# MODIFIED URETHANE PAVEMENT MARKING

Updated: 01/17/2024

**Description:** This work shall consist of furnishing, ***laying out*** and applying a reflectorized modified urethane, plural component, durable liquid pavement marking lines, sizes and colors as shown on the plans.

Layout of modified urethane pavement marking lines and symbols will be incidental to the MODIFIED URETHANE PAVEMENT MARKING pay items. Layout and application of pavement markings, especially “hand-work”, shall be done concurrently, to the best of the contractor’s effort, in order to be efficient and to minimize disruption of traffic on busy roads. After the Contractor has laid out the pavement markings, approval must be given from the Engineer prior to the start of permanent striping. ***24 hour notice must be given to the Engineer, for review of layout, prior to the start of placement.***

***For locations/routes/roads longer than 200 feet, a truck mounted spraying device, operated from the same truck that the equipment is mounted from, is required for application. The use of a hand truck for main line pavement markings is to be avoided.***

**Materials:** All materials shall meet the following specifications:

1. Modified Urethane Marking: The modified urethane pavement marking material shall consist of a homogeneous blend of modified urethane resins and pigments designed to provide a simple volumetric mixing ratio of two components (must be two volumes of Part A to one volume of Part B). No volatile solvent or fillers will be allowed.
2. Pigmentation: The pigment content by weight of Component A shall be determined by low temperature ashing according to ASTM D 3723. The pigment content shall not vary more than two percent from the pigment content of the original qualified paint.  
     
   White Pigment shall be Titanium Dioxide meeting ASTM D 476 Type II, Rutile.   
     
   Yellow Pigment shall be Organic Yellow and contain no heavy metals.
3. Environmental: Upon heating to application temperature, the material shall not exude fumes, which are toxic or injurious to persons or property when handled according to manufacturer specifications. The modified urethane pavement marking material compositions shall not contain free isocyanate functionality.
4. Daylight Reflectance: The daylight directional reflectance of the cured modified urethane material (without reflective media) shall be a minimum of 80 percent (white) and 50 percent (yellow) relative to magnesium oxide when tested using a color spectrophotometer with a 45 degree circumferential / zero degrees geometry, illuminant C, and two degrees observer angle. The color instrument shall measure the visible spectrum from 380 to 720 nm with a wavelength measurement interval and spectral bandpass of 10 nm. In addition, the color of the yellow modified urethane shall visually match Color Number 33538 of Federal Standard 595a with chromaticity limits as follows:

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| x | 0.490 | 0.475 | 0.485 | 0.539 |
| y | 0.470 | 0.438 | 0.425 | 0.456 |

1. Weathering Resistance: The modified urethane, when mixed in the proper ratio and applied at 0.35 to 0.41 mm (14 to 16 mils) wet film thickness to an aluminum alloy panel (Federal Test Std. No. 141, Method 2013) and allowed to cure for 72 hours at room temperature, shall be subjected to accelerated weathering for 75 hours. The accelerated weathering shall be completed by using the light and water exposure apparatus (fluorescent UV – condensation type) and tested according to ASTM G 53.  
     
   The cycle shall consist of four hours UV exposure at 50 ºC (122 ºF) and four hours of condensation at 40 ºC (104 ºF). UVB 313 bulbs shall be used. At the end of the exposure period, the material shall show no substantial change in color or gloss.
2. Drying Time: The modified urethane material, when mixed in the proper ratio and applied at 0.35 to 0.41 mm (14 to 16 mils) wet film thickness and with the proper saturation of glass spheres, shall exhibit a no-tracking time of three minutes or less when tested according to ASTM D 711.
3. Adhesion: The catalyzed modified urethane pavement marking materials when applied to a 100 x 100 x 50 mm (4 x 4 x2 in) concrete block shall have a degree of adhesion which results in a 100 percent concrete failure in the performance of this test.

The concrete block shall be brushed on one side and have a minimum strength of 24,100 kPa (3,500 psi). A 50 mm (2 in) square film of the mixed modified urethane shall be applied to the brushed surface and allowed to cure for 72 hours at room temperature. A 50 mm (2 in) square cube shall be affixed to the surface of the modified urethane by means of an epoxy glue. After the glue has cured for 24 hours, the modified urethane specimen shall be placed on a dynamic testing machine in such a fashion so that the specimen block is in a fixed position and the 50 mm (2 in) cube (glued to the modified urethane surface) is attached to the dynamometer head. Direct upward pressure shall be slowly applied until the modified urethane system fails. The location of the break and the amount of concrete failure shall be recorded.

1. Hardness: The modified urethane marking materials, when tested according to ASTM D-2240, shall have a Shore D Hardness greater than 75. Films shall be cast on a rigid substrate at 0.35 to 0.41 mm (14 to 16 mils) in thickness and allowed to cure at room temperature for 72 hours before testing.
2. Abrasion: The abrasion resistance shall be evaluated on a Taber Abrader with a 1,000 gram load and CS-17 wheels. The duration of test shall be 1,000 cycles. The wear index shall be calculated based on ASTM test method D-4060 and the wear index for the catalyzed material shall not be more than 80. The tests shall be run on cured samples of modified urethane material which have been applied at a film thickness of 0.35 to 0.41 (14 to 16 mils) to code S-16 stainless steel plates. The films shall be allowed to cure at room temperature for at least 72 hours and not more than 96 hours before testing.
3. Tensile: When tested according to ASTM D-638, the modified urethane pavement marking materials shall have an average tensile strength of not less than 6,000 pounds per square inch. The Type IV Specimens shall be pulled at a rate of ¼” per minute by a suitable dynamic testing machine. The samples shall be allowed to cure at 75 °F± 2°F for a minimum of 24 hours and a maximum of 72 hours prior to performing the indicated tests.
4. Compressive Strength: When tested according to ASTM D-695, the catalyzed modified urethane pavement marking materials shall have a compressive strength of not less than 12,000 pounds per square inch. The cast sample shall be conditioned at 75°F± 2°F for a minimum of 72 hours before performing the indicated tests. The rate of compression of these samples shall be no more than ¼” per minute.
5. Glass Spheres: The glass spheres shall meet the requirements of Article 1095.04(m) and Article 1095.07 of the Standard Specifications for first drop and second drop glass beads.
6. The material shall be shipped to the job site in substantial containers and shall be plainly marked with the manufacturer’s name and address, the name and color of the material, date of manufacture and batch number.
7. Prior to approval and use of the modified urethane pavement marking materials, the manufacturer shall submit a notarized certification of an independent laboratory, together with the results of all tests, stating these materials meet the requirements as set forth herein. The certification test report shall state the lot tested, manufacturer’s name, brand name of modified urethane and date of manufacture. The certification shall be accompanied by one half-liter (one-pint) samples each of Part A and Part B. Samples shall be sent in the appropriate volumes for complete mixing of Part A and Part B.

After approval by the Department, certification by the modified urethane manufacturer shall be submitted for each batch used. New independent laboratory certified test results and samples for testing by the Department shall be submitted any time the manufacturing process or paint formulation is changed. All costs of testing (other than tests conducted by the Department) shall be borne by the manufacturer.

1. Acceptance samples shall consist of one half-liter (one-pint) samples of Part A and Part B, of each lot of paint. Samples shall be sent in the appropriate volumes for complete mixing of Part A and Part B. The samples shall be submitted to the Department for testing, together with a manufacturer’s certification. The certification shall state the formulation for the lot represented is essentially identical to that used for qualification testing. All, acceptance samples shall be taken by a representative of the Illinois Department of Transportation. The modified urethane pavement marking materials shall not be used until tests are completed and they have met the requirements as set forth herein.
2. The manufacturer shall retain the test sample for a minimum of 18 months.

Application Equipment: The modified urethane pavement marking compounds shall be applied through equipment specifically designed to precisely meter the two components in the ratio of 2:1 and approved by the manufacturer of the material. This equipment shall produce the required amount of heat at the mixing head and gun tip and maintain those temperatures within the tolerances specified. This equipment shall also have as an integral part of the gun carriage, a high pressure air spray capable of cleaning the pavement immediately prior to the marking application.

The equipment shall be capable of spraying both yellow and white urethane, according to the manufacturer’s recommended proportions and be mounted on a truck of sufficient size and stability with an adequate power source to produce lines of uniform dimensions and prevent application failure. The truck shall have at least two urethane tanks each of 415 L (110 gal) minimum capacity and shall be equipped with hydraulic systems. It shall be capable of placing stripes on the left and right sides and placing two lines on a three-line system simultaneously with either line in a solid or intermittent pattern, in yellow or white, and applying glass beads by the double drop pressurized bead system. The system shall apply both the first drop glass beads and the second drop glass beads at a rate of 1.2 kg per L (10 lb./gal). The equipment shall be equipped with pressure gauges for each proportioning pump. All guns shall be in full view of operators at all times. The equipment shall have a metering device to register the accumulated installed quantities for each gun, each day. Each vehicle shall include at least one operator who shall be a technical expert in equipment operations and urethane application techniques. Certification of equipment shall be provided at the preconstruction conference ***and proof of recent calibration and maintenance per manufacture specifications shall be provided prior to commencement of work.***

***Contractor should have well maintained, clean, serviceable equipment on site in order to start operations. Equipment breakdowns should be limited to emergency situations only.***

***A deficiency deduction of $1,000.00 per incident, for excessive breakdowns of equipment, will be applied to monies due to the Contractor, as determined by the Engineer.***

**Application:** The pavement shall be cleaned by a method approved by the Engineer to remove all dirt, grease, glaze or any other material that would reduce the adhesion of the markings with minimum or no damage to the pavement. New PCC pavements shall be blast-cleaned to remove all curing compounds.

Markings shall be applied to the cleaned surfaces on the same calendar day. If this cannot be accomplished, the surface shall be re-cleaned prior to applying the markings. Existing pavement markings shall be at least 90 percent removed. No markings shall be applied until the Engineer approves the cleaning.

Widths, lengths and shapes of the cleaned surface shall be prepared wider than the modified urethane pavement marking material to be applied, such that a prepared area is on all sides of the urethane pavement marking material after application.

New asphalt concrete and seal coated surfaces shall be in place a minimum of two weeks prior to marking applications.

The cleaning operation shall be a continuous moving operation process with minimum interruption to traffic.

The pavement markings shall be applied to the cleaned road surface, during conditions of dry weather and subsequently dry pavement surfaces at a minimum uniform wet thickness of **25 mils (0.64 mm)** in accordance with the manufacturer’s installation instructions. The application and combination of reflective media (glass beads and/or reflective elements) shall be applied at a rate specified by the manufacturer. At the time of installation, the pavement surface temperature shall be 40º F (5˚ C) and rising and the ambient temperature shall be 35º F (2˚ C) and rising. The pavement surface temperature and the ambient temperatures shall be determined and documented before the start of each of marking operation. The pavement markings shall not be applied if the pavement shows any visible signs of moisture or it is anticipated that damage causing moisture, such as rain showers, may occur during the installation and curing periods. The Engineer shall determine the atmospheric conditions and pavement surface conditions that produce satisfactory results.

Unless directed by the Engineer, lines shall not be laid directly over a longitudinal crack or joint. The edge of the center line or lane line shall be offset a minimum distance of 50 mm (2 inches) from a longitudinal crack or joint. Edge lines shall be approximately 50 mm (2 inches) from the edge of pavement. The finished center and lane lines shall be straight, with the lateral deviation of any 3 meter (10-foot) line not to exceed 25 mm (1 inch).

**Notification:** The Contractor shall notify the Engineer 72 hours prior to the placement of the markings in order that an inspector can be present during the operation. At the time of this notification, the Contractor shall indicate the manufacturer and lot numbers of urethane and reflective media that he intends to use. The Engineer will ensure that the approved lot numbers appear on the material package. Failure to comply with this provision may be cause for rejection.

The Contractor shall provide an accurate temperature-measuring device(s) that shall be capable of measuring the pavement temperature prior to application of the material, the material temperature at the gun tip and the material temperature prior to mixing.

The Contractor shall be required to maintain a minimum initial retroreflectivity for all epoxy pavement/modified urethane marking that he/she applies, as follows:

|  |  |  |
| --- | --- | --- |
| Material | Color | Retro reflectivity  (millicandelas/m2/lux) |
| Urethane | White | 300 |
| Urethane | Yellow | 250 |

The Engineer will measure the retro reflectivity a minimum of **twelve (12) hours** after and within **fourteen (14) days** of the application. The Engineer will take a minimum of ten (10) readings per color line, evenly spaced, on a 1,000 meter (0.6 mile) roadway section on all roadways specified in the schedule of quantities for modified urethane pavement marking or as determined by the Engineer. The Engineer will average all of the readings for each color line within the 1,000 meter section of roadway to determine the retro reflectivity. The Contractor shall be required to replace all urethane pavement not meeting the minimum retro reflectivity requirements at no additional expense to this contract.

**Inspection:** The urethane pavement markings will be inspected following installation, but no later than December 15, and inspected following a winter performance period that extends 180 days from December 15 in accordance with the provisions of Article 780.10 of the Standard Specification for Road and Bridge Construction.

**Method of Measurement:** The lines will be measured for payment in feet of urethane pavement marking lines applied and accepted, measured in place. Double yellow lines will be measured as two separate lines. Words and symbols shall conform to the size and dimensions specified in the Manual on Uniform Traffic Control Devices and Standard 780001 and will be measured based on total areas indicated in table 1 or as specified in the plans.

**Basis of Payment:** This work will be paid for at the contract unit prices per foot of applied line for MODIFIED URETHANE PAVEMENT MARKING - LINE 4, 5, 6, 8, 12, 24 inches or per square foot MODIFIED URETHANE PAVEMENT MARKING – LETTERS AND SYMBOLS measured as specified herein.