

MICHIGAN
DEPARTMENT OF TRANSPORTATION

SPECIAL PROVISION
FOR
THIN EPOXY POLYMER BRIDGE DECK OVERLAY

STM:JDC

1 of 5

APPR:JAB:BDZ:03-24-25

FHWA:APPR:03-24-25

a. Description. This work consists of cleaning/preparing entire deck surface and applying a two-coat epoxy overlay. Ensure all work is completed in accordance with section 712 of the Standard Specifications for Construction except as modified herein. Bring any discrepancies between the two to the attention of the Engineer.

b. Materials. Use a solvent-free, moisture insensitive, 100 percent solids, low-modulus, and two-component epoxy system to overlay the structure. Ensure containers are marked clearly "Part A" or "Part B". The epoxies that are approved for thin overlays are in Table 1.

Table 1: Approved Two Component 100 Percent Solids Epoxy Systems

Supplier	Product	Telephone
BASF	MasterSeal 350	(800) 433-9517
E-Bond	526 Lo-Mod	(616) 532-0782
E-Chem	EP50	(505) 217-2121
Euclid Chemical	Flexolith Flexolith Summer Grade Flexolith HD	(800) 321-7628
Poly-Carb	Flexogrid Mark – 163 Flexogrid Mark - 154	(817) 797-1113
Sika	Sikadur 22-Lo Mod	(248) 866-8956
Transpo	T-48 Chip Seal	(573) 808-1040
Unitex	Propoxy Type III DOT	(800) 745-3700

Ensure aggregate meets the gradation requirements in Table 2 and has a hardness of seven or higher on the Mohs hardness scale. Ensure aggregate is angular, consists of natural silica sand, basalt, or other nonfriable aggregate, and contains less than 0.2 percent moisture when tested in accordance with *ASTM C566*.

Table 2: Angular Aggregates Gradation Requirements

Sieve Size	Minimum % Passing	Maximum % Passing
3/8	100	100
4	98	100
8	30	75
16	0	5
30	0	1
Pan	0	0

Furnish a general certification per the *MQAP Manual* to the Engineer that the aggregate meets the requirements specified herein.

c. Equipment. For the epoxy overlay, furnish a distribution system or distributor capable of accurately blending the epoxy resin and hardening agent, and uniformly and accurately applying the epoxy materials at the specified rate to the bridge deck in such a manner as to cover 100 percent of the work area including a minimum of 1 inch of the vertical face of curb/barrier. Furnish a fine aggregate spreader capable of uniformly and accurately applying dry aggregate to cover 100 percent of the epoxy material. Furnish a self-propelled vacuum truck.

For hand applications, furnish calibrated containers, a Jiffy® type mixer, and 1/4 inch notched squeegees which are suitable for mixing and applying the epoxy and aggregate.

For mechanical applications, furnish mixing equipment that will automatically and accurately proportion the components in accordance with the manufacturer's recommendations, mix and continuously place the epoxy overlay. Ensure the operation proceeds in such a manner that will not allow the mixed material to segregate, dry, be exposed or otherwise harden in such a way as to impair the retention and bonding of broadcasted aggregate.

d. Construction.

1. Surface Preparation. The Engineer will inspect patching and cleaning operations. The Engineer's approval is required prior to placement of the overlay. Protect utilities, drainage structures, curbs, bridge joints, and any other structure within or adjacent to the epoxy overlay from surface preparation activities and application of the surface treatment materials. For the purposes of this special provision, the term *bridge joints* does not include sawed construction joints.

Verify that the compressed air used for any work is free of oil and moisture contamination in accordance with *ASTM D4285*. Use either an absorbent or a nonabsorbent white collector positioned within 24 inches of the air-discharge point, centered in the air stream. Allow air to discharge onto the collector for a minimum of 1 minute. Visually examine the collector for the presence of oil and/or water. Conduct the test at least one time per shift for each compressor system in operation in the presence of the Engineer. If air contamination is evident, make adjustments to achieve clean, dry air. Examine the work performed since the last acceptable test for evidence of defects or contamination due to contaminated compressed air. Repair contaminated work at no additional cost to the contract.

Do not perform surface preparation or installation of epoxy overlay on concrete less than 28 days of age. Ensure that traffic paint lines and surface texturing or grooving are completely removed. Clean the entire concrete surface by shotblasting to remove all materials that may interfere with the bonding or curing of the binder utilizing a minimum steel shot size of S-460. Ensure areas that cannot be shotblasted are cleaned by abrasive blasting (i.e. areas adjacent to expansion, drainage structures, curb/barrier interface). The cleaned concrete surface must meet the *International Concrete Repair Institute Guideline 310.2R, Selecting and Specifying Concrete Surface Preparation for Sealers, Coatings, Polymer Overlays and Concrete Repair, CSP 7*. To ensure prepared surface is adequate for epoxy adhesion, perform a direct tension test per *ASTM C1583/C1583M*. Perform one direct tension test for every 400 square yards of overlay area. Ensure minimum bond strength is 250 psi for the surface preparation to be considered adequate. Use a vacuum truck or oil-free moisture-free air blast to remove all dust

and other loose material. Brooms are prohibited. Remove any oil or other contamination after initial cleaning.

Ensure both courses of epoxy overlay are applied within 24 hours of the final cleaning, and prior to opening the area to traffic.

No visible moisture can be present on the surface of the concrete at the time of epoxy overlay application. Oil-free moisture-free compressed air may be used to dry the deck surface. Use a plastic sheet left taped in place in accordance with *ASTM D4263* to identify moisture in the epoxy overlay area except as modified herein. Tape an 18 inch by 18 inch transparent polyethylene sheet (4 mil) to the deck every 500 square feet. Ensure all edges are sealed with tape that will stick to the concrete substrate. Leave the plastic sheet in place for a minimum of 3 hours or the manufacturer's recommended cure time for the conditions, whichever is longer. Ensure there is no moisture visible on the polyethylene sheet. Ensure alternate methods to detect moisture are approved by the Engineer.

Remove all debris from the bridge joints. Protect the bridge joints, and any other areas not to be overlaid, from damage during preparation of the surface. Ensure the protection is removed once the epoxy and aggregate has been applied and prior to initial set. Ensure removing the protection is done soon enough to in no way harm the adjacent overlay. Ensure protection is applied again prior to the second coat and removed again prior to initial set as to not damage adjacent surfaces. Ensure the protection meets the approval of the Engineer.

2. Application. Ensure handling and mixing of the epoxy resin and hardening agent is performed in a safe manner to achieve the desired results in accordance with the manufacturer's recommendations for a two-coat system or as directed by the Engineer. Do not place epoxy overlay materials when the concrete surface is less than 50 °F or ambient air temperature is forecast to fall below 50 °F within 8 hours of application. Do not place epoxy overlay materials if weather or surface conditions are such that the material cannot be properly handled, placed, and cured in accordance with the manufacturer's requirements and the specified requirements of traffic control.

Apply the epoxy overlay in two separate courses in accordance with the manufacturer's recommendation for a two-coat system with the following rate of application. Ensure the first course is no less than 2½ gallons per 100 square feet. Ensure the second course is no less than 5 gallons per 100 square feet.

Ensure application of aggregate to both the first and second courses is of sufficient quantity so the entire surface is covered in excess. Ensure no bleed through, or wet spots are visible in the overlay. Remove and replace any areas within course applications with wet spots or where epoxy has bled through.

After the epoxy mixture has been prepared for the overlay, immediately apply it to the surface of the bridge deck with a 1/4 inch notched squeegee. Use the notched squeegee to push a pool of epoxy uniformly across the bridge deck. Apply the dry aggregate in such a manner as to cover the epoxy mixture completely within 5 minutes of application. Minimize all foot traffic on the uncured epoxy and ensure any foot traffic will only be done with steel spiked shoes approved by the Engineer. Cure each course of epoxy overlay until vacuuming or brooming can be performed without tearing or damaging the surface. Do not allow traffic or equipment on the overlay surface during the curing period. Remove by vacuuming or brooming all loose aggregate after the first course curing period. Immediately apply the next overlay course to

complete the overlay. Ensure the minimum curing periods are in accordance with the manufacturer's recommendations, as shown in Table 3, or as directed by the Engineer. Remove by vacuuming or brooming all loose aggregate after the second course curing period. Ensure all bridge joints are free of loose aggregate, epoxy and other debris resulting from overlay operations. Excess aggregate may be reused if it is clean, dry, free from foreign matter, and meets gradation requirements. Blend the excess aggregate at a ratio of 3 parts virgin material to 1 part recycled material. Inspect aggregate recovery equipment prior to reclamation operation to prevent the introduction of foreign material. Collect excess aggregate within 24 hours of placement. Do not collect excess aggregate that has been rained on or driven on.

Table 3: Anticipated Cure Time (Hours)

Average Temperature of Deck, Epoxy and Aggregate Components, °F	1 st Course	2 nd Course
<60		(a)
60-64	2	2
65-69	2	2
70-74	1.75	1.75
75-79	1.75	1.75
80-84	1.5	1.5
>85	1	1
a. Ensure the second course is cured for a minimum of 8 hours if the air temperature drops below 60 °F during the curing period, or per the manufacturer's recommendations.		

Plan and execute the work to provide the minimum curing periods as specified in Table 3, or other longer minimum curing periods as recommended by the manufacturer prior to opening to public or construction traffic, unless otherwise permitted. Ensure first course applications are not opened to traffic. Remove any contamination, detrimental to adhesion of the second course, from the first course at the Contractor's expense prior to the application of the second course.

Remove and replace any areas damaged or marred by the Contractor's operations in accordance with this special provision. All cost associated with this work will be borne by the Contractor.

Remove and replace areas as directed by the Engineer and in accordance with 20SP-712D – Removal of Thin Epoxy Polymer Bridge Deck Overlay.

Furnish the Engineer with all records including, but not limited to, the following for each batch provided:

- batch numbers and sizes,
- location of batches as placed on deck, referenced by stations,
- epoxy yield, referenced by stations,
- batch time,
- temperature of air, deck surface, epoxy components, including aggregates,
- loose aggregate removal time, and
- time open to traffic.

3. Clean Up. At the end of the project or a minimum 7 days after the epoxy polymer

overlay has cured, remove, and dispose all loose aggregate that has shed from the epoxy binder by vacuuming or brooming. Do not re-use this aggregate.

e. Measurement and Payment. The completed work, as described, will be measured and paid for at the contract unit price using the following pay item:

Pay Item	Pay Unit
Epoxy Ovly	Square Yard

Epoxy Ovly includes preparing and cleaning the concrete surface, preparing and applying a two-coat epoxy overlay system on the concrete surface, and including miscellaneous clean-up. This pay item also includes cleaning and protecting bridge joints.