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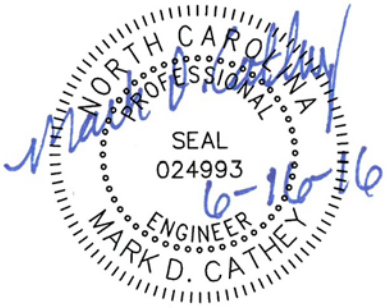
SITE SPECIFIC CONSTRUCTION QUALITY ASSURANCE PLAN

MACON COUNTY MSW LANDFILL
PERMIT TO CONSTRUCT
PHASE 3 CELL 1
MACON COUNTY, NORTH CAROLINA

MARK D. CATHEY, P.E.



McGill ASSOCIATES

Engineering • Planning • Finance
Asheville, North Carolina

JUNE 2015

13.00726

SITE SPECIFIC CONSTRUCTION QUALITY ASSURANCE PLAN

Macon County MSW Landfill
Macon County, North Carolina
Phase 3 Cell 1

This Construction Quality Assurance Plan has been prepared as required under Rule .1617 and in accordance with Rule .1621.

1.0 INTRODUCTION

1.1 Project Background

The Macon County MSW Landfill Site is the current MSW landfill for Macon County. The current project involves the construction of a 7.6-acre expansion referred to as Phase 3 Cell 1. Phase 3 Cell 1 will be constructed to provide approximately 5 years of landfill airspace for the County. Phase 3 Cell 2 will be constructed and brought on line as Phase 3 Cell 1 nears operational capacity. Macon County began receiving wastes in 1993 Phase 1 Cell 1. The current active waste area, Phase 2 Cell 2, began operation in 1999. This project is a standalone MSW Cell. The Phase 3 Cell 1 Project will consist of structural fill to achieve the desired gradients followed by a compacted, low-permeability clay liner layer, a low-permeability geocomposite clay liner, a 60-mil high density polyethylene (HDPE) geomembrane liner, and an aggregate drainage layer. The Macon County Landfill site is located in Macon County at 1448 Lakeside Drive (S.R. 1324).

1.2 Project Scope

The purpose of this Site Specific Construction Quality Assurance Plan (SSCQAP) is to provide guidance to McGill Associates and sub-contractor personnel on required documentation activities during the construction of the engineered Phase expansion. This guidance is intended to ensure that construction meets the requirements of Macon County and the Project Construction Quality Assurance (CQA) Plan and project drawings and specifications.

The overall goals of the SSCQAP are to ensure that proper construction techniques and procedures are used to verify that the materials and installation techniques used meet Project CQA Plan and project drawings and specifications. Additionally, the program will identify and define problems that may occur during construction and ensure that these problems are corrected before the construction is complete. At completion of work, the program will culminate in a certification report, which documents that, the structural fill, clay liner, geosynthetic liners, geotextiles, drainage/ protective layer, and leachate

collection piping have been constructed in substantial compliance with this SSCQAP and project drawings and specifications. and the geosynthetic liners have been constructed in substantial compliance with this SSCQAP and project drawings and specifications. The primary emphasis of the SSCQAP is careful documentation during the preparation and placement of the clay and the geosynthetic liner.

1.2.1 Scope of Services

The Scope of Services provided by CQA Consulting Firm for the construction of engineered base is as follows:

1. Pre-Construction materials evaluation (structural fill, clay liner, geosynthetics).
2. Structural Fill observation, testing, documentation, and verification of construction procedures.
3. Clay liner or geosynthetic clay liner (GCL) observation, testing, documentation, and verification of construction procedures.
4. Geosynthetic observation, testing, documentation, and verification of construction procedures.
5. Geotextile observation, testing, documentation, and verification of construction procedures.
6. Granular drainage and Protective Layer observation, testing, documentation, and verification of construction procedures.
7. Leachate collection piping observation, testing, documentation, and verification of construction procedures.
8. Provide CQA Report and CQA Certification that Phase 3 was constructed in accordance with this SSCQAP.

1.2.2 Construction Schedule

Construction of Phase 3 Cell 1 shall be completed within 270 consecutive calendar days.

Description
Preconstruction Meeting
Structural Fill Subgrade Installation
Primary Clay Liner or Geosysnthetic Clay Liner Installation
Primary Geomembrane Liner Installation

Primary Geotextile Cushion Installation

Installation of Leachate Collection System

Installation of Washed Stone Drainage Layer

Submit CQA Report and CQA Certification

2.0 Parties Involved

2.1 Macon County

Contact: Mr. Chris Stahl, (828) 349-2100
Title: Macon County Solid Waste Director

2.2 McGill Associates, P.A.

Contact: Mark D. Cathey, P.E. (828) 252-0575
Title: Project Engineer

2.3 General Contractor

Contact: Unknown

Title:

2.3.1 Surveyor

Contact: Unknown

Title:

2.3.2 Geosynthetic Manufacturer

Contact: Unknown

Title:

2.3.3 Geosynthetic Installer

Contact: Unknown

2.4 Construction Quality Assurance Consulting Firm

Contact: Unknown

Title:

2.4.1 CQA Certifying Engineer

Name: Unknown

Title:

CQA Resident Engineer

Name: Unknown

Title:

Geosynthetic Testing Laboratory

Contact: Unknown

Title:

2.4.4 Soils Laboratory (permeability testing)

Contact: Unknown

Title:

3.0 Preconstruction Meeting

A Preconstruction meeting will be held prior to the beginning of construction. The following people shall be present: Owner representative, Solid Waste Director, County Engineer, Project Engineer, Design Engineer, Certifying CQA Engineer/CQA Project Manager, Resident CQA Engineer, General Contractor, Geosynthetics Installer, and all other subcontractors.

The following items will be discussed at a minimum:

Any questions about the SSCQAP will be addressed and any modifications that result will be documented. Any modifications to the approved SSCQAP must be approved by the North Carolina Department of Environment, Health, and Natural Resources, Division of Waste Management, Solid Waste Section (NCDENR Solid Waste Section).

- Special permits and state and/or federal regulations.
- Responsibilities, expectations, and roles of each party.
- Lines of authority and proper lines of communication.
- Procedures for documenting and reporting information.
- Distribution and storage of documents and reports.
- Protocol for testing and geosynthetic sample management.
- Protocol for handling construction deficiencies.
- Protocol for repairs and re-testing.
- Conduct site walk through:

  Discuss work plans
  Inspect material handling and storage locations
  Review office facilities (copy machine, mailing, etc.)

- Review detailed time schedule for all operations.
- Review work area security, check-in procedure, and safety protocol.
- Establish procedures for material processing.
- Review site health and safety requirements.

The Preconstruction Meeting will be documented by McGill Associates and a copy of the meeting minutes will be distributed to all parties who attend.

4.0 Definitions

4.1 Construction Quality Assurance

A planned and systematic application of all means and actions designed to provide adequate confidence that items or services meet design and specifications requirements and will perform satisfactorily in service. In the context of the geosynthetic liner system, construction quality assurance refers to means and actions employed by the CQA Resident Engineer, CQA Senior Lead Technician, and the CQA Monitors to ensure

conformity of the liner system installation with guidelines set forth in the SSCQAP, construction plans, and construction specifications.

4.2 Construction Quality Control

Those actions which provide a means to measure and regulate the characteristics of an item or services to design, and specifications requirements. In the context of the geosynthetic liner system installation, quality control refers to those actions taken by the Geosynthetic Contractor/Manufacturer to ensure that the product and the workmanship meets the requirements set forth in the SSCQAP, construction plans, and construction specifications.

4.3 Design Engineer

The individual or firm responsible for the preparation of this SSCQAP, construction drawings, and construction specifications.

4.4 Project Engineer

The individual or firm responsible for the implementation of this SSCQAP, construction drawings, and construction specifications.

4.5 General Contractor

The firm responsible for the complete construction of the soil and geosynthetic components of the landfill as specified in this SSCQAP and as shown on the construction drawings and construction specifications.

4.6 Construction Quality Assurance Consultant

The firm responsible for observing, testing and documenting activities related to construction quality assurance during the installation of the leak detection layer, clay liner, geomembrane liner, and the leachate collection system. The CQA Certifying Engineer is responsible for issuing a summary certification and documentation report bearing his/her Professional Engineering Seal. The CQA Resident Engineer is responsible for the management of on-site CQA personnel and providing the Project Engineer and Owner with a daily report of the construction activities.

5.0 DOCUMENTATION PROCEDURES

5.1 Standard Reporting Procedures

The CQA Technicians shall issue a daily report of construction activities. These reports shall include, as a minimum, the following information:

An identifying sheet number for cross-referencing and documentation control.

Date, project name, location and other identification.

1. Weather conditions.

2. Problems encountered and resolutions.

3. Descriptions and locations of ongoing construction.

4. Equipment and personnel in each work area, including subcontractors.

5. Descriptions and specific locations of areas or units of work being tested and/or observed and documented (identified by coordinates or seam/panel numbers).

6. Locations where samples were taken.

7. A summary of test results, failures, and re-tests.

5.2 Monitors of geosynthetic installation shall perform and/or provide the following information and services:

a. Material delivery (time, date, and physical condition of material)
b. Unloading and on-site storage and transport
c. Sampling for conformance testing
d. Deployment operations (roll #, panel #, approved QA\QC cert, thickness, overlap, defects, etc.)
e. Seam preparation (proper overlap and cleanliness)
f. Seaming operations (seaming method, seam#, welding technician, welding apparatus #, welder settings, ambient temperature, chronological order of seams welded, seam length, etc.)
g. Conditions of panel before and after placement
h. Locate and document all defects in the geosynthetic material.
i. Repairs (location, method, technician, date, etc.)
j. Trial seams (monitor preparation and testing)
k. Nondestructive testing (visual observation and documentation)
l. Sampling for destructive seam testing (locating test location)

m. Final walkovers (confirm defect repairs)

5.3 Applicable Forms

As a minimum, the CQA monitors will utilize the following forms for the project:

1. Daily Meeting/Field Report
2. Weekly Meeting/Progress Report
3. Monthly Meeting/Progress Report
4. Nuclear Density Testing
5. Drive Cylinder Test Report
6. Soil Testing Tracking Log
7. Certificate of Acceptance of Soil Subgrade
8. Geosynthetic Materials Inventory Checklist
9. Weather Log
10. Trial Weld Form
11. Panel Deployment
12. Panel Seaming
13. Nondestructive Seam Testing
14. Destructive Sample Test Log
15. Geosynthetic Defect Log
16. Geosynthetic Repair Log
17. Construction Site Safety Form
18. Construction Photo Log
19. Certificate of Completion

5.4 Problem/Deficiency Identification and Corrective Action Report

The CQA Monitor is required to inform the General Contractor and/or the Geosynthetic Contractor, or their representatives, in a timely manner, of any difference between the interpretation of the SSCQAP, the construction plans and construction specifications by the contractor versus the CQA Monitor's interpretation. In addition, any actual or suspect work deficiencies shall be brought to the Project Engineer's and Owner's attention.

A special meeting shall be held when and if a problem or deficiency is present. At a minimum, the meeting shall be attended by the General Contractor, the Owner, the Project Engineer, the CQA Resident Engineer, and the CQA Monitor. If the problem involves a possible design modification, the Design Engineer shall be notified. The purpose of the meeting is to define and resolve the problem or work deficiency as follows:

1. Define and discuss the problem or deficiency
2. Review alternative solutions
3. Implement an action plan to resolve the problem or deficiency

The CQA Resident Engineer or his representative will document all proceedings.

Any changes and/or modifications to the SSCQAP must be approved by the Owner, Design Engineer, Project Engineer, CQA Certifying Engineer, and the NCDENR Solid Waste Section.

5.5 Plan Modifications

Design and/or specification changes shall be made only with written approval of the Owner, the Design Engineer and the Project Engineer. Substantial design changes shall also require approval from the NCDENR Solid Waste Section.

5.6 Scope Change

The CQA Resident Engineer shall notify the Project Engineer whenever additional engineering services are requested by Owner that exceed the original scope of services.

5.7 Photographic Documentation

Photographs taken to document observations, problems, and/or deficiencies, or work in progress will include identification of the date, location, direction of view, and time period. Photographs will be filed in chronological order in a permanent protective file by the CQA team. One set of prints shall be turned over to both the Owner and Project Engineer at the conclusion of the project.

The permanent file will also contain a comprehensive index of each photo, which the CQA Monitor is responsible for preparing and maintaining. This index will include the following information:

1. Date of photograph
2. Provide a location and scale where photographed, including information regarding the orientation of the photograph itself for proper viewing
3. Subject description
4. Photo file number

The following is a list of minimum photographs to be taken during cell construction:

1. Subgrade/subbase proof rolling

2. Geosynthetic conformance sampling
3. Geomembrane deployment
4. Fusion welding devices
5. Extrusion welding devices
6. Air testing
7. Vacuum box testing
8. Seaming
9. Destructive sample location and removal
10. Trial welds
11. Tensiometer testing
12. Geotextile deployment
13. On-site lab soil testing
14. Drainage Layer Construction
15. Progress photographs
16. Design modifications
17. Construction deficiencies
18. Completed construction

5.8 Final Construction Documentation Report

During placement of the drainage layer and stormwater control liner, the CQA Resident Engineer shall prepare a final certification-documentation report covering the installation and testing of the clay and geosynthetic lining system. This report shall certify that the clay or GCL system and geosynthetic liner system has been constructed in substantial accordance with this SSCQAP, the construction drawings, and the construction specifications. A Draft Copy of this report shall be issued to the Project Engineer following completion of the lining system. The final report shall be issued to the Project Engineer following completion of the drainage layer. For this project, two (2) copies of the draft version, five (5) copies of the final version of the report, and a digital copy of the final version of the report, complete with all attachments shall be issued.

5.9 Format of CQA Report

As a minimum, the certification report will contain the following items for discussion in the narrative portion of the report. The proposed table of contents is:

5.9.1 Table of Contents

Section

1.0 Summary of Information

1.1 Narrative
1.2 Reference Information

2.0 Soil Preconstruction Data (embankment and clay liner)

2.1 Proctors
2.2 Soil Density/Moisture
2.3 Soil Classification

3.0 Subgrade Field Data

3.01 Moisture Content
3.02 Field Density Testing

3.1 Clay Liner or GCL Field Data

3.21 Moisture Content
3.22 Field Density Testing
3.23 Permeability Testing

4.0 Soil Laboratory Data

4.1 Construction Proctors
4.2 Soil Classification
4.3 Permeability

5.0 Geosynthetic Quality Control

5.1 Manufacturer's Q.C.
5.2 Installer Resumes
5.3 Material Conformance Testing

6.0 Geosynthetic Liner Field Data

6.1 Weather Log
6.2 Trial Welds
6.3 Panel Placement
6.4 Panel Seaming
6.5 Non-Destruct Test
6.6 Destruct Test
6.7 Repair Log
6.8 Installed Quantities
6.9 Defect Location Map

7.0 Protective/Drainage Layer Data

7.1 Preconstruction testing

7.2 Field and laboratory testing

7.2.1 Sieve analysis
7.2.2 Permeability testing

8.0 Project Meeting Minutes

9.0 Construction Photographs

10.0 Pertinent Information

5.9.2 List of Drawings

As a minimum, the certification will include in an appendix the following proposed list of drawings:

- Geomembrane Panel Layout
- Defect Location Map
- Map giving elevation of subgrade, clay or GCL liner, and drainage layer at a maximum frequency of every fifty (50) feet and a maximum frequency of every fifty (50) feet along grade breaks.

5.10 Site Surveying Requirements

The CQA Resident Engineer shall coordinate all survey activities with the surveyor, provided by the Contractor. Survey services will be required for initial site layout, final grade verification, and primary geomembrane as-built survey. All grade surveying shall be conducted on a maximum 50-foot grid and a maximum 50-foot frequency along grade breaks. The certification surveys will be as directed by the CQA Resident Engineer and shall include the following items:

- Panel placement and seaming locations
- Location of destructive testing samples
- Location of all significant repairs
- Topographic survey of base grades
- Topographic survey of top of clay or GCL liner
- Topographic survey of top of drainage layer

6.0 LANDFILL CONSTRUCTION-EARTHWORK

6.1 Subgrade/ Structural Fill Preparation

6.1.1 Subgrade

Subgrade preparation shall be performed by the General Contractor and in accordance with the construction drawings and construction specifications.

The General Contractor shall be responsible for preparing the subgrade prior to placement of the base liner system and is responsible for constructing the subgrade in accordance with the technical specifications.

Before beginning placement of the Compacted Clay Liner:

1. The Resident CQA Engineer shall document that a licensed land surveyor has verified that all grades and elevations are consistent with the NCDENR Solid Waste Section approved engineering plans.

2. The Resident CQA Engineer shall document that he/she has visually inspected the subgrade surface to evaluate its suitability and that the subgrade meets the criteria specified in the project specifications.

3. The prepared subgrade shall be proof-rolled using a smooth-drum roller (minimum 20 tons) making a minimum of two (2) passes in each direction or other procedures and equipment approved by the Project Engineer.

4. The Resident CQA Engineer shall document that the subgrade has been tested for conformance to the construction specifications at the following minimum frequencies:

Construction Testing SUBGRADE TESTING FREQUENCIES		
TEST	ASTM METHOD	QUANTITY
Field Density	D6938, D1556, D2937	1/5,000 YD^3
Field Moisture	D2216, D6938, D4643	1/5,000 YD^3

6.1.2 Structural Fill

Structural fill shall be the soil placed to achieve the design subgrade contours. The subgrade will be tested for field density and field moisture content at a minimum frequency of one (1) test per 5,000 cubic yards placed. Testing will also consist of visual observation and documentation of proof-rolling with a smooth-drum roller (minimum 20 tons) with at least two (2) passes in each direction or by other procedures and equipment approved by the Project Engineer. If a nuclear gauge is used as the primary means of construction testing, the instrument shall be calibrated properly and test data shall be verified using alternate test methods such as drive cylinders. An alternate test method shall be used at least once for every hundred tests performed with the nuclear gauge. The alternate test method should be performed in the same area as an instrument reading in order to allow accurate comparison of the data resulting from the two tests.

Preconstruction Qualification Structural Fill		
Test	**ASTM Method**	**Quantity**
Natural Moisture Content	D2216	1/5,000 YD^3
Laboratory Compaction	D698	1/5,000 YD^3

Construction Testing STRUCTURAL FILL TESTING FREQUENCIES		
TEST	ASTM METHOD	QUANTITY
Field Density	D6938, D1556, D2937	1/5,000 YD^3
Field Moisture	D2216, D6938, D4643	1/5,000 YD^3

6.2 Select Backfill Placement and Testing

Select backfill will be utilized on a limited basis in berms near the liner edge and at anchor trenches. This material will have the same preconstruction and testing requirements as the subgrade, with the exception that the preconstruction and construction testing will have to be performed to show conformance with the Maximum Particle Size requirements. The testing requirements are as follows:

Preconstruction Qualification		
Test	**ASTM Method**	**Quantity**
Natural Moisture Content	D2216	1/5,000 YD^3
Laboratory Compaction	D698	1/5,000 YD^3
Grain Size Analysis	D422	1/5,000 YD^3
*** Preconstruction test samples shall be taken from the borrow source and or clay stockpiled prior to construction.**		
Construction Testing		
Test	**ASTM Method**	**Quantity**
Field Density	D6938, D1556, D2937	1/5,000 YD^3
Field Moisture	D2216, D6938, D4643	1/5,000 YD^3
Grain Size Analysis	D422	1/5,000 YD^3

6.3 Compacted Clay Liner Material

The Compacted Clay Liner shall consist of low-permeability soils placed on the prepared subgrade.

Table 1 - QA Testing Frequencies and Criteria for Compacted Clay Liner Layer

Preconstruction Qualification		
Test	**ASTM Method**	**Quantity**
Natural Moisture Content	D2216	1/1,000 YD^3 or Change in Material
Grain Size Analysis	D422 or D1140	1/5,000 YD^3 or Change in Material
Classification	D2487	1/5,000 YD^3 or Change in Material
Atterberg Limits	D4318	1/5,000 YD^3 or Change in Material
Laboratory Compaction	D698 - Standard	1/5,000 YD^3 or Change in Material
Permeability **	D5084	1/10,000 YD^3 or Change in Material Three per Moisture-Density Curve
*** Preconstruction test samples shall be taken from the borrow source and or clay stockpiled prior to construction.** ****** The Moisture-Density Curve shall show the region in which the required maximum permeability is met. A minimum of three (3) permeability tests (ASTM D5084) shall be performed per curve to establish the zone of acceptable moistures and densities at which the required maximum permeability may be achieved. If the Contractor elects to run multiple curves to enlarge the zone of acceptance, all curves must be submitted.		
Construction Testing		
Test	**ASTM Method**	**Quantity**
Field Density	D6938, D1556, D2937	1/10,000 FT^2/Lift
Field Moisture	D2216, D6938, D4643	1/10,000 FT^2/Lift
Classification	D2487	1 per acre per lift
Permeability	Extracted per D1587 Tested Per D5084	1/40,000 FT^2/Lift
Atterberg Limits	D4318	1/5,000 YD^3
Grain Size	D422 or D1140	1/5,000 YD^3
Maximum particle Size		3- inch diameter (lower 18 inches) 1/4-inch diameter (top 6 inches)
Soil Layer Thickness	Observation, Field Measurement	Continuous Observation, Minimum of Five (5) per Lift

If a nuclear gauge is used as the primary method for construction testing of the clay liner, the test data shall be verified by alternate test methods at least once for every 10 tests performed.

Any modifications made to these testing frequencies will require prior approval from the NCDENR Solid Waste Section.

Clay liner material generally consists of cohesive soils with low hydraulic conductivity used as barriers in lining systems. Soils used in clay liners shall consist of clean, select material free of debris, excessive coarse particles or other deleterious matter. Soils with a visibly identifiable organic content, or soils classified according to the Unified Soil Classification System as organic silt or organic clay (OL, OH) shall not be used.

Any tests resulting in the penetration of the compacted clay liner shall be repaired by backfilling the test area with a hand-tamped 50/50 bentonite/clay mixture.

6.4 Clay Liners

Prior to the construction of a clay liner, soil evaluation tests shall be performed to confirm the adequacy of clay liner materials procured from each on-site or off-site source area. All tests shall be performed in a geotechnical laboratory. The General Contractor shall submit the results of source evaluation tests to the Project Engineer. Previous testing and evaluations of the soil sources may also be used to evaluate the soil material. The material shall be accepted or rejected by the Project Engineer according to these results. The acceptance and rejection criteria for the clay liner material will be verified by the construction of a test pad in accordance with the construction specifications

6.4.1 Quality Assurance Testing

Permeability tests shall be performed at a confining pressure of 25 psi +/- 1 psi and with a gradient in accordance with ASTM method D5084. Samples taken from each location shall be compared to the approved moisture-density-permeability relation. Test frequencies for construction testing are given in Table 1 of Section 6.3. The Resident CQA Engineer shall certify that the clay liner was constructed using the same methods and acceptance criteria consistent with test pad construction and tested according to the NCDENR Solid Waste Section approved plans.

6.4.2 Test Pad Construction

The test pad shall be constructed in accordance with the technical specifications. The results of the test pad testing shall be in accordance with Table 1 in Section 6.3 and the previously approved moisture-density-permeability relationship established from preconstruction testing. Field moisture and density tests and laboratory permeability tests

will be performed by the Resident CQA Engineer for each lift placed on the test pads to verify the construction method, equipment, and material to achieve the maximum required permeability for the clay liner. If the contractor chooses to construct the test pads within the cell, all lifts of the test pads must pass to enable them to remain as part of the clay liner. The Contractor shall allow sufficient time for construction and testing of the test pad prior to placement of the Compacted Clay Liner.

6.4.3 Clay Liner Placement

The clay liner shall be placed in accordance with Section 02300 of the technical specifications.

6.4.4 Clay liner Acceptance

The Resident CQA Engineer must approve the condition of the clay liner prior to the geosynthetic installer deploying the geomembrane.

The soil components of the lining system will be approved by the Resident CQA Engineer when:

1. The installation of the soil components is finished.

2. Verification of the adequacy of the constructed components, including repairs, if any, is completed in accordance with this SSCQAP and the technical specifications.

All documentation of installation is completed.

The depth and grade of the clay liner has been verified by a licensed surveyor and has been approved by the project engineer.

3. The appropriate frequency of permeability tests have been performed and the results have been approved by the Certifying CQA Engineer.

4. The Soil QA Monitors shall certify that installation of the soil components has proceeded in accordance with this SSCQAP and the Technical Specifications.

6.5 Granular Drainage and Protective Layer

The Granular Drainage and Protective Layer will be the twenty-four (24) inch layer of material placed directly over the liner system to provide protection for the liner system as well as a drainage conduit for leachate drainage. The testing requirements are as follows:

Testing Frequencies and Criteria for Granular Drainage and Protective Layer

Preconstruction Qualification		
Test	**ASTM Method**	**Quantity**
Moisture Content	D2216	1 per source***
Grain Size	D422 or D1140	1 per source***
Classification	D2487	1 per source
Calcium Carbonate	D4373	1 per source
Permeability	D2434	1 per source
***In addition to quarry certificate		
Construction Testing		
Test	**ASTM Method**	**Quantity**
Grain Size	D422	1/1,500 YD^3
Permeability	D2434	1/6,000 YD^3

6.6.2 Placement

Placement of the granular drainage layer shall be performed by a low ground pressure dozer and/or off-road dump truck not in direct contact with the geomembrane. A minimum depth of 2 feet of drainage layer material must be maintained at all times during placement activities when vehicles other than the low ground pressure dozer are needed. High traffic areas, such as access roads constructed to transport material into the landfill, should have a minimum depth of three (3) feet.

The drainage layer shall be placed in the coolest part of the day when possible in order to reduce the potential for wrinkles forming in the geomembrane. See Sections 1.4.2 and 1.1.5 of Appendix B for information on evaluating and repairing wrinkles in the geomembrane.

The Resident CQA Engineer will observe placement activities. The General Contractor is to provide laborers ahead of drainage material placement to assist in minimizing

wrinkle formation of the geomembrane. Temperature variations may impact the Contractor's ability to place this material.

6.6.3 Depth Verification

CQA Monitor(s) will randomly verify granular drainage layer depth utilizing test pits or survey means. A Surveyor licensed in the State of North Carolina will survey the top of the drainage layer to certify proper depth was achieved. The General Contractor may use depth markers (i.e., painted tubes, flags, traffic cones, etc.) during placement to provide depth control and minimize possible damage to geomembrane. Depth markers shall be removed as the drainage layer is completed. Depth markers shall not be constructed of a material that could potentially puncture the geomembrane and shall be approved by the Project Engineer.

7.0 LANDFILL CONSTRUCTION-GEOMEMBRANE

7.1 Geomembrane Liner

The geosynthetic components of the lining system will be approved by the Resident CQA Engineer when:

The installation of the geosynthetic components has been completed in accordance with this SSCQAP and the Technical Specifications.

Verification of the adequacy of all seams including associated testing and repairs, if any, is completed in accordance with this SSCQAP and the Technical Specifications.

1. All documentation of installation is completed.

2. The Geosynthetic CQA Monitor(s) are able to recommend acceptance.

7.2 Geomembrane Quality Control

The Geosynthetic Contractor/Manufacturer will provide geosynthetic quality control in accordance with Appendix A.

7.3 Geomembrane Quality Assurance

7.3.1 Conformance Sampling

Conformance testing will be done on-site as material arrives and is inventoried. Conformance sampling procedures will be in accordance with Appendix A.

7.4 Geomembrane Seaming

Field seaming will be done in accordance with Appendix B.

7.4.1. Double Tracked Fusion Welding

All seaming performed shall utilize the double-tracked fusion process when possible. Detailing and repairs do not require double tracked fusion welding.

7.4.2 Extrusion Welding

Extrusion welding shall only be used when double-tracked fusion welding is not possible. The extrusion process will be utilized for repair or detail work, attaching temporary rain flaps, capping a failed seam, or completion of other appurtenances that cannot be performed with fusion welding.

7.5 Geomembrane/Seam Repairs

All repairs to the geomembrane or seams shall be done utilizing the extrusion welding process. All repair work shall be conducted in accordance with Appendix B.

7.6 Geotextile Quality Control

The Geosynthetic Contractor/Manufacturer shall provide quality control information in accordance with Appendix C.

7.7 Geotextile Quality Assurance

Conformance sampling will be performed on-site as material arrives and is inventoried. All conformance sampling will be in accordance with Appendix C.

8.0 LEACHATE COLLECTION PIPING

8.1 Definition and Applicability

Leachate Collection Piping pertains to the High Density Polyethylene Pipe (HDPE) pipe utilized in the collection and transmission of leachate and/or other contaminated liquids generated as a byproduct of the disposal of MSW.

8.2 Quality Control Documentation

Prior to the shipment of any HDPE pipe, the Manufacturer shall provide the Resident CQA Engineer with the following information:

1. A specification for the HDPE pipe that includes all properties contained in the Project Technical Specifications measured using the appropriate test methods.

2. At a minimum, results shall be given for the following:

Property	Test Method	Frequency
Relative Density	ASTM D1505	Per Shipment
Melt Index	ASTM D1238	Per Shipment
Carbon Black Content	ASTM D3350	Per Shipment
Tensile Strength at Yield	ASTM D638, Type IV	Per Shipment
Elastic Modulus	ASTM D638	Per Shipment

The Manufacturer shall identify all HDPE pipe products with the following:

Manufacturers Name
Product Identification
Size
SDR Rating

The Resident CQA Engineer shall review these documents and shall report any discrepancies with the above requirements to the Project Engineer. The Resident CQA Engineer shall verify that:

Property values submitted by the Manufacturer meet the required Project Technical Specifications.

Measurements of properties by the Manufacturer are properly documented and that the test methods used are acceptable.

HDPE pipe products are appropriately labeled.

Appendix A

1.0 Geomembranes

1.1 Description and Applicability

Geomembranes are low permeability geosynthetic barriers used in lining systems. This Section is applicable to smooth and textured high density polyethylene (HDPE) geomembranes. This Section may need to be modified when using other geomembranes.

1.2 Manufacturing Plant Inspection

The Owner or other appropriate representative may conduct an inspection of the Manufacturer's plant. In addition, the Project Engineer, or his designated representative, may visit the manufacturing plant for a project-specific inspection if deemed necessary. If possible, the project-specific inspection shall be prior to or during the manufacturing of the geomembrane rolls for that particular project. The purpose of the plant inspection is to review the manufacturing process and quality control procedures.

The manufacturing plant inspection shall include:

Verification that properties guaranteed by the manufacturer are met and meet all the project specifications.

Verification that the measurement of properties by the Manufacturer is properly documented and test methods used are acceptable.

Spot inspection of the rolls and verification that they are free of imperfections or any sign of contamination by foreign matter.

Review of handling, storage, and transportation procedures, and verification that these procedures will not damage the geomembrane.

Verification that roll packages have a label indicating the name of the manufacturer, type of geomembrane, thickness, roll number, and roll dimensions.

Verification that extrusion rods and/or beads are produced from the same base resin type as the geomembrane.

A report describing the inspection shall be retained by the Owner and by the Project Engineer for project-specific inspections.

1.3 Quality Control Documentation

Prior to the shipment of any geomembrane, the Manufacturer shall provide the Resident CQA Engineer with the following information:

1. The origin (supplier's name and production plant) and identification (brand name and number) of the resin used to manufacture the geomembrane.

2. Copies of dated quality control certificates issued by the resin supplier.

3. Results of tests conducted by the Manufacturer to verify that the resin used to manufacture the geomembrane meets the project specifications.

4. A statement indicating that the amount of reclaimed polymer added to the resin during manufacturing was done with appropriate cleanliness.

5. A list of the materials that comprise the geomembrane, expressed in the following categories as percent by weight: polyethylene, carbon black, other additives.

6. A specification for the geomembrane that includes all properties contained in the project specifications measured using the appropriate test methods.

7. Written certification that minimum values given in the specification are guaranteed by the Manufacturer.

8. Quality control certificates, signed by a responsible party employed by the Manufacturer. Each quality control certificate shall include roll identification numbers, testing procedures, and results of quality control tests. At a minimum, results shall be given for the following:

Property	Test Method	Frequency
Thickness	ASTM D-5199 (Smooth) ASTM D-5994 (Textured)	Each Roll
Relative Density	ASTM D-1505	Every 5th roll
Tensile Properties	ASTM D6693 Type IV	Every 5th roll
Tear Resistance	ASTM D1004 Die C	Every 5th roll
Puncture Resistance	ASTM D-4833	Every 5th roll
Carbon Black Content	ASTM D-1603 or D-4218	Every 5th Roll
Carbon Black Dispersion	ASTM D-5596	Every 5th Roll

The Manufacturer shall identify all rolls of geomembranes with the following:

Manufacturer's name
Product identification
Thickness
Roll number
Roll dimensions

The Resident CQA Engineer shall review these documents and shall report any discrepancies with the above requirements to the Project Engineer. The Resident CQA Engineer shall verify that:

Property values certified by the Manufacturer meet all of its guaranteed specifications.

Measurements of properties by the Manufacturer are properly documented and that the test methods used are acceptable.

Quality control certificates have been provided at the specified frequency for all rolls, and that each certificate identifies the rolls related to it.

Rolls are appropriately labeled.

Certified minimum properties meet the project specifications.

1.4 Conformance Testing

1.4.1 Sampling Procedures

Upon delivery of the rolls of the geomembrane, the Resident CQA Engineer shall ensure that conformance test samples are obtained for the geomembrane. The geomembrane rolls to be sampled shall be selected by the Resident CQA Engineer. Samples shall be taken across the entire width of the roll judged by the Resident CQA Engineer not to be damaged. Unless otherwise specified, samples shall be 3 ft (1 m) long by the roll width. The Resident CQA Engineer shall mark the machine direction on the samples with an arrow.

A lot shall be defined as a group of consecutively numbered rolls from the same manufacturing line. Alternatively, a lot may be designated by the Certifying CQA Engineer based on a review of all roll information including quality control documentation and manufacturing records.

If the Project Engineer desires, the Resident CQA Engineer can perform the conformance test sampling at the manufacturing plant. This may be advantageous in expediting the installation process for very large projects.

Unless otherwise specified in the project specifications, samples shall be taken at a rate of one per lot and not less than one per 100,000 ft^2 (10,000 m^2) of geomembrane. These samples shall be forwarded to the Resident CQA Engineer for testing.

1.4.2 Conformance Tests

The following conformance tests shall be conducted:

Relative Density (ASTM D-1505)
Carbon black content (ASTM D-1603 or D-4218)
Carbon black dispersion (ASTM D-5596)
Thickness – Smooth (ASTM D-5199)
Thickness - Textured (ASTM D-5994)
Tensile properties (ASTM D-6693, Type IV)

Other conformance tests may be required by the project specifications.

1.4.3 Test Results

All conformance test results shall be reviewed and accepted or rejected by the Certifying CQA Engineer prior to the deployment of the geomembrane. The Certifying CQA Engineer shall examine all results from laboratory conformance testing and shall report any non-conformance to the Project Engineer. The Certifying CQA Engineer shall be responsible for checking that all test results meet or exceed the property values listed in the project specifications.

If a test result is in nonconformance, all material from the lot represented by the failing test shall be considered out-of-specification and rejected. Alternatively, at the option of the Project Engineer, additional conformance test samples may be taken to "bracket" the portion of the lot not meeting the project specification. This procedure is valid only when all rolls in the lot are consecutively produced and numbered from one manufacturing line. To isolate the out-of-specification material, additional samples must be taken from rolls that have roll numbers immediately adjacent to the roll that was sampled and failed. If both additional tests pass, the roll that represents the initial failed test and the roll manufactured immediately after that roll (next large roll number) shall be rejected. If one or both of the additional tests fail, then the entire lot shall be rejected or the procedure repeated with two additional tests that bracket a greater number of rolls within the lot.

1.5 Geomembrane Specifications

1.5.1 Materials

The geomembrane materials used for construction shall be in strict accordance with the technical specifications.

1.5.2 Construction

The geomembrane liner shall be installed as soon as practical after completion and approval of the compacted clay liner or portion thereof. The top of the compacted clay liner will be surveyed to ensure adequate thickness of clay material and proper grades toward the collection sump area have been achieved. The geomembrane is to cover the bottom of the secure cell and the side slopes in accordance with the Contract Drawings.

Areas to receive liner installation should be relatively smooth and even, free of ruts, voids, etc., to the extent required by the Engineer. This shall be accomplished by final dressing of the compacted liner with smooth drum rollers. No vehicles are permitted on final dressed surfaces unless authorized by the Engineer.

An anchor trench (as illustrated on the Contract Drawings) will be required to secure the geomembrane. No loose soil will be allowed to underlie the geomembrane in the anchor trenches. The time schedule for excavation and backfilling of the anchor trenches is to be approved by the Engineer so that desiccation of trench soils does not occur prior to backfilling.

Before the geomembrane installation begins, the Resident CQA Engineer shall verify that:

1) A State of North Carolina licensed Professional Land Surveyor has verified all lines and grades of the compacted clay liner.

2) A qualified and licensed Professional Engineer has verified that the clay liner surface meets the criteria specified in the project specifications.

3) The clay liner surface to be lined has been rolled, compacted, or hand-worked so as to be free of irregularities, protrusions, loose soil, and abrupt changes in grade.

4) The surface of the clay liner does not contain stones, which may be damaging to the geomembrane.

5) There is no area excessively softened by high water content.

6) There is no area where the clay liner surface contains desiccation cracks, which may damage the geomembrane.

7) The clay liner has sufficient thickness and that all permeability tests have not exceeded the specified maximum permeability.

8) The geomembrane to be deployed has an absolute minimum thickness of 60 mils and passing conformance samples at the frequencies specified in Section 1.4.1 of this Appendix B and be documented .

The Installer shall certify in writing that the surface on which the geomembrane will be installed is acceptable. A certificate of acceptance shall be given by the Installer to the Resident CQA Engineer prior to commencement of geomembrane deployment in the area under consideration. The Certifying CQA Engineer shall be given a copy of this certificate by the Resident CQA Engineer.

After the underlying soil has been accepted by the Installer, it is the Installer's responsibility to indicate to the General Contractor any change in the underlying soil condition that may require repair work. The General Contractor will consult with the Resident CQA Engineer regarding the need for repairs. If the Resident CQA Engineer concurs with the Installer, the General Contractor shall ensure that the underlying soil is repaired.

At any time before or during the geomembrane installation, the Resident CQA Engineer shall indicate to the General Contractor any locations which may not be adequately prepared for the geomembrane.

The Resident CQA Engineer shall verify that the **anchor trench** is constructed in accordance with the following:

1) The anchor trench has been constructed according to the project plans and specifications.

2) If the anchor trench is excavated in a clay material susceptible to desiccation, the amount of trench open at any time is minimized. The Resident CQA Engineer shall inform the Contractor and Project Engineer of any signs of significant desiccation associated with the anchor trench construction.

3) Rounded corners are provided in the trench so as to avoid sharp bends in the geomembrane.

4) Excessive amounts of loose soil are not allowed to underlie the geomembrane in the anchor trench.

5) The anchor trench is adequately drained to prevent ponding or softening of the adjacent soils while the trench is open.

6) The anchor trench is backfilled and compacted as outlined in the project specifications.

Care shall be taken when backfilling the trenches to prevent any damage to the geosynthetic components. The Resident CQA Engineer shall observe the backfilling operation and advise the Contractor and Project Engineer of any problems. Any problems shall be documented by the Resident CQA Engineer in his daily report.

Appendix B

1.0 Field Seaming

1.1.1 Seam Layout

Before installation begins, the Installer shall provide the Resident CQA Engineer and the Project Engineer with a panel layout drawing. This drawing shall present all the proposed seams of the lining system at the facility. The Project Engineer and the Resident CQA Engineer shall review the panel layout drawing and verify that it is consistent with the technical specifications and the Division approved plans. No panels may be seamed until written approval of the panel layout drawing has been provided by the Project Engineer. In addition, panels not specifically shown on the panel layout drawing may not be used without the Project Engineer's prior approval.

In general, seams should be oriented parallel to the line of maximum slope, thus, oriented along, not across, the slope. In corners and odd-shaped geometric locations, the number of seams should be minimized. No horizontal seam should be less than 10 ft (3.0m) from the toe or crest of the slope, or areas of potential stress concentrations, unless otherwise authorized by the Project Manager.

A seam numbering system compatible with the panel numbering system shall be used by the Resident CQA Engineer and the CQA monitors.

1.1.2 Accepted Seaming Methods

Approved processes for field seaming are fusion welding and extrusion welding. Proposed alternate processes shall be documented and submitted by the Installer to the Project Engineer for approval. Only apparatuses that have been specifically approved by make and model shall be used. The Contractor shall submit all documentation regarding seaming methods to be used to the Resident CQA Engineer for review.

1.1.2.1 Fusion Process

The CQA monitor shall log ambient temperature, seaming apparatus, and geomembrane surface temperatures at appropriate intervals and report any noncompliances to the Resident CQA Engineer.

The Resident CQA Engineer shall verify that:

The Installer maintains on-site the number of spare operable seaming apparatuses agreed upon at the pre-construction meeting.

Equipment used for seaming is not likely to damage the geomembrane.

The electric generator is placed on a smooth base such that no damage occurs to the geomembrane.

A smooth insulating plate or fabric is placed beneath the hot welding apparatus after usage such that no damage occurs to the geomembrane.

1. A movable protective layer is used as required by the Installer directly below each overlap of geomembrane that is to be seamed to prevent buildup of moisture between the sheets and to prevent debris from collecting around the pressure rollers.

2. In general, the geomembrane panels are aligned to have an overlap of 4 to 6 in (100 mm to 150 mm) for fusion welding. In any event, the final overlap shall be sufficient to allow peel tests to be performed on the seam.

3. No solvent or adhesive is used.

4. The geomembrane is protected from damage in heavy traffic areas.

1.1.2.2 Extrusion Process

The CQA monitor shall log ambient temperature, seaming apparatus, and geomembrane surface temperatures at appropriate intervals and report any noncompliances to the Resident CQA Engineer.

The Resident CQA Engineer shall verify that:

The Installer maintains on-site the number of spare operable seaming apparatuses agreed upon at the pre-construction meeting.

Equipment used for seaming is not likely to damage the geomembrane.

Prior to beginning a seam, the extruder is purged until all heat-degraded extrudate has been removed from the extruder barrel.

Clean and dry welding rods or extrudate pellets are used.

The electric generator is placed on a smooth base such that no damage occurs to the geomembrane.

Grinding is completed no more than one hour prior to seaming.

A smooth insulating plate or fabric is placed beneath the hot welding apparatus after usage such that no damage occurs.

The geomembrane is protected from damage in heavy traffic areas.

Exposed grinding marks adjacent to an extrusion weld shall be minimized. In no instance shall exposed grinding marks extend more than 1/8 in (6 mm) from the finished seamed area.

In general, the geomembrane panels are aligned to have a nominal overlap of 3 in (75 mm) for extrusion welding. In any event, the final overlap shall be sufficient to allow peel tests to be performed on the seam.

No solvent or adhesive is used.

The procedure used to temporarily bond adjacent panels together does not damage the geomembrane; in particular, the temperature of hot air at the nozzle of any temporary welding apparatus is controlled such that the geomembrane is not damaged

1.1.3 Seam Preparation

The CQA monitors shall verify that prior to seaming, the seam area is clean and free of moisture, dust, dirt, debris or foreign material of any kind. If seam overlap grinding is required, the CQA monitors must ensure that the process is completed according to the Manufacturer's instruction within one hour of the seaming operation, and in a way that does not damage the geomembrane. The CQA monitors shall also verify that seams are aligned with the fewest number of wrinkles and "fishmouths".

1.1.4 Test Seams

Trial seams shall be made on fragment pieces of geomembrane liner to verify that conditions are adequate for production seaming. Trial seams shall be performed in accordance with Section 02620 of the technical specifications.

1.1.5 General Seaming Procedures

During general seaming, the CQA monitors shall ensure the following:

Fishmouths or wrinkles at the seam overlaps shall be cut along the ridge of the wrinkle in order to achieve a flat overlap. The cut fishmouths or wrinkles shall be seamed and any portion where the overlap is inadequate shall then be patched with an oval or round patch of the same geomembrane extending a minimum of 6 in (150 mm) beyond the cut in all directions.

If seaming operations are carried out at night, adequate illumination shall be provided.

Seaming shall extend to the outside edge of panels placed in the anchor trench.

All cross seam tees should be extrusion welded to a minimum distance of 4 in (100 mm) on each side of the tee.

No field seaming shall take place without the Master Seamer being present.

A firm substrate may be required to be provided by using a flat board, a conveyor belt, or similar hard surface directly under the seam overlap to achieve proper support.

The Resident CQA Engineer shall verify that the above seaming procedures or any other procedures agreed upon and indicated in the Preconstruction Meeting or construction progress meetings are followed, and shall inform the Project Engineer of any nonconformance.

1.1.6 Seaming Weather Conditions

1.1.6.1 Cold Weather Conditions

To ensure a quality installation, if seaming is conducted when the ambient temperature is below 40°F (5°C), the following conditions shall be met:

Geomembrane surface temperatures shall be determined by the Resident CQA Engineer at intervals of at least once per 100 feet (30 m) of seam length to determine if preheating is required. For extrusion welding, preheating is required if the surface temperature of the geomembrane is below 41°F (5°C).

1. For fusion welding, preheating may be waived by the Project Engineer based on a recommendation from the Resident CQA Engineer, if the Installer demonstrates to their satisfaction that welds of equivalent quality may be obtained without preheating at the expected temperature of installation.

2. If preheating is required, the CQA monitors shall observe all areas of geomembrane that have been preheated by a hot air device prior to seaming, to ensure that they have not been overheated.

3. Care shall be taken to confirm that the surface temperatures are not lowered below the minimum surface temperatures specified for welding due to winds or other adverse conditions. It may be necessary to provide wind protection for the seam area.

4. All preheating devices shall be approved prior to use by the Resident CQA Engineer.

Additional destructive tests shall be taken at an interval between 250 feet and 500 feet 75 to 150 m) of seam length, at the discretion of the Resident CQA Engineer.

Sheet grinding may be performed before preheating, if applicable.

Test seams shall be conducted under the same ambient temperature and preheating conditions as the production seams. Under cold weather conditions, additional trial seams shall be conducted if the ambient temperature drops by more than 10°F from the initial trial seam test conditions. Such new seams shall be constructed upon completion of seams in progress during temperature drop.

1.1.6.2 Warm Weather Conditions

At ambient temperatures above 104°F, no seaming of the geomembrane shall be permitted unless the Installer can demonstrate to the satisfaction of the Resident CQA Engineer that geomembrane seam quality is not compromised. Test seams shall be conducted under the same ambient temperature conditions as the production seams. At the option of the Resident CQA Engineer, additional destructive tests may be required for any suspect areas.

1.2 Nondestructive Seam Testing

1.2.1 Concept

The Installer shall nondestructively test all field seams over their full length using an air pressure test (for double fusion seams only, a vacuum test or other approved method. Air pressure testing and vacuum testing are described elsewhere respectively. The purpose of nondestructive tests is to check the continuity of seams. It does not provide quantity information on seam strength. Nondestructive testing shall be carried out as the seaming work progresses, not at the completion of all field seaming.

For all seams, the CQA monitors shall:

Observe nondestructive testing procedures.

Record location, data, test unit number, name of tester, and outcome of all testing.

Inform the Installer and Resident CQA Engineer of any required repairs.

Any seams that cannot be nondestructively tested shall be cap-stripped. The cap-stripping operations shall be observed by the Resident CQA Engineer and Installer for uniformity and completeness.

1.2.2 Air Pressure Testing

Air pressure testing is applicable to double fusion welding which produces a double seam with an enclosed space.

The Equipment for air pressure testing shall consist of the following:

An air pump (manual or motor driven), equipped with pressure gauge and capable of generating and sustaining a pressure between 25 and 30 psi (160 and 200 kPa) and mounted on a cushion to protect the geomembrane.

A rubber hose with fittings and connections.

A sharp hollow needle, or other pressure feed device, approved by the Resident CQA Engineer.

The following procedures shall be followed:

Seal both ends of the seam to be tested.

Insert needle or other approved pressure feed device into the air channel created by the fusion weld.

Insert a protective cushion between the air pump and the geomembrane.

Pressurize the air channel to a pressure of approximately 30 psi (200 Kpa). Close valve, allow 2 minutes for pressure to stabilize, and sustain pressure for at least 5 minutes. Pressure loss over the 5-minute period should not exceed 3psi.

If loss of pressure exceeds the maximum permissible pressure differential as outlined in the project specifications or does not stabilize, locate fault area and repair in accordance with Section 1.4.3.

Cut opposite end of tested seam area once testing is complete to verify continuity of the air channel. If air does not escape, locate blockage and retest unpressurized area.

Remove needle or other approved pressure feed device and grind and weld or patch the hole in the geomembrane.

1.2.3 Vacuum Testing

Vacuum testing is applicable to extrusion welding.

The equipment shall consist of the following:

A vacuum box assembly consisting of a rigid housing, a transparent viewing window, a soft neoprene gasket attached to the bottom, a porthole or valve assembly, and a vacuum gauge.

A pump assembly equipped with a pressure controller and pipe connections.

A rubber pressure/vacuum hose with fittings and connections.

A soapy solution. (CQA monitors shall ensure solution makes bubbles when air is passed through.)

A bucket and wide paint brush, or other means of applying the soapy solution.

The following procedures shall be followed:

Wet a strip of geomembrane approximately 12 in X 48 in (0.3 m X 1.2 m) with the soapy solution.

Place the box over the wetted area.

Close the bleed valve and open the vacuum valve.

Ensure that a leak-tight seal is created.

Energize the vacuum pump and reduce the applied pressure to approximately 5 psi (10 in of Hg/35kPa) gauge.

For a minimum of 10 seconds, apply vacuum with the box placed and maintaining a seal, examine the geomembrane through the viewing window for the presence of soap bubbles.

If no bubble appears after 10 seconds, close the vacuum valve and open the bleed valve, move the box over the next adjoining area with a minimum 3 in (75 mm) overlap, and repeat the process.

All areas where soap bubbles appear shall be marked and repaired in accordance with Section 1.4.3.

1.2.4 Test Failure Procedures

The Installer shall complete any required repairs in accordance with Section 1.4.3. For repairs, the CQA monitor shall:

Observe the repair and testing of the repair.

Mark on the geomembrane that the repair has been made.

Document the repair procedures and test results.

1.3 Destructive Seam Testing

1.3.1 Concept

The purpose of destructive tests is to evaluate seam strength. Destructive seam tests shall be performed at selected locations. Seam strength testing shall be done as the seaming work progresses, not at the completion of all field seaming.

1.3.2 Location and Frequency

The Resident CQA Engineer shall select where seam samples will be cut out for laboratory testing. The frequency and locations shall be established as follows:

A minimum frequency of one test location per 500 feet (150 m) of seam length performed by each welding machine. This frequency is to be determined as an average taken throughout the entire facility.

Test locations shall be determined during seaming at the discretion of the Resident CQA Engineer or the Project Engineer. Special consideration shall be given to locations where the potential for imperfect welding, such as overheating, contamination, and offset welds exists.

1.3.3 Sampling Procedures

Samples shall be cut by the Installer at locations chosen by the Resident CQA Engineer as the seaming progresses so that laboratory test results are available before the geomembrane is covered by another material. The Resident CQA Engineer shall:

Observe sample cutting.

1. Assign a number to each sample, and mark it accordingly.

2. Record sample location on layout drawing.

3. Record reason for taking the sample at this location (e.g., statistical routine, suspicious feature of the geomembrane).

All holes in the geomembrane resulting from destructive seam sampling shall be repaired in accordance with repair procedures described in Section 1.4.3 immediately following receipt of successful test results. The continuity of the new seams in the repaired area shall be tested according to Section 1.2.3. All holes in the geomembrane shall be temporarily patched or repaired in accordance with Section 1.4.3 before the end of each work day in order to protect the clay liner from inclement weather.

1.3.4 Sampling Procedure

Destructive sampling shall be performed in accordance with Section 02620 of the technical specifications.

1.3.5 Field Testing

Destructive field testing shall be performed in accordance with Section 02620 of the technical specifications.

1.3.6 Destructive Test Failure

Destructive test failures shall be handled in accordance with Section 02620 of the technical specifications.

1.4 Defects and Repairs

1.4.1 Identification

All seams and non-seam areas of the geomembrane shall be examined by the CQA monitors for identification of defects, holes, blisters, undispersed raw materials, large wrinkles and any sign of contamination by foreign matter. The geomembrane surface shall be cleaned by the Installer prior to examination if the CQA monitor determines that the amount of dust or mud inhibits examination.

1.4.2 Evaluation

Each suspect location both in seam and non-seam areas shall be nondestructively tested using the methods described in Section 1.2. Each location which fails the nondestructive testing shall be marked by the CQA monitor and repaired by the Installer. Work shall not proceed with any materials that will cover locations that have been repaired until successful nondestructive and/or laboratory tests are obtained.

When seaming of the geomembrane is completed, and prior to placing overlying materials, the Resident CQA Engineer shall indicate to the General Contractor any large wrinkles that should be cut and reseamed by the Installer. The number of wrinkles to be repaired should be kept to an absolute minimum. Therefore, wrinkles should be located during the coldest part of the installation period, while keeping in mind the forecasted weather to which the undercover geomembrane may be exposed. Wrinkles are considered to be large when the geomembrane can be folded over onto itself which is generally a wrinkle that extends 12 in (0.3 m) from the subgrade. Seams produced while repairing wrinkles shall be nondestructively tested.

When placing overlying material on the geomembrane, every effort must be made to minimize wrinkle development. If possible, cover should be placed during the coolest weather. In addition, small wrinkles should be isolated and covered as quickly as possible to prevent their growth. The placement of cover materials shall be observed by McGill Associates or a CQA monitor to ensure that wrinkle formation is minimized and that, in all cases, the geomembrane is not folded over on itself.

1.4.3 Repair Procedures

Any portion of the geomembrane exhibiting a flaw, or failing a destructive or nondestructive test, shall be repaired. Several procedures exist for the repair of these areas. The final decision as to the appropriate repair procedure shall be determined by the Project Engineer and the Resident CQA Engineer.

1. The repair procedures available include:

    a. Patching, used to repair holes, tears, undispersed raw materials, and contamination by foreign matter.

    b. Spot welding used to repair pinholes, or other minor, localized flaws.

    c. Capping, used to repair large lengths of failed seams.

d. Extrusion welding the flap, used to repair areas of inadequate fusion seams which have an exposed edge. Repairs of this type shall be approved by Resident CQA Engineer and shall not exceed 100 ft (30 m) in total length.

e. Removing bad seam and replacing with a strip of new material welded into place.

2. For any repair method, the following provisions shall be satisfied:

a. Surfaces of the geomembrane which are to be repaired using extrusion methods shall be ground no more than one hour prior to the repair.

b. All surfaces shall be clean and dry at the time of the repair.

c. All seaming equipment used in repairing procedures shall meet the requirements of this SSCQAP.

d. Patches or caps shall extend at least 6 in (150 mm) beyond the edge of the defect, and all corners of patches shall be rounded with a radius of approximately 3 in (75 mm).

1.4.4 Repair Verification

The CQA monitors shall observe all nondestructive testing of repairs and shall record the number of each repair, date and test outcome. Each repair shall be nondestructively tested using the method described in Section 1.2 as appropriate. Repairs that pass the nondestructive test shall be taken as an indication of an adequate repair. Repairs more than 500 ft (50 m) long require destructive test sampling. Failed tests require that the repair shall be redone and re-tested until a passing test results.

1.5 Geomembrane Protection

The quality assurance procedures indicated in this Section are intended only to assure that the installation of adjacent materials does not damage the geomembrane. The quality assurance of the adjacent materials themselves are covered in separate Sections of this manual.

1.5.1 Soils

1. Placement of gravel on the geomembrane shall not proceed at an ambient temperature below 32 degrees F (0 degrees C) nor above 104 degrees F (40 degrees C) unless otherwise specified.

2. Placement of gravel on the geomembrane should be done during the coolest part of the day to minimize the development of wrinkles in the geomembrane.

3. Equipment used for placing gravel shall not be driven directly on the geomembrane.

4. A minimum thickness of 24 inches of gravel shall be maintained between the geotextile cushion and the top of the drainage layer Off-road trucks shall have a minimum thickness of 3 feet between them and the geomembrane/geotextile cushion.

5. In any areas traversed by heavy construction, any vehicles other than low ground pressure vehicles approved by the Project Engineer, the gravel layer shall have a minimum thickness of 3 ft (09 m). This requirement may be waived if provisions are made to protect the geomembrane through an engineered design approved by the Project Engineer. Drivers shall proceed with caution when traveling on the overlying gravel and prevent spinning of tires or sharp turns.

6. Leachate collection pipes shall not be crossed with construction equipment without the full two (2) feet of stone in place. In areas where off-road trucks must repeatedly cross the leachate piping, a temporary stone road shall be build to bridge over the pipe and maintain a minimum thickness of three (3) feet.

7. Care shall be taken to avoid creating wrinkles in the geomembrane during placement of the gravel layer.

1.5.2 Sumps and Appurtenances

The sumps shall be constructed in accordance with the technical specifications and the Resident CQA Engineer shall certify the following:

1. Installation of the geomembrane, sumps, equipment, and appurtenant areas has been performed properly, and connections of geomembrane to sumps and appurtenances have been made according to project specifications.

2. Extreme care is taken while welding around appurtenances since nondestructive testing will be difficult in these areas.

3. The geomembrane has not been visibly damaged while making connections to sumps and appurtenances.

4. The Resident CQA Engineer or his representative shall be present at all times when the Installer is welding geomembrane to appurtenant structures.

The Resident CQA Engineer shall inform the Project Engineer in writing if the above conditions are not fulfilled.

Appendix C

1.0 Geotextiles

1.1 Definition and Applicability

Geotextiles are used in protection and filtering applications in lining systems. This Section does not describe procedures for other applications such as erosion control or reinforcement. This Section is applicable to nonwoven geotextiles made of polyester of polypropylene and not applicable to nonwoven geotextiles made of other materials or woven geotextiles.

1.2 Manufacturing Plant Inspection

The Owner or an appropriate representative may conduct a periodic inspection of the Manufacturer's plant. In addition, the Project Engineer or his designated representative may visit the manufacturing plant for a project-specific inspection if deemed necessary. If possible, the project-specific inspection shall be prior to or during the manufacturing of the geotextile rolls for that particular project. The purpose of the plant inspections is to review the manufacturing process and quality control procedures.

The manufacturing plant inspection shall include:

1. Verification that properties of the geotextile guaranteed by the Manufacturer are met and meet the project specifications.

2. Verification that the measurement of properties by the manufacturer is properly documented and test methods used are acceptable.

3. Inspection of the rolls and verification that they are free of imperfections or any sign of contamination by foreign matter.

4. Review of packaging, handling, storage, and transportation procedures and verification that these procedures will not damage the geotextile.

5. Verification that roll packages have a label indicating the name of the manufacturer, type of geotextile, roll number and roll dimensions.

6. Verification that the geotextiles are inspected continuously for the presence of needles using a metal detector.

A report describing the inspection will be retained by the Owner for periodic inspections and by the Project Engineer for project-specific inspections.

1.3 Quality Control Documentation

Prior to the shipment of any geotextile, the Manufacturer shall provide the Resident CQA Engineer with the following information:

1. Results of tests conducted by the Manufacturer to verify that the material used to manufacture the geotextile meets the project specifications.

2. A specification for the geotextile that includes all properties contained in the Project Technical Specifications were measured using the appropriate test methods.

3. Written certification that minimum values given in the Project Technical Specifications are guaranteed by the Manufacturer.

4. Quality control certificates, signed by a responsible party employed by the Manufacturer. Each quality control certificate shall include roll identification numbers, testing procedures, and the results of quality control tests. At a minimum, results shall be given for the following:

Property	Test Method	Frequency
Mass per Unit Area	ASTM D-5261	Each Roll
Grab Tensile Strength	ASTM D-4632	Every 5th Roll
Grab Tensile Elongation	ASTM D-4632	Every 5th Roll
Puncture (pin) Strength	ASTM D-4833	Every 5th Roll
Apparent Opening Size (AOS)	ASTM D-4751	Every 5th Roll

The Manufacturer shall identify all rolls of geotextiles with the following:

Manufacturer's name
Product identification
Thickness
Roll number
Roll dimensions

The Resident CQA Engineer shall review these documents and shall report any discrepancies with the above requirements to the Project Engineer. The Resident CQA Engineer shall verify that:

Property values certified by the Manufacturer meet all of its guaranteed specifications.

Measurements of properties by the Manufacturer are properly documented and that the test methods used are acceptable.

Quality control certificates have been provided at the specified frequency for all rolls, and that each certificate identifies the rolls related to it.

Rolls are appropriately labeled.

Certified minimum properties meet the project specifications.

1.4 Conformance Testing

1.4.1 Sampling Procedures

Upon delivery of the rolls of geotextiles, the Resident CQA Engineer shall ensure that conformance test samples are obtained for the geotextile. The rolls to be sampled shall be selected by the Resident CQA Engineer. Samples shall be taken from any portion of a roll that has not been damaged. Unless otherwise specified, samples shall be 3 ft (1 m) long by the roll width. The Resident CQA Engineer shall mark the machine direction on the samples with an arrow. All lots of material and the particular test sample that represents each lot should be defined before the samples are taken.

A lot shall be defined as a group of consecutively numbered rolls from the same manufacturing line. Alternatively, a lot may be designated by the Certifying CQA Engineer based on a review of all roll information including quality control documentation and manufacturing records.

Unless otherwise specified in the project specifications, samples shall be taken at a rate of one per lot, not to be less than one per 100,000 ft^2 of geotextile. These samples shall then be forwarded to the Geosynthetic laboratory for testing to ensure conformance with the project specifications.

1.4.2 Conformance Tests

The following conformance tests shall be conducted;

Mass per Unit Area (ASTM D5261)
Grab Tensile Strength (ASTM D4632)
Grab Tensile Elongation (ASTM D4632)
Puncture Strength (ASTM D4833)
Apparent Opening Size (ASTN D4751)

1.4.3 Test Results

All conformance test results shall be reviewed and accepted or rejected by the Certifying CQA Engineer prior to the deployment of the geotextile. The Certifying CQA Engineer shall examine all results from laboratory conformance testing and shall report any non-conformance to the Project Engineer. The Certifying CQA Engineer shall be responsible for checking that all test results meet or exceed the property values listed in the project specifications.

If a test result is in nonconformance, all material from the lot represented by the failing test shall be considered out-of-specification and rejected. Alternatively, at the option of the Project Engineer, additional conformance test samples may be taken to "bracket" the portion of the lot not meeting the project specification. This procedure is valid only when all rolls in the lot are consecutively produced and numbered from one manufacturing line. To isolate the out-of-specification material, additional samples must be taken from rolls that have roll numbers immediately adjacent to the roll that was sampled and failed. If both additional tests pass, the roll that represents the initial failed test and the roll manufactured immediately after that roll (next large roll number) shall be rejected. If one or both of the additional tests fail, then the entire lot shall be rejected or the procedure repeated with two additional tests that bracket a greater number of rolls within the lot.

2.0 Geocomposites

2.1 Definition and Applicability

Geocomposites are geosynthetic nets with geotextile heat bonded to the surface. The geocomposite can be single-sided or double-sided depending on the application. They are used as a drainage medium in lining systems, where the properties of the geotextile can either serve as a filter media from clogging the geonet or increase stability of the lining system. This Section is applicable to geocomposites where the geonet portion is made of high density polyethylene (HDPE), including "foamed" HDPE products but is not applicable to geocomposites where the geonet is made of other polymers.

2.2 Manufacturing Plant Inspection

The Owner or appropriate representative may conduct a periodic inspection of the Manufacturer's plant. In addition, the Project Engineer, or his designated representative may visit the manufacturing plant for a project-specific inspection if deemed necessary. If possible, the project-specific inspection shall be prior to or during the manufacturing of the geocomposite rolls for that particular project. The purpose of the inspection is to review the manufacturing process and quality control procedures.

The manufacturing plant inspection shall include:

Verification that properties guaranteed by the Manufacturer are met and meet all project specifications.

1. Verification that properties guaranteed by the Manufacturer are met and meet all Project Technical Specifications.

2. Verification that the measurement of properties by the Manufacturer is properly documented and test methods used are acceptable.

3. Spot inspection of the rolls and verification that they are free of imperfections or any sign of contamination by foreign matter.

4. Review of packaging, handling, storage, and transportation procedures and verification that these procedures will not damage the geocomposite.

5. Verification that the geotextiles are inspected continuously for the presence of needles using a metal detector.

6. Verifications that roll packages have a label indicating the name of the manufacturer, type of geocomposite, roll number and roll dimensions.

A report describing the inspection will be retained by the Owner for periodic inspections and by the Project Engineer for project-specific inspections.

2.3 Production

The geocomposite shall be manufactured by heat bonding the geotextile to the HDPE drainage net on one or both sides. No burn through geotextiles shall be permitted. No glue or adhesive shall be permitted.

The geonet portion of the geocomposite shall be manufactured by extruding two sets of strands to form a three (3) dimensional structure to provide planar water flow.

2.4 Quality Control Documentation

Prior to the shipment of any geocomposite, the Manufacturer shall provide the Resident CQA Engineer with the following information:

1. The origin (supplier's name and production plant) and identification (brand name and number) of the resin used for geonet.

2. Copies of dated quality control certificates issued by the geonet resin supplier.

3. Results of tests conducted by the Manufacturer to verify that the resin used to manufacture the geonet meets the Project Technical Specifications.

4. A statement indicating that the amount of any reclaimed polymer added to the resin during manufacturing was done with appropriate cleanliness.

5. A list of the materials that comprise the geonet, expressed in the following categories as a percent by weight: polyethylene, carbon black, other additives.

6. Results of tests conducted by the Manufacturer to verify that the material used to manufacture the geotextile meets the Project Technical Specifications.

7. A specification for the geocomposite that includes all properties contained in the Project Technical Specifications measured using the appropriate test methods.

8. Written certification that minimum values given in the Project Technical Specification are guaranteed by the Manufacturer.

9. Quality control certificates, signed by a responsible party employed by the Manufacturer. Each quality control certificate shall include roll identification numbers, testing procedures, and results of quality control tests. At a minimum, results shall be given for the following:

GEONET COMPONENT		
Property	**Test Method**	**Frequency**
Density	ASTM D1505 or ASTM D792, Method B	Every 5th Roll
Thickness	ASTM D5199	Each Roll
Carbon Black Content	ASTM D1603 or D4218	Every 5th Roll
Peak Tensile Strength	ASTM D5035	Every 5th Roll
Transmissivity (MARV)	ASTM D4716	Every 5th Roll
GEOTEXTILE COMPONENT		
Property	**Test Method**	**Frequency**
Mass per Unit Area	ASTM D5261	Each Roll
Grab Tensile Strength	ASTM D4632	Every 5th Roll
Grab Tensile Elongation	ASTM D4632	Every 5th Roll
Puncture Strength	ASTM D4833	Every 5th Roll
Permittivity (min. avg.)	ASTM D4491	Every 5th Roll
Apparent Opening Size (AOS)	ASTM D4751	Every 5th Roll
UV Stability, % Retained (500 hr.)	ASTM D4355	Every 5th Roll

GEOCOMPOSITE		
Property	**Test Method**	**Frequency**
Ply Adhesion	ASTM D7005	Every 5th Roll
Transmissivity (MARV)	ASTM D4716	Every 5th Roll

The manufacturer shall identify all rolls of geocomposite with the following:

Manufacturers Name
Product Identification
Roll Number
Roll Dimensions

The Resident CQA Engineer shall review these documents and shall report any discrepancies with the above requirements to the Project Engineer. The Resident CQA Engineer shall verify that:

Property values certified by the Manufacturer meet all of its guaranteed specifications.

Measurements of properties by the Manufacturer are properly documented and that the test methods used are acceptable.

Quality control certificates have been provided at the specified frequency for all rolls, and that each certificate identifies the rolls related to it.

Rolls are appropriately labeled.

Certified minimum properties meet the project specifications.

2.5 Conformance Testing

2.5.1 Sampling Procedures

Upon delivery of the rolls of geocomposite, the Resident CQA Engineer shall ensure that conformance test samples are obtained for the geocomposite. The rolls to be sampled shall be selected by the Resident CQA Engineer. Samples shall be taken from any portion of a roll that has not been damaged. Unless otherwise specified, samples shall be 3 ft. (2 m) long by the roll width. The Resident CQA Engineer shall mark the machine direction on the samples with an arrow.

A lot shall be defined as a group of consecutively numbered rolls from the same manufacturing line. Alternatively, a lot may be designed by the Certifying CQA Engineer

based on a review of all roll information including quality control documentation and manufacturing records.

Unless otherwise specified in the project specifications, samples shall be taken at a rate of one per lot, not to be less than one per 100,000 ft^2 of geocomposite. These samples shall then be forwarded to the Geosynthetic laboratory for testing to ensure conformance to the project specifications.

2.5.2 Conformance Tests

The following conformance tests shall be conducted;

Ply Adhesion (ASTM D7005)
Transmissivity (ASTM D4716)

2.5.3 Test Results

All conformance test results shall be reviewed and accepted or rejected by the Certifying CQA Engineer prior to the deployment of the geocomposite. The Certifying CQA Engineer shall examine all results from laboratory conformance testing and shall report any non-conformance to the Project Engineer. The Certifying CQA Engineer shall be responsible for checking that all test results meet or exceed the property values listed in the project specifications.

If a test result is in nonconformance, all material from the lot represented by the failing test shall be considered out-of-specification and rejected. Alternatively, at the option of the Project Engineer, additional conformance test samples may be taken to "bracket" the portion of the lot not meeting the project specification. This procedure is valid only when all rolls in the lot are consecutively produced and numbered from one manufacturing line. To isolate the out-of-specification material, additional samples must be taken from rolls that have roll numbers immediately adjacent to the roll that was sampled and failed. If both additional tests pass, the roll that represents the initial failed test and the roll manufactured immediately after that roll (next large roll number) shall be rejected. If one or both of the additional tests fail, then the entire lot shall be rejected or the procedure repeated with two additional tests that bracket a greater number of rolls within the lot.