

**SPECIFICATION**

**PREFORMED THERMOPLASTIC TWO (2) LAYER MARKINGS**

1. **USE:** A durable, high skid resistant, retroreflective pavement marking material suitable for use as a public, private or commercial pavement delineation or marking on asphalt and portland cement concrete surfaces.
  - 1.1. The markings must consist of 2 layers: a top stencil layer over a solid bottom layer of a contrasting color such that the wording or graphic of the stencil layer is easily discernable once placed atop the solid bottom layer.
  - 1.2. The top layer of the markings must be a resilient white, blue or other color thermoplastic product, the surface of which must contain glass beads and abrasives in an alternating pattern. The bottom layer must be a resilient thermoplastic product of a contrasting color. The surface of the bottom layer must be free of drop on beads and abrasive materials. The markings must be resistant to the detrimental effects of motor fuels, lubricants, hydraulic fluids etc.
  - 1.3. Legends are capable of being affixed to bituminous and/or portland cement concrete pavements by the use of the normal heat of a propane torch.
  - 1.4. The markings must be capable of conforming to pavement contours, breaks and faults through the action of traffic at normal pavement temperatures. The markings shall have resealing characteristics, such that it is capable of fusing with itself and previously applied thermoplastic when heated with the torch.
  - 1.5. The markings shall not have minimum ambient and road temperature requirements for application, storage, or handling.
2. **MANUFACTURING CONTROL AND ISO CERTIFICATION:** The manufacturer must be ISO 9001:2008 certified and provide proof of current certification. The scope of the certification shall include manufacture of reflective highway markings.
3. **MATERIAL:** Must be composed of an ester modified rosin resistant to degradation by motor fuels, lubricants etc. in conjunction with aggregates, pigments, binders, abrasives, and glass beads which have been factory produced as a finished product, and meets the requirements of the current edition of the Manual on Uniform Traffic Control Devices for Streets and Highways. The thermoplastic material conforms to AASHTO designation M249-79 (98), with the exception of the relevant differences due to the material being supplied in a preformed state.
  - 3.1. Graded Glass Beads:
    - 3.1.1. The material must contain a minimum of thirty percent (30%) intermixed graded glass beads by weight. The intermixed beads shall be clear and transparent. Not more than twenty percent (20%) consists of irregular fused spheroids, or silica. The index of refraction shall not be less than 1.50.
    - 3.1.2. The top stencil layer of material must have factory applied coated surface beads and abrasives in addition to the intermixed beads at a rate of 1/2 lb. ( $\pm$  20%) per 11 sq. ft. The surface beads and abrasives must be applied in an alternating arrangement across the surface of the material so that the surface is covered in what is best described as a “checkerboard” pattern of glass beads and abrasive materials. The abrasive material must have a minimum hardness of 7 (Mohs scale). These factory applied coated surface beads shall have the following specifications:

Size Gradation		Retained, %	Passing, %
US Mesh	Um		
12	1700	0 - 2%	98 - 100%
14	1400	0 - 6%	94 - 100%
16	1180	1 - 21%	79 - 99%
18	1000	28 - 62%	38 - 72%
20	850	62 - 71%	29 - 38%
30	600	67 - 77%	23 - 33%
50	300	86 - 95%	5 - 14%
80	200	97-100%	0 - 3%

## 2 layer PM SA

- 1) Minimum 80% rounds
- 2) Minimum refractive index of 1.5
- 3) Minimum SiO<sub>2</sub> Content of 70%;
- 4) Maximum iron content of 0.1%;

### 3.2. Pigments:

- 3.2.1. White: The top layer with cut-out lettering and symbols shall be white. The material shall be manufactured with sufficient titanium dioxide pigment to meet FHWA Docket No. FHWA-99-6190 Table 5 and Table 6 as revised and corrected.
- 3.2.2. Blue, Red and Yellow: The bottom layer is typically blue, non-beaded. The material shall be manufactured with sufficient pigment to meet FHWA Docket No. FHWA-99-6190 Table 5 and Table 6 as revised and corrected. The yellow pigments must be organic and must be heavy-metal free.
- 3.2.3. Other Colors: The pigments must be heavy-metal free.
- 3.3. Heating indicators: The top surface of the material (same side as the factory applied surface beads) shall have regularly spaced indents. These indents shall act as a visual cue during application that the material has reached a molten state so satisfactory adhesion and proper bead embedment has been achieved and a post-application visual cue that the installation procedures have been followed.
- 3.4. Skid Resistance: The surface of the preformed thermoplastic material shall contain factory applied non-skid material with a minimum hardness of 7 (Mohs scale). Upon application the material shall provide a minimum skid resistance value of 60 BPN when tested according to ASTM E 303
- 3.5. Dimensions: The top and bottom layers of the two-layer marking are \_\_ inches wide x \_\_ inches long. Other sizes are available.
- 3.6. Thickness: The material must be supplied at a minimum thickness of 90 mils (2.29 mm) for each layer.
- 3.7. Environmental Resistance: The material must be resistant to deterioration due to exposure to sunlight, water, salt or adverse weather conditions and impervious to oil and gasoline.
- 3.8. Abrasives: The abrasives and surface beads must be applied in an alternating arrangement across the surface of the material so that the surface is covered in what is best described as a “checkerboard” pattern of glass beads and abrasive materials. The abrasive material must have a minimum hardness of 7 (Mohs scale).

## 4. **APPLICATION:**

- 4.1. Asphalt: The materials shall be applied using the propane torch method recommended by the manufacturer. The material must be able to be applied without minimum requirements for ambient and road temperatures and without any preheating of the pavement to a specific temperature. The material must be able to be applied without the use of a thermometer. The pavement shall be clean, dry and free of debris. Supplier must enclose application instructions with each box/package.
- 4.2. Portland Concrete: The same application procedure shall be used as described under Section 4.1. However, a compatible primer sealer may be applied before application to assure proper adhesion.
5. **PACKAGING:** The preformed thermoplastic markings shall be placed in protective plastic film with cardboard stiffeners where necessary to prevent damage in transit. Linear material must be cut to a maximum of 3' long pieces. Legends and symbols must also be supplied in flat pieces. The cartons in which packed shall be non-returnable and shall not exceed 40" in length and 25" in width, and be labeled for ease of identification. The weight of the individual carton must not exceed seventy (70) pounds. A protective film around the box must be applied in order to protect the material from rain or premature aging.
6. **TECHNICAL SERVICES:** The successful bidder shall provide technical services as required.
7. **PERFORMANCE:** The preformed thermoplastic markings shall meet state specifications and be approved for use by the appropriate state agency.