in windrows, operate windrow pickup equipment so substantially all the mixture deposited on the roadbed is picked up and loaded into the paver. Prevent the windrow pickup equipment from contaminating the mixture.

Specification 330-6.1.3, add the following at the end:

If the windrow material violates the temperature requirements of 320-6.3.2, remove the material from the area of deficient temperature and replace with new asphalt meeting the temperature requirements.

Specification 330-6.1.5.1, modify the existing language in 330-6.1.5.1 as shown below:

330-6.1.5.1 Thickness Control: Ensure the spread rate is within 5% of the target spread rate. When determining the spread rate, use, at a minimum, an average of five truckloads of mix, except use an average of three truckloads of mix for windrow paving. When the average spread rate is beyond plus or minus 5% of the target spread rate, monitor the thickness of the pavement layer closely and adjust the construction operations.

If the Contractor fails to maintain an average spread rate within plus or minus 5% of the target spread rate for two consecutive days, the Engineer may elect to stop the construction operation at any time until the issue is resolved.