

**Maricopa Association of Governments
Uniform Standard Specification
for
Cement Treated Base
Section 312—2020 Edition**

Compliments of



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SECTION 312

CEMENT TREATED BASE

312.1 DESCRIPTION:

Cement treated base shall consist of a combination of base material and Portland cement as specified in Section [705](#).

312.2 GENERAL:

When the mixing of cement treated base in a stationary mixer is required, it will be so specified. Otherwise, cement treated base may be mixed in either a traveling plant or in a stationary plant, at the option of the Contractor.

If the cement treated aggregate is mixed in a central plant, it shall not contain moisture in excess of 1 percent above or below optimum at the time of delivery on the grade. Certain types of transit mixers will not discharge such material unless it is greatly in excess of optimum moisture. Use of such mixers will not be permitted.

If the material is mixed in place, the machine or combination of machines used shall be capable of thoroughly mixing the cement and aggregate, when using the granular material specified, in a single pass. No lift thickness shall exceed 8 inches. If the thickness required is in excess of 8 inches, it shall be mixed in two separate lifts of equal thickness.

312.3 CONSTRUCTION METHODS:

Mixing of materials, regardless of the type of mixer used or method employed shall be continued until the cement and water are evenly distributed throughout the aggregate, and a mixture of uniform appearance is obtained.

The amount of cement used shall conform to requirements of Section [705](#). Cement delivered in standard sacks from commercial producers will be assumed to weigh 94 pounds per sack and need not be weighed. Bulk cement or fractional sacks of cement shall be weighed.

The amount of water used shall be that required to give optimum moisture content. A portion of the required water may be added to the aggregate prior to the addition of the cement, if approved. Moisture content of the material delivered to the grade shall be checked for moisture content a minimum of four times per shift using AASHTO T-217. Batch adjustments shall be made as necessary to correct for deficiencies.

After spreading, the cement treated base shall be compacted to a density of at least 95 percent of the maximum density as determined by the mix design. Density testing shall be performed using ASTM [D6938](#), with moisture content periodically corrected in accordance with AASHTO T-217.

Compressive strength of the cement treated base material shall be tested a minimum of twice per shift using Arizona ARIZ-241. Strength specimens shall be compacted on site and protected from moisture loss or disturbance by any practical means. Specimens shall be kept in this manner on site for 18-24 hours inside a hard outer-shelled container that will protect the specimens from external environmental elements. The specimens shall be carefully transported to the laboratory for moist curing after this initial 18-24 hour cure.

After compaction, the surface of the cement treated base course shall not deviate at any point more than 3/8 inch from the lower edge of a 10-foot straightedge laid parallel to the centerline of the roadway.

A construction joint shall be made at the end of each day's construction by trimming the end of the compacted mixture to a straight vertical plane, normal to the centerline of the roadway and with the vertical edge in thoroughly compacted material.

Cement shall not be added to more material than will be mixed, compacted and sealed the same day. Cement treated base shall not be mixed or placed when either the aggregate or subgrade is frozen. The air temperature shall be at least 40°F. in the shade and rising at the time of mixing.

In areas that are inaccessible to the mixing, spreading, or compacting equipment designated herein, other methods and equipment acceptable to the Engineer may be utilized.

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The mixed material shall not remain undisturbed on the subgrade for more than 30 minutes, not more than 3 hours shall elapse between the time water is added to the mixture, and final compaction is accomplished.

The mixed materials shall be spread for the full width of the base under construction, either by one spreader or by several spreaders operating in a staggered position across the subgrade, unless permission is granted to do part-width construction. Should permission be granted for part-width construction, not more than 30 minutes shall elapse between the times of placing the material in adjacent lanes at any location, and the longitudinal joint against which additional mixed material is to be placed shall be trimmed to a straight vertical plane parallel to the centerline of the roadway. Trimming shall be done in such a manner as to cause the least possible loosening of the compacted base material and to leave no loose material on the subgrade. The material cut away in trimming may be used in the construction of the shoulders or the adjacent lanes if approved, or shall be disposed of in a satisfactory manner.

During mixing, spreading and compacting and until the application of the curing seal, any moisture lost by evaporation shall be replaced by the addition of water by means of a light fog or fine spray.

The mixed base materials shall be covered as soon as possible after final compaction and shall be cured in accordance with this specification.

312.4 TRAVELING PLANT MIXING:

312.4.1 Placing Aggregate: The aggregate to be treated shall be placed on the roadway either as a uniform layer that, when compacted, will produce a base of the depth and width shown on the plans or as one or more windrows that, when spread, will yield a uniform layer which will compact to the prescribed dimensions. If the aggregate is placed in one or more windrows, a windrow sizer will be required. The number and size of the windrows may vary, depending on the width and depth of treatment and on the capacity of the machine, but regardless of size, the windrow shall be uniform in cross-section and shall not be larger than can be handled by the plant.

Care shall be exercised during the placement of the aggregate to prevent segregation of the fine and coarse portion of the aggregate.

312.4.2 Placing Cement: Cement shall be added to the uniform layer or windrow of aggregate by means of mechanized equipment, which will spread the cement in correct and uniform quantities. For any section of roadway, the quantity of cement placed by mechanical spreaders shall not deviate more than 10 percent from the computed quantity for the section. When cement is applied to a windrow, the top of the windrow shall be slightly trenched to retain the spread of cement.

If storm winds cause a loss of spread cement, spreading operations shall be halted until such winds subside and, at the first indication of losses, prompt action shall be taken to avoid further losses. If cement losses are deemed excessive, the deficient quantity shall be furnished and added in the proper amount by the Contractor at no additional cost to the Contracting Agency.

312.4.3 Mixing: Mixing shall be accomplished by means of an approved single pass traveling continuous mixing machine, or combination of machines, of the pug or auger type. The machine shall be so constructed that the device for picking up or mixing the aggregate can be controlled, and during the mixing operations, it shall be set to mix the aggregate, cement and water to the design depth without cutting into or disturbing the subgrade or picking up any material other than that material to be processed. The machine shall be equipped so that water may be introduced at the time of mixing through a metering device, which will accurately and uniformly control and measure the amount of water being used.

The cement and aggregate shall be mixed in the machine simultaneously with the adding, through the machine, of the additional amount of water required.

The material shall be spread immediately after mixing, in reasonably close conformity to the lines, grades and dimensions established or shown on the plans.

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312.4.4 Stationary Plant Mixing: If the stationary plant method of mixing is employed, the aggregate, cement and water shall be mixed at a central plant using either a batch pug mill type or a continuous type mixer. Dead areas in the mixer, in which the material does not move or is not sufficiently agitated, shall be corrected, either by a reduction in the weight of materials or by other adjustments.

312.4.5 Batch Mixing: If a batch pug mill type mixer is used, the aggregate and cement shall be proportioned by batch weights. Cement shall be weighed on separate scales from the aggregate batching scales.

The weight of the charge in a batch mixer shall not exceed that which will permit complete mixing of all materials. The period of mixing shall not be less than 30 seconds from the time all materials are in the mixer. Water may be proportioned by volume or by weight.

312.4.6 Continuous Mixing: If a continuous type mixer is used, the materials shall be proportioned by volume.

The continuous type mixer shall be equipped with metering devices and feeders, which will introduce the cement, aggregate, and water into the mixer in the specified proportions. The water pump shall be equipped with a means of varying the rate of delivery. The metering devices and feeders shall be interlocked and so synchronized as to maintain a constant ratio of cement and water to the aggregate.

The rate of feed to a continuous type mixer shall not exceed that which will permit complete mixing of all the material.

312.4.7 Spreading: The treated material shall be transported from the plant to the prepared subgrade in approved equipment.

The surface on which the material is to be placed shall be thoroughly moistened and kept moist, but not excessively wet, until covered by the material.

Plant mixed cement treated base shall be spread by approved spreader boxes or finishing machines. The machines shall be constructed and operated so as to produce a layer of uniform density and cross-section in sufficient quantity to provide a compacted base reasonably conforming to the lines, grades and cross-sections established or shown on the plans.

312.4.8 Compacting: Initial compaction shall begin immediately after mixing and spreading. Successive passes of compacting equipment shall overlap the previous adjacent pass by at least 25 percent of its width. Following initial compaction and before final compaction, the treated material shall be bladed with a motor grader or a Planning machine to obtain a surface reasonably true to the lines, grades and cross-sections established or shown on the plans. During and immediately following the shaping operations, if required, the Contractor shall lightly scarify the surface with a nail drag or other approved equipment to prevent the formation of surface compaction planes.

Extreme care shall be exercised by the Contractor during the blading operation so that no more material than is necessary is disturbed and so that this operation can be completed as quickly as possible. Material thus cut shall be wasted if so directed. Compaction shall proceed without interruption, except as stated above, until the required degree of compaction is obtained.

312.5 INVERTED SECTION:

Where the cement treated base is to be covered with an aggregate base material to prevent shrinkage crack reflection and overloading of the cement treated base, the minimum thickness of the aggregate base shall be 4 inches, unless otherwise specified in the special provisions. In order to provide for free internal drainage of the aggregate base course overlaying the cement treated material, it shall be non-plastic and the percentage of material passing the No. 200 sieve shall not exceed 8. The cement treatment shall be held back approximately 1 foot from each curb line so as to permit drainage of any water that may become trapped between the cement treated base material and the bituminous surfacing.

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312.6 CURING:

The mixed cement treated base materials shall be covered as soon as possible after final compaction with a bituminous curing seal. Application shall be by means of a pressure distributor in accordance with the requirements of Section [330](#). The approximate quantity of bituminous material to be used shall be as specified; however, the exact amount will be determined by the Engineer at the time of application.

After the bituminous curing seal has been applied, the cement treated base course shall be kept free of equipment and traffic for a period of at least 7 days or until it will not pick up under traffic. Curing seal shall conform to the requirement of Section [712](#) or [713](#) for the type specified.

In lieu of the curing seal, the Contractor may, at his option, keep the surface of the compacted base continuously moist until overlaid with the aggregate base course. The aggregate base or the surfacing may be placed as soon as the cement treated base has been compacted. The spray equipment on the water truck shall be approved by the Engineer prior to the use of this equipment to spray the soil cement base course. The spray equipment must produce a fine, even spray to prevent washing of the surface of the base course. A cement treated section may be opened to all traffic immediately after placement and compaction of the surfacing.

312.7 DEFICIENCY:

When, in the opinion of the Engineer, there is reason to believe that a deficiency in thickness exists in the cement treated base, cores will be taken in the same pattern as that defined in Section [321](#). If the base has been covered or it is otherwise impractical to correct the deficiency of ½ inch or more in thickness, the corrective measure listed in Table [310-1](#) for Type II deficiency shall be taken by the Contractor at no additional cost to the Contracting Agency.

312.8 PAYMENT:

Payment for the Portland cement will be made by the tons of cement complete in place.

Payment for base material will be made by the tons of aggregate complete in place including mixing, spreading, and compacting.

No separate payment will be made for curing.

- End of Section -