

## **10-1. POLYESTER CONCRETE OVERLAY**

### **GENERAL**

#### **Summary**

This work includes placing a polyester concrete overlay with a high molecular weight methacrylate (HMWM) resin prime coat to bridge decks.

#### **Submittals**

Submit an overlay placement plan and a public safety plan under Section 5-1.02, "Plans and Working Drawings," of the Standard Specifications. The plan review time will be 15 days.

The overlay placement plan must include:

1. Schedule of overlay work and testing for each bridge
2. Description of equipment for applying HMWM resin
3. Description of equipment for measuring, mixing, placing, and finishing polyester concrete overlay
4. Method for isolating expansion joints
5. Cure time for polyester concrete
6. Description of equipment for applying sand
7. Storage and handling of HMWM resin and polyester concrete components
8. Disposal of excess HMWM resin, polyester concrete, and containers

The public safety plan must include details for:

1. A public notification letter with a list of delivery and posting addresses. The letter must state overlay work locations, dates, times, and what to expect. Deliver the letter to residences and businesses within 30 meters of overlay work and to local fire and police officials at least 7 days before starting work. Post the letter at the job site.
2. An airborne emissions monitoring plan prepared and executed by a certified industrial hygienist (CIH) certified in comprehensive practice by the American Board of Industrial Hygiene. The plan must have at least 4 monitoring points including the mixing point, application point, and point of nearest public contact. Monitor airborne emissions during overlay work and submit emissions monitoring results after completing the work.
3. An action plan for protection of the public when airborne emissions levels exceed permissible levels.
4. A copy of the CIH's certification.

Submit a material safety data sheet for each shipment of HMWM and polyester resin components before use.

#### **Quality Control and Assurance**

Submit samples of HMWM and polyester resins 15 days before use under Section 6-3, "Testing," of the Standard Specifications. Notify the Engineer 15 days before delivery of resin in containers over 209 liters to the job site.

Complete a trial overlay before starting work. Results from airborne emissions monitoring of the trial overlay must be submitted to the Engineer before starting production work.

The trial overlay must:

1. Be at least 3.6 meters wide by 1.8 meters long and the same thickness as the project overlay
2. Be constructed on a prepared concrete base
3. Be placed within the project limits at an approved location
4. Be constructed using the same equipment as the production work
5. Replicate field conditions for the production work
6. Determine the initial polyester concrete set time
7. Demonstrate suitability of the proposed means and methods
8. Demonstrate suitability of the airborne emissions monitoring plan
9. Be disposed of under Section 7-1.13, "Disposal of Material Outside the Highway Right of Way," of the Standard Specifications

**MATERIALS**

Polyester concrete consists of polyester resin binder and aggregate.  
Polyester resin binder must:

1. Be an unsaturated isophthalic polyester-styrene co-polymer.
2. Contain at least 1 percent by weight gamma-methacryloxypropyltrimethoxysilane, an organosilane ester silane coupler.
3. Be used with a promoter compatible with suitable methyl ethyl ketone peroxide and cumene hydroperoxide initiators.
4. Comply with the following:

**Polyester Resin Binder**

Property	Requirement	Test Method
Viscosity *	0.075 to 0.200 Pa·s (RVT, No. 1 Spindle, 20 RPM at 77°F)	ASTM D 2196
Specific Gravity *	1.05 to 1.10 at 25°C	ASTM D 1475
Elongation	35 percent, minimum Type I at 11.5 mm/min. Thickness = 6.5±1 mm	ASTM D 638
	Sample Conditioning: 18/25/50 + 5/70	ASTM D 618
Tensile Strength	17.5 MPa, minimum Type I at 11.5 mm/min. Thickness = 6.5±1 mm	ASTM D 638
	Sample Conditioning: 18/25/50 + 5/70	ASTM D 618
Styrene Content *	40 percent to 50 percent by weight	ASTM D 2369
PCC Saturated Surface-Dry Bond Strength	3.5 MPa, minimum, at 24 hours and 21° ± 1°C	California Test 551
Static Volatile Emission *	60 gram per square meter, loss, maximum	SCAQMD Method 309-91

\*Test must be performed before adding initiator.

Aggregate for polyester concrete must:

1. Comply with Section 90-2.02, "Aggregates," of the Standard Specifications

2. Have at most 45 percent crushed particles retained on the 2.36-mm sieve when tested under California Test 205
3. Have fine aggregate consisting of natural sand
4. Have a weighted average aggregate absorption of at most 1 percent when tested under California Tests 206 and 207
5. At the time of mixing with resin, have a moisture content of at most one half of the weighted average aggregate absorption when tested under California Test 226
6. Comply with one of the following aggregate gradings:

**Combined Aggregate Grading**

Sieve Size	Percentage Passing	
	3/8 inch Maximum	No. 4 Maximum
12.5-mm	100	100
9.5-mm	83 - 100	100
4.75-mm	65 - 82	62 - 85
2.36-mm	45 - 64	45 - 67
1.18-mm	27 - 48	29 - 50
600- $\mu$ m	12 - 30	16 - 36
300- $\mu$ m	6 - 17	5 - 20
150- $\mu$ m	0 - 7	0 - 7
75- $\mu$ m	0 - 3	0 - 3

HMWM resin prime coat consists of a resin, promoter, and initiator. HMWM resin must:

1. Be low odor and wax-free
2. Comply with the following:

**Methacrylate Resin**

Property	Requirement	Test Method
Volatile Content *	30 percent, maximum	ASTM D 2369
Viscosity *	0.025 Pa·s, maximum, (Brookfield RVT with UL adaptor, 50 RPM at 25°C)	ASTM D 2196
Specific Gravity *	0.90 minimum, at 25°C	ASTM D 1475
Flash Point *	180°F, minimum	ASTM D 3278
Vapor Pressure *	1.0 mm Hg, maximum, at 25°C	ASTM D 323
PCC Saturated Surface-Dry Bond Strength	3.5 MPa, minimum at 24 hours and 21 ± 1°C	California Test 551

\* Test must be performed before adding initiator.

Sand for abrasive sand finish must:

1. Be commercial quality blast sand
2. Have at least 95 percent pass the 2.36-mm sieve and at least 95 percent retained on the 0.85-mm sieve when tested under California Test 205
3. Have an average absorption of at most 1 percent when tested under California Test 207

**CONSTRUCTION**

Use a continuous mixer to mix polyester concrete. The continuous mixer must:

1. Employ an auger screw/chute device.
2. Be equipped with an automatic metering device that measures and records aggregate and resin volumes. Record volumes at least every 5 minutes, including time and date. Submit recorded volumes at the end of the work shift.
3. Have a visible readout gage that displays volumes of aggregate and resin being recorded.
4. Be certified under California Test 109 before use.
5. Produce a satisfactory mix consistently during a demonstration.

Polyester concrete may be mixed in mechanical mixers of at most 0.25-cubic meter capacity. Finishing equipment for polyester concrete must:

1. Have grade control capabilities
2. Be used to consolidate the polyester concrete

The Engineer will provide final grade and cross slope before the start of overlay work.

The Engineer may (1) test existing deck surfaces for smoothness under Section 51-1.17, "Finishing Bridge Decks," of the Standard Specifications, and (2) require the deck smoothness be modified under Section 42-2, "Grinding," of the Standard Specifications.

New concrete deck surfaces must comply with Section 51-1.17, "Finishing Bridge Decks," of the Standard Specifications before starting overlay work.

Prepare the deck under "Prepare Concrete Bridge Deck Surface," "Remove Unsound Concrete," and "Rapid Setting Concrete Patches" of these special provisions.

The deck must be dry before placing the HMWM prime coat. The concrete surface must be at least 10 degrees C and at most 38 degrees C. Relative humidity must be at most 85 percent.

Sweep the deck. Blow the deck clean with compressed air.

Thoroughly mix all components of HMWM resin prime coat. Apply the HMWM resin to the deck surface:

1. Within 5 minutes of mixing
2. At a rate of approximately \_\_\_\_\_ sq meters per liter
3. Uniformly and spread to completely cover surfaces to be overlaid

Place the HMWM prime coat on magnesium phosphate concrete no sooner than 72 hours after final set or on modified high alumina based concrete no sooner than 30 minutes after final set.

Initiate the polyester resin binder and blend completely. Add aggregate and mix for at least 2 minutes.

Place the polyester concrete:

1. Immediately after applying the HMWM prime coat
2. Before gelling
3. Within 15 minutes of adding initiator

The resin binder must weigh approximately 12 percent of the weight of the aggregate. The Engineer will determine the exact percentage. Polyester concrete must have an initial set time of at least 30 minutes and at most 120 minutes when tested using an initial-setting time Gillmore needle under ASTM C 266.

Consolidate and finish the overlay to the required grade and cross section using finishing equipment. Polyester concrete must be consolidated to a relative compaction of at least 97 percent when tested under California Test 552.

Apply a sand finish of at least 0.4-kg per square meter before gelling occurs.

Protect the overlay from moisture for at least 4 hours after finishing. Allow traffic or equipment on the overlay no sooner than 4 hours after final finishing.

Completed polyester concrete deck surfaces must comply with Section 51-1.17, "Finishing Bridge Decks," of the Standard Specifications.

Surface smoothness must vary at most 6 mm from the lower edge of a 3.6 meter  $\pm$  0.06 meter long straightedge placed in any direction.

Taper polyester concrete overlay edges if the overlay is not completed within the allowable lane closure time and is more than 12 mm higher in elevation than the adjacent pavement. Taper edges transverse to the direction of traffic at a 20:1 (horizontal:vertical) slope. Taper edges longitudinal to the direction of traffic at a 4:1 (horizontal:vertical) slope. Tapers may remain and be overlaid with polyester concrete overlay.

## **MEASUREMENT AND PAYMENT**

Furnish polyester concrete overlay will be measured and paid for by the cubic meter. The volume to be paid for will be determined based on the quantity of resin binder used, the percent by weight of resin binder in the polyester concrete, and a unit weight of 2160 kg per cubic meter. The payment quantity shall be the calculated quantity of polyester concrete overlay used in the work, except material used in trial overlays and wasted or unused material. When the plans show that unsound concrete patching material is polyester overlay, the payment quantity will include the patches.

Place polyester concrete overlay will be measured and paid for by the square meter. The area to be paid for will be based on the plan dimensions.

The contract price paid per cubic meter for furnish polyester concrete overlay shall include full compensation for furnishing all labor, materials, tools, equipment, and incidentals, and for doing all the work involved in furnishing polyester concrete, including furnishing HMWM resin prime coat and materials for trial overlays, as shown on the plans, as specified in the Standard Specifications and these special provisions, and as ordered by the Engineer.

The contract price paid per square meter for place polyester concrete overlay shall include full compensation for furnishing all labor, materials, tools, equipment, and incidentals, and for doing all the work involved in constructing the polyester concrete overlay, complete in place, including application of HMWM prime coat and constructing and disposing of trial overlays and base, as shown on the plans, as specified in the Standard Specifications and these special provisions, and as ordered by the Engineer.

Public safety plan will be paid for on the basis of a lump sum price.

The contract lump sum price paid for public safety plan shall include full compensation for furnishing all labor, materials, tools, equipment, and incidentals, including the public action plan and airborne emissions monitoring work performed by the CIH, notification of the public, and reporting test results, complete in place, as shown on the plans, as specified in the Standard Specifications and these special provisions, and as directed by the Engineer.

Modifications to existing bridge deck smoothness will be paid for as extra work as provided in Section 4-1.03D, "Extra Work," of the Standard Specifications.