

# **IGGA Guide Specification: Conventional Diamond Grinding for Pavement Preservation**

## **Introduction**

This standard developed, by the International Grooving and Grinding Association (IGGA), specifies the procedures for Conventional Diamond Grinding for Pavement Preservation. The user of this standard shall be responsible to ensure that all local safety, health and environmental standards are made a part of the specifications.

The user of this standard accepts ALL responsibility for decisions made as a result of its use. The International Grooving and Grinding Association, its Officers, Board of Directors and staff are absolved of any responsibility for any decisions made as a result of its use. Use of this standard implies acceptance of the terms of use.

# **Guide Specification: Conventional Diamond Grinding for Pavement Preservation**

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## **SCOPE**

This standard specifies the procedures for operations of continuous diamond grinding Portland cement concrete or asphalt concrete pavement and roadway surfaces to provide desired surface characteristics such as ride, friction and drainage. This standard does not apply to corrective bump grinding. The standard also provides guidelines for levels of acceptance for the desired surface characteristics. The user of this standard shall be responsible to ensure that all local safety, health and environmental standards are made a part of the project specification.

Conventional diamond grinding is also utilized to reduce the noise created by the interaction of the tire with the pavement surface in areas of low to moderate noise concern. When grinding solely for noise reduction, it is important to completely remove the existing surface texture such as transverse tining. The profile requirements stated elsewhere in this specification may not apply to grinding solely for noise abatement. In areas of high tire/pavement noise concern and speed limits above 45 mph, the pavement should be ground in accordance with the specification for the Next Generation Concrete Surface (NGCS) grinding.

## **EQUIPMENT**

Grinding shall be performed using diamond blades mounted on a self-propelled machine designed for grinding and texturing pavement. The grinding equipment shall be at a minimum 35,000 pounds including the grinding head, and of a size that will grind a strip at least 3 feet wide. The effective wheel base of the machine shall be no less than 12 feet. The effective wheel base is defined as the distance from the front wheel assembly transverse pivot point to the transverse pivot point of the profile/depth control/ ground drive wheels.

The equipment shall have a positive means of vacuuming the grinding residue from the pavement surface, leaving the surface in a clean, near-dry condition.

Grinding equipment that causes raveling, aggregate fractures or disturbance to the joints shall not be permitted.

The equipment shall be maintained to ensure it is in proper working order, with attention paid to the "roundness" of the match and depth control wheels. Any wheels found to be out of round shall be immediately replaced.

## **CONSTRUCTION**

The construction operation shall be scheduled and proceed in a manner that produces a neat, uniform finished surface. Shoulder, auxiliary or ramp lane grinding shall transition from the edge of

the mainline as required to provide drainage leaving no more than a 3/16-inch ridge and an acceptable riding surface. Full- and partial-depth concrete repairs, slab stabilization and dowel bar retrofit shall be completed prior to any grinding. Joint sealing shall be completed subsequent to the diamond grinding operations.

Grinding shall be accomplished in a manner that eliminates joint or crack faults so there is no more than a 1/16-inch differential between the adjacent sides of the joints and cracks. Grinding shall also substantially remove pavement conditions such as warp and curl to provide an acceptable ride.

Lateral drainage shall be achieved by maintaining a constant cross slope between grinding extremities in each lane. The finished cross slope shall mirror the pregrind cross slope and shall have no depressions or misalignment of slope greater than 1/4-inch in 12 feet when measured with a 12-foot straightedge placed perpendicular to the centerline. Steps will be taken to ensure that wheel path rutting is substantially removed and that the grinding operation is simply not texturing the wheel path depressions. Areas of deviation shall be reground. Straightedge requirements will not apply across longitudinal joints or outside the ground area.

Grinding shall begin and end at lines normal to the pavement centerline at the project limits. Passes of the grinding head shall not overlap more than 1-inch. No unground surface area between passes will be permitted.

### **FINAL SURFACE FINISH**

The grinding process shall produce a pavement surface that is true in grade and uniform in appearance with longitudinal line-type texture. The line-type texture shall contain corrugations parallel to the outside pavement edge and present a narrow ridge corduroy type appearance. The peaks of the ridges shall be 1/8-inch +/- 1/16-inch higher than the bottom of the grooves with evenly spaced ridges.

It shall be the contractor's responsibility to select the number of blades per foot to be used to provide the proper surface finish for the aggregate type and concrete present on the project. The number of blades used for grinding will range between 50 - 60 blades per foot as necessary to provide the designated texture. Harder aggregate may require the use of 55 – 60 blades per foot. The engineer may require removal of unbroken fins at the contractor's expense. The project conditions may dictate that the contractor has to make multiple passes with the equipment to meet the specifications. It is the contractor's responsibility to determine the proper sequence of operations to meet the specification. If multiple passes of the grinding equipment are required, the area will only be considered for payment once. A minimum of 95 percent of any 100-foot section of pavement surface shall be textured. Depressed pavement areas due to subsidence or other localized causes will be exempted from texture and smoothness requirements.

### **SLURRY HANDLING AND REMOVAL**

Slurry shall be collected, processed and disposed off in accordance with the IGGA Diamond Grinding Slurry Handling--Best Management Practices - April 2013. This document is available on the web at [www.igga.net](http://www.igga.net).

## SMOOTHNESS REQUIREMENTS

An initial smoothness index of representative portions of the project may be available through the project contact person upon written request. When available, this information represents the conditions that existed at the time the survey was made. The contractor is cautioned to note the date the survey was made since the conditions may have changed over time. This profile is for informational purposes only, to give the contractor an idea of the conditions that existed at the time of the survey. The contractor assumes the risk of error if the information is used for any purpose other than as stated. Contractors are responsible for visiting the project site to make their own condition determination prior to bidding.

Prior to performing any grinding work, the contractor shall provide a control profile developed using an inertial profiler with a laser that simulates the tire footprint. Single point lasers shall not be used. Line laser equipment such as RoLine™, Gocator™ or an approved equal shall be used. All equipment shall have current certification and be approved by the contracting authority.

The control profile will be used to identify the required smoothness for the project as indicated in Table 1. The control profile will be obtained after any and all corrective work which impacts the pavement roughness such as slab repairs, DBR, pothole repair, etc. The profile will be obtained in 0.1 lane mile long segments (528 feet), and the location of each segment accurately established, either through stationing or GPS coordinates.

The finished surface shall have a final MRI improvement in accordance with Table 1 and grinding will not be considered acceptable until the smoothness requirements are achieved. It is important that the segment locations from the control profile match the segment locations tested in the smoothness acceptance measurements. Price adjustments for exceeding the requirements are indicated in Table 2.

**TABLE 1 SMOOTHNESS REQUIREMENTS**

Posted Speed Limit (mph)	< 45		≥ 45	
	≤ 330	> 330	≤ 185	> 185
Required Post Grind MRI	≤ 115	≤ 0.35*(Existing Segment MRI)	≤ 65	≤ 0.35*(Existing Segment MRI)

Depressed pavement areas due to subsidence or other localized causes will be excluded from the smoothness requirements. These areas shall be reviewed and approved by the engineer.

The contractor shall measure profiles in both wheel paths and average the resulting IRI to determine acceptance (i.e. MRI). The profiles shall be measured 3 feet from each lane line. A guide shall be used to ensure proper alignment of the profile. The engineer shall have a representative with the inertial profiler during all testing periods. This representative shall sign the resulting profile form.

The engineer shall conduct comparison profiles on no less than 10 percent of the segments using the same type of certified equipment as the contractor. When light weight profilers are used, it is of great importance that a proper guide is used to ensure that all testing is completed over the same track. The contractor and agency testing should be completed during the same time of day and

under similar climatic conditions. The results of these verification profiles shall not vary more than 10 percent from the contractor profiles.

The engineer may choose to accept isolated sections if the variance between the two profiles is less than 15 percent. When the difference exceeds 15 percent on an isolated basis or 10 percent on a consistent basis, referee testing will be required to determine which device is providing an accurate evaluation of the pavement surface. The party found to have the inaccurate equipment will pay for the referee testing. The engineer may choose to withhold payment for segments that do not meet these criteria until the problem is resolved. The engineer may choose to obtain verification profiles on the entire project if the comparison profiles are constantly outside the allowable tolerance. The engineer will charge for the additional testing if the contractor's operation is found to be in error. Segments found not meeting the smoothness requirements will require regrinding at no additional cost to the department.

For roadways with posted speeds less than 45 mph, the finished ground surface shall not include any bumps exceeding 0.3-inch in 25 feet. For roadways with posted speeds of 45 mph or more, the localized roughness (IRI) will be less than or equal to 125 inches per mile, when determined using the ProVAL Assurance Module with a 25 ft baseline.

The conditions of smaller municipal projects may not be suited for the above type of smoothness requirements. In these cases, the only smoothness requirement may be 1/8-inch variance in a 12-foot straightedge test.

### **METHOD OF MEASUREMENT**

Grinding will be measured by the square yard of area diamond ground. The measurement will be the final textured surface area regardless of the number of passes required to achieve acceptable results. Minor areas of unground pavement within the designated areas to be ground will be included in the measurement. When conditions require a feather pass into the shoulder or auxiliary or ramp lanes, payment will be by the square yard based on a width of 2 feet times the length of the required feather pass. The minimum length of feather pass will be 100 feet. Areas which were not designated to be diamond ground will not be measured for smoothness.

### **BASIS OF PAYMENT**

Grinding will be paid for at the contract price per square yard. Payment shall be full compensation for all labor, equipment, material and incidentals to complete this work, including hauling and disposal of grinding residue.

**TABLE 2 RECOMMENDED PRICE ADJUSTMENTS**

<b>Posted Speed &lt; 45 mph</b>		<b>Posted Speed ≥ 45 mph</b>	
<b>MRI (in./mi.)</b>	<b>\$/ Sq. Yd.</b>	<b>MRI (in./mi.)</b>	<b>\$/ Sq. Yd.</b>
<b>0-79</b>	<b>\$1.13</b>	<b>0-45</b>	<b>\$1.01</b>
<b>80-90</b>	<b>(90-MRI)*0.1125</b>	<b>45-54</b>	<b>(54-MRI)*0.1125</b>
<b>≥ 91</b>	<b>0</b>	<b>&gt; 54</b>	<b>0</b>