### NCHRP 20-44(27) FACILITATING BALANCED MIX DESIGN IMPLEMENTATION

### FINAL CONDUCT OF RESEARCH REPORT

Prepared for National Cooperative Highway Research Program Transportation Research Board

of

The National Academies of Sciences, Engineering, and Medicine

Randy C. West National Center for Asphalt Technology Auburn, Alabama 36830 September 2022

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### SUMMARY

In September 2015, the FHWA Expert Task Group on Mixtures and Construction formed a Task Force on Balanced Mix Design (BMD) that defined BMD as "asphalt mix design using performance tests on appropriately conditioned specimens that address multiple modes of distress taking into consideration mix aging, traffic, climate and location within the pavement structure." BMD infers that mixtures are designed to provide adequate resistance to rutting and cracking using appropriately selected mixture performance tests rather than relying solely on volumetric guidelines.

The National Center for Asphalt Technology (NCAT) completed NCHRP 20-07/Task 406 *Development* of a Framework for Balanced Mix Design in August 2018. The proposed framework allows state Departments of Transportation (DOTs) to select performance tests of their choice for evaluation of mixture rutting resistance, cracking resistance, and moisture damage resistance. The project final report included an analysis of knowledge gaps and recommended research needs that should be addressed in order to continue progress toward the implementation of BMD. The final report also included two proposed provisional standards for BMD that were balloted by AASHTO COMP and subsequently approved as provisional standards in 2019. These standards are MP 46-20 Balanced Mix Design and PP 105 Balanced Design of Asphalt Mixtures.

### CHAPTER 1

# **Project Objective and Scope**

The objective of this project was to assist DOTs and contractors in the early stages of BMD implementation by providing up-to-date information on using simple but robust mixture performance tests as part of mix design and quality assurance.

The project included three tasks to facilitate BMD implementation as follows:

- **Task 1** Propose updates and refinements to the AASHTO provisional BMD standards based on new information from ongoing research on test methods, aging protocols, and laboratory and/or field studies from which criteria may be established.
- Task 2 Conduct six online BMD workshops to share information with stakeholders in states where efforts to implement BMD are progressing quickly.
- **Task 3** Organize and host a national BMD conference to share information and lessons learned from DOTs and contractors that have lead BMD efforts as well as to identify gaps in knowledge yet to be adequately addressed.

## CHAPTER 2

# Summary of Work Completed

The following sections describe the work completed as fulfillment of the three tasks to facilitate implementation of Balanced Mix Design.

#### Task 1 – Proposed Updates and Refinements to the AASHTO Provisional BMD Standards

In January 2021, NCAT submitted a redlined version of MP 46-20 with suggested revisions to some of the mixture performance tests and criteria in the specification document. Most of the revisions were accepted by the AASHTO COMP and have been incorporated into MP 46-22. In September 2022, NCAT proposed additional revisions to MP 46-22 based on the most recent information on the use of mixture performance tests and criteria for BMD among state DOTs. These revisions are highlighted with track changes in Appendix A.

#### Task 2 – Online BMD Workshops

The six online BMD workshops were completed between September and December 2020. Table 1 list the dates, locations and number of participants for the six workshops.

Table 1. Dates and Elocations of Online DMD workshops			
Dates	State	DOT Point of Contact	No. of Participants
Sept. 1-3, 2020	Tennessee	Matthew Chandler	29
Sept. 15-17, 2020	Vermont	Aaron Schwartz	39
Oct. 21-23, 2020	Arizona	Jesús Sandoval-Gil	38
Nov. 4-6, 2020	Nebraska	Robert Rea	34
Nov. 17-19, 2020	Oregon	Chris Duman	27
Dec. 7-9, 2020	North Carolina	Todd Whittingham	30

Table 1. Dates and Locations of Online BMD Workshops

The workshops were conducted as three 2-hour sessions on consecutive days using Zoom. The contents of the workshops were customized for the specific state depending on their selection or preferences for BMD tests, progress toward implementation, and the agency's mixture QA program. An example agenda is provided in Table 2.

Day 1: Sept	ember 1, 9 – 11 AM Central Time	
Duration	Topic	Presenter
15 min	The Need for a New Era of Asphalt Mix Design	Randy West
20 min	BMD Approaches and State of Practice	Fan Yin
25 min	Asphalt Mixture Performance Tests	Randy West
20 min	Development and Implementation of a BMD Specification	Fan Yin
20 min	BMD Efforts in Tennessee	Randy & Matt Chandler
20 min	Open Discussions	Randy & Fan

Table 2. Agenda for the Tennessee BMD Workshop

Day 2: September 2, 9 – 11 AM Central Time		
Duration	Торіс	Presenter
50 min	IDEAL-CT Cracking Test	Adam Taylor
50 min	Rutting and Moisture Damage Tests	Nathan Moore
20 min	Open Discussions	Adam & Nathan

Day 3: September 3, 9 – 11 AM Central Time Duration Topic Presenter 30 min Using Performance Tests During Production Randy West Benchmarking Existing Mix Designs 15 min Fan Yin Interlaboratory Evaluations of Performance Tests 15 min Fan Yin Randy West 15 min Using Performance Tests in Quality Assurance **BMD Shadow and Pilot Projects** Randy West 10 min 10 min Training on Mixture Performance Tests Fan Yin 10 min **BMD** Resources Fan Yin 15 min **Open Discussions** Randy & Fan

A full list of participants for all six workshops is included in Appendix B. Participants were provided links to the presentation materials and other virtual handouts in advance of the sessions and links to the Zoom recordings after the sessions are completed. Participants were also provided Professional Development Hour certificates for the workshop if they requested them.

Overall, participants were appreciative of the information and discussions that will be helpful as they move along the steps toward implementation.

#### Task 3 – National BMD Conference

The National BMD Conference was held September 2-3, 2021, at the Loews Vanderbilt Hotel in Nashville, TN. The conference was free to all participants and was held live and broadcast via Zoom to virtual attendees. The conference agenda is shown in Figure 1.

Approximately 60 people participated in person and over 100 participated online; the registration list is included in Appendix C. Feedback on the conference was excellent. In particular, many participants especially liked the small discussions during the breakout sessions. Recordings of the conference sessions were emailed to attendees in September.

### NATIONAL BALANCED MIX DESIGN

IMPLEMENTATION CONFERENCE

#### **THURSDAY, SEPTEMBER 2**

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### BMD RESOURCES

Scan this QR code or visit aub.ie/bmd for additional resources related to balanced mix design.



This conference is funded by NCHRP 20-44 (27) Facilitating Balanced Mix Design Implementation and organized by the National Center for Asphalt Technology.

Figure 1. National BMD Conference Agenda

Key takeaways from presentations from the BMD early adopters states and contractors were:

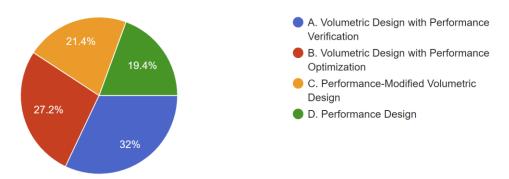
- The Vermont Agency of Transportation (VTrans) is motivated to implement BMD as a means to increase RAP contents and improve resistance of asphalt pavements to a variety of distresses. VTrans initially selected the HWTT and the I-FIT for BMD and began benchmarking plant produced mixtures in 2015. These results were used to support the decision in 2017 to switch to PG 70-28 for most mainline paving. Pilot projects began with Type IVS (9.5 mm surface) using Approach A. TSR was eliminated. Challenges and impediments so far have been issues with HWTT data storage and HWTT turn-around time. VTrans' BMD special provision is on hold while the agency evaluates a variety of related issues including surrogate tests, and aging. Industry experience so far is one contractor that has acquired all necessary BMD equipment. An interesting contractor finding was that binder source made a large difference on FI results but the impact was different depending on the aggregate type. Split sample FI testing indicate differences between agency and contractor lab results. Results also showed that PMLC and LMLC were different, with production results indicating lower stiffness.
- Virginia is motivated to deploy BMD as a pathway to improve the life and durability of asphalt pavement as well provide a means to allow for more sustainable and innovative mix designs. VDOT established an aggressive timeline for implementation beginning in 2018 and an anticipated initial implementation date of 2023. They are primarily using Approach A and using volumetrics for field control, and also have a mix design approach between Approach C and D, but still using traditional volumetric controls during production. Their BMD tests are IDEAL-CT, APA, and Cantabro. They have been building a database of mixtures and used that to set preliminary criteria, but recognize that they lack long-term validation of those criteria. Early shadow projects are being monitored for lab to field correlation. Challenges are dealing differences between unreheated versus reheated mix samples, additional manpower and equipment needs, and training. The contractor experience on pilot projects provided a learning experience. BMD mixes required changes in aggregate materials, increasing asphalt contents, and a recycling agent or a softer binder grade. The pilot projects required a significantly higher demand on QC operations, and raised issues limited ovens capacity and lab space.
- New Jersey DOT began using mix performance tests (Bending Beam Fatigue, Overlay Test and APA) for specialty mixes over 10 years ago based on research by Dr. Tom Bennert at Rutgers University. Key factors in test selection were sensitivity to mix parameters, correlation to field data, testing time, and simplicity of analysis. Mixtures are sampled and tested during production. NJDOT challenges are turn-around time, lab space, and retention of technicians. Positive industry response on opportunity to work outside the box, but obstacles are time to complete tests, additional mix design costs, specialty asphalt binders, slower production, and the need for more training. Keys to success are good communication between agency and industry, benchmarking and being transparent with results.
- Maine DOT is motivated to implement BMD to improve pavement performance and allow for mix design innovations. They have evaluated several rutting and cracking tests. They have a benchmarking database with approximately 1300 HWTT tests, 2000 AMPT tests, 3200 IDEAL-CT tests, 1600 IDEAL-RT tests, and 350 HT-IDT tests. They are moving forward with IDEAL-CT and IDEAL-RT.
- Wisconsin DOT is progressing toward BMD implementation. They funded several studies to examine different BMD tests and aging protocols. They selected the HWTT to assess rutting resistance and the IDEAL-CT for evaluating cracking resistance. They've been building a benchmarking database, drafted a BMD pilot special provision for the primary upper layer, and are planning a study quantify the production variability of HWTT and IDEAL-CT and to validate criteria with field test sections.

Breakout session discussions covered four topics with the following questions and responses collected among live and virtual participants.

- 1. Which of the BMD approaches do you prefer for mix design approval?
  - A: Volumetric Design with Performance Verification
    - B: Volumetric Design with Performance Optimization
    - C: Performance-Modified Volumetric Design
    - D: Performance Design

Which of the BMD approaches do you prefer for mix design approval?

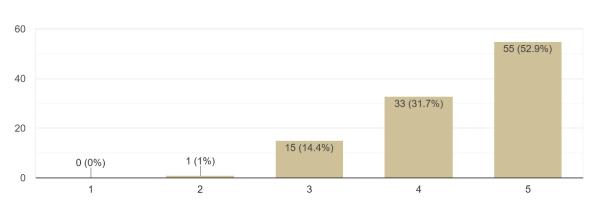
103 responses



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- 2. From your perspective, which sources of data should be used to set BMD criteria? Agree or Disagree on a 1 to 5 scale
  - Benchmarking data
  - PMS data linked with BMD test results
  - Criteria from other states
  - Lab-to-field correlations from experimental test sections.

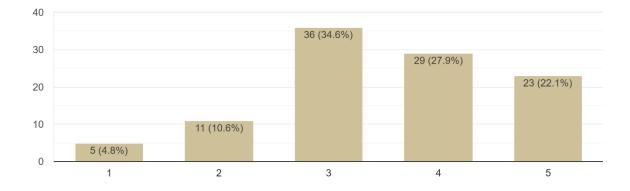


Benchmarking Data

104 responses

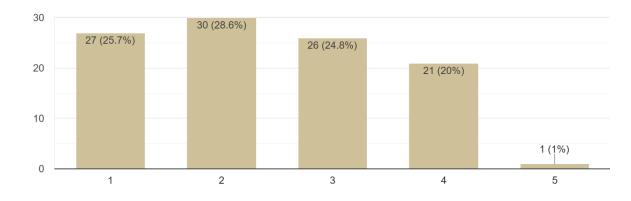
#### PMS data linked with BMD test results

104 responses

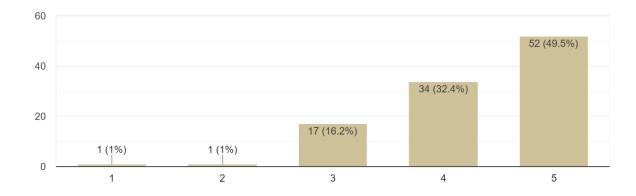


### Criteria from other states

105 responses



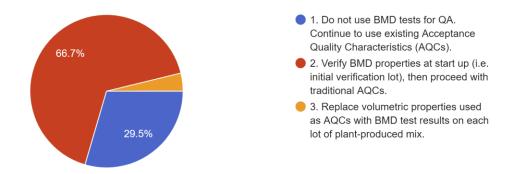
# Lab-to-field correlations from experimental test sections 105 responses



## 3. Which approach would you prefer for Quality Assurance at the BEGINNING of implementation?

Which approach would you prefer for Quality Assurance at the BEGINNING of implementation?

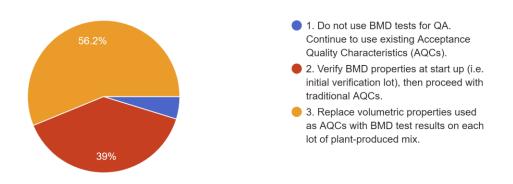
105 responses



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4. Which approach would you ULTIMATELY prefer for Quality Assurance after several years?

Which approach would you ULIMATELY prefer for Quality Assurance after several years?

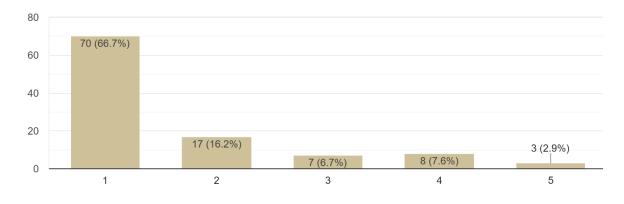


5. Agree or Disagree on a 1 to 5 scale

- Mix aging is NOT a critical issue at this time.
- Mix aging must be included with MIX DESIGN cracking tests for surface mixes.
- Mix aging must somehow be assessed with cracking tests used for Quality Assurance of surface mixes.

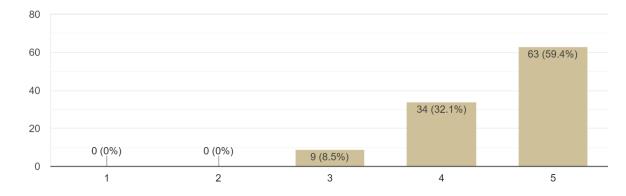
### Mix aging is NOT a critical issue at this time

105 responses



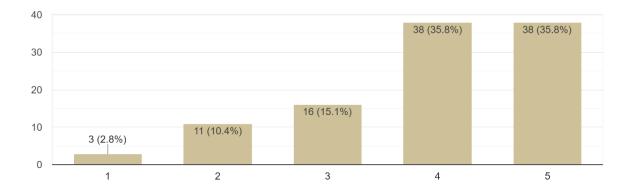
### Mix aging must be included with MIX DESIGN cracking tests for surface mixes

106 responses



Mix aging must somehow be assessed with cracking tests used for Quality Assurance of surface mixes

106 responses



## APPENDIX A

# Sept. 2022 Proposed Revisions to MP 46-22

(The proposed revisions to MP 46 (2022) have been excluded from the report for AASHTO evaluation)

## APPENDIX B

# Participant Lists for Six Online Workshops

Table 1. Dates and Loca	dons of Onnic Divil	vvorksnops	
Dates	State	DOT Point of Contact	No. of Participants
Sept. 1-3, 2020	Tennessee	Matthew Chandler	29
Sept. 15-17, 2020	Vermont	Aaron Schwartz	39
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Nov. 17-19, 2020	Oregon	Chris Duman	27
Dec. 7-9, 2020	North Carolina	Todd Whittingham	30

Table 1. Dates and Locations of Online BMD Workshops

Name	Organization	Contact Information
Ted Bryant		
Chad Norton		
Mike Hemsley	Paragon Technical Services	
Austin Bateman	Delta Contracting	
Will Hunt		
Jared Nix	Rogers Group	
Tim Murphy	Vulcan Materials	
Cliff Dye	TN DOT	
Scott Gilliam	TN DOT	
Randall Gilliam	TN DOT	
Tony Renfro	TN DOT	
Kevin Isenberg	TN DOT	
Jason Dryden	TN DOT	
Hossam Bahour	TN DOT	
John Asherbranner	TN DOT	
Mike Doran	TN DOT	
David Royster	TN DOT	
Billy Goins	TN DOT	
Brad Baskette	TN DOT	
Heather Purdy Hall	TN DOT	
Matthew Chandler	TN DOT	
Hong Park	TN DOT	
Tyler Lacy	TN DOT	
Frank Sadler	TN DOT	
Kara Shears	TN DOT	
Lindsey Skaggs	TN DOT	
Frankie Murphy	TN DOT	
Larry Doles	TN DOT	
Matt Jeffers	Ergon	

### Vermont, Sept. 15-17, 2020

Name	Organization	Contact Information	
Bud Clough			
John Hall			
Tim French			
Jim McNall			
Richard Cook			
Fuller Sand and Gravel			
Matt Geoffroy			
Mike Bailey			
Aaron Roy			
John Cawthern			
Mark Gray			
Mark Peloquin			
Jeffery Greer			
Mark Speshock			
Matt Elliott			
Albert Zander			
Chris Thomas			
Brian Hricay			
Gerald Otis			
Ling Cheng			
Peter Moore			
lan Anderson			
Nick Van Den Berg			
Aaron Schwartz			
Katrina Collins			
Ryan Darling			
Troy Larson			
Laura Behymer			
Ben Tabor			
Elise Coolbeth			
Kadyn Garcia			
Trent Coletta			
Brandon Kipp			
Matt Bogacyzk			
Andy Elms			
Tim Wilk			
Steven Dombrowski			
Larkin Wellborn			
Matthew Digiovanni			
		1	

Arizona, Oct. 21-23, 2020

Name	Organization	Contact Information
Jesús A. Sandoval-Gil	AZ DOT	
Brent Conner	AZ DOT	
Abraham Abdulnour	AZ DOT	
Isaac Conez	AZ DOT	
Jessica Banner	AZ DOT	
Murari M. Pradhan	AZ DOT	
Kelly Baum	AZ DOT	
Dharminder Sharma	AZ DOT	
Joshua Bailey	AZ DOT	
Danny Brock	AZ DOT	
Martin Coronado	AZ DOT	
Aaron R. Robert	AZ DOT	
Nye McCarty	AZ DOT	
Brian Lasham	Granite	
Cristian Velazquez	Granite	
Bruce Victory	FNF Construction, Inc.	
Thomas C. Ludlum	HollyFrontier Asphalt Company	
Brian Frazier	Town of Marana	
Morris Reyna	Town of Marana	
Mark Navarro	Town of Oro Valley	
Rubben K. Lolly	City of Phoenix	
David Orchekowsky	Pima County DOT	
Robert Lane	Pima County DOT	
Xavier de la Garza	Pima County DOT	
Joseph A. Phillips	Terracon	
Miguel Romo	MRM Construction Services, Inc.	
Juan Carlos Villegas	MRM Construction Services, Inc.	
Elizabeth Ortega	MRM Construction Services, Inc.	
David Simon	MRM Construction Services, Inc.	
Carey Oberheim	City of Prescott	
Brad J. Parker	Vulcan	
Matt Manthey	Mesa City Transportation Dept.	
Jeyakaran Thavathurairaja	Integer Consulting LLC.	
Mike Davenport	Solterra Materials	
Sathish Banda	Western Technologies Inc.	
Raphael Tixer	Western Technologies Inc.	
Don Cornelison	Speedie and Associates	
Robert Sowder	AZ DOT	

Name	Organization	Contact Information
Corey Hilbrands	Omni Engineering	
Gregg Leber	Constructors, Inc.	
Mackenzie Hayden	Constructors, Inc.	
Mike Collins	Knife River Midwest	
Robert Rea	NDOT	
Andy Dearmont	NDOT	
Mick Syslo	NDOT	
Jody Paul	NDOT	
Jacob Reynolds	NDOT	
Mike Reynolds	NDOT	
Jerry Isom	NDOT	
Terry Becker	NDOT	
James Smith	NDOT	
Cal Splattstoesser	NDOT	
Kimberly Kirchner	NDOT	
Brandon Remm	NDOT	
Stacy Burford	NDOT	
Kathy Fread	NDOT	
Michael Eich	NDOT	
Allissa Reinhard	NDOT	
Asad Sahak	NDOT	
Amy Tran	NDOT	
Sean Johnson	NDOT	
Bruce Barrett	NDOT	
Kellie Troxel	NDOT	
Hamzeh Haghshenas	UNL	
Nitish Bastola	UNL	
Nima Aminpour	UNL	
Mahdieh Khedmati	UNL	
Shin-Che Huang	FHWA	
Eric Hunsley	Werner Construction	
Matt Soucie	Werner Construction	
David Mraz	FHWA	
Andrew Heuerman	FHWA	

### Oregon, Nov. 17-19, 2020

Name	Organization	Contact Information
Graham Cole	Baker Rock Resources	
Dan Schnurbusch	Knife River Quality Control	
Kevin Jordan	Carlson Testing Inc.	
Michael Miller	RiverBend Materials	
Tyler Lomax	Knife River	
Randy High	Oregon Mainline Paving	
Christopher Duman	Oregon DOT	
Jim Gunter	Oregon DOT	
Tim Earnest	Oregon DOT	
Kelly Warren	Oregon DOT	
Mike Stennett	Oregon DOT	
Larry Ilg	Oregon DOT	
Justin Moderie	Oregon DOT	
Paul Burch	Oregon DOT	
Tom Bosworth	Wildish Sand & Gravel Co.	
Dr. Erdem Coleri	Oregon State University	
Wayne Brown	ODOT	
Paul Mcgrath	ODOT	
Allyson Peterson	ODOT	
Barb Worbington	ODOT	
Scott Young	ODOT	
Andy Clark	ODOT	
David Kirkland	ODOT	
James Brown	ODOT	
James Darnell	ODOT	
Dustin Hass	ODOT	
Travis Evans	High Desert Agg. & Paving	

### North Carolina, Dec. 7-9, 2020

Name	Organization	Contact Information
Dr. Y. Richard Kim	North Carolina State University	
Ellis Powell	САРА	
Todd Wilson	Barnhill Contracting Company	
Marvin Hylton	Thompson-Arthur Paving & Construction	
Richard Wise	Rogers Group Inc.	
Jaehoon Jeong	NC State University	
Bart Roark	Maymead, Inc.	
Todd Whittington	NCDOT	
Matt Hilderbran	NCDOT	
Brian Hunter	NCDOT	
Charles Colgate	NCDOT	
Tony Collins	NCDOT	
Kristin Ewan	NCDOT	
Mehdi Haeri	NCDOT	
Clark Morrison	NCDOT	
Andrew Wargo	NCDOT	
Shihai Zhang	NCDOT	
Josh Holland	NCDOT	
George Boules	NCDOT	
Jim Sawyer	NCDOT	
John Flowers	NCDOT	
Kevin Smith	NCDOT	
Eric Fazekas	NCDOT	
Justin Gill	NCDOT	
Wiley Jones	NCDOT	
Brian Skeens	NCDOT	
Vasyl "Basil" Shymonyak	Carolina Sunrock LLC	
David Branscome	Sharpe Brothers Paving	
Roger Ridenhour Jr.	NJR Group Inc.	
Russel Ross	Fred Smith Company	

## APPENDIX C

# National BMD Conference Flyer, BMD Conference Registration List



Balanced mix design is opening the door to utilizing innovative materials and technologies to design asphalt pavements while providing agencies with a more reliable way to accept mixtures.

BACK-TO-BACK WITH THE AAPT ANNUAL MEETING SEPTEMBER 2-3, 2021 | NASHVILLE, TN

Register and reserve your room at the Loews Vanderbilt Hotel at ncat.us/education/bmd





BMD Conference Attendees List

### National BMD Implementation Conference

### September 2-3, 2021 | Nashville, TN

First	Last	Organization	Thu	Fri
Gina	Ahlstrom	FHWA	/	-
Shamma	AL Kaabi	Al Ain City Municipality		
hossam	bahour	TDOT	~	~
Ann	Baranov	infraTest USA Inc.	1	
Brad	Baskette	TDOT	~	1
Austin	Bateman	Delta Contracting Company, LLC		
Jason	Bausano	Ingevity	~	1
Jim	Bibler	Gilson Company Inc		
Erik	Biggers	Martin Marietta	V	V
Pablo	Bolzan	Universidad CatV≥lica Argentina		
Ramon	Bonaquist	Advanced Asphalt Technologies LLC		1
Jenna	Bowers	Ingevity	~	~
Cory	Bramlett	Stewart Brothers	~	~
Jennifer	Breuer	Superior Bowen		
Dale	Brewer	Delta Contracting Company, LLC	V	~
Stormy	Brewster	Marathon Petroleum Company	1	1
Alicia	Brooks	Luck Stone	~~	
Alicia	Brooks	Luck Stone		
Wade	Collins	PTI	~	~
John	Collins	Sustainable Pavement Technologies		
Ronald	Corun	Ron Corun Consulting LLC		
John	D'Angelo	D,ÄôAngelo Consulting	~	~
Stacey	Diefenderfer	VTRC / VDOT	~	-
Jason	Dryden	TDOT	V	~
Jon	Epps	Texas A&M Transportation Institute		
Fisseha				
Nega	Ezezew	Prome Consultung E g.		
David	Farris	Rogers Group Inc	V	~
Mike	Fielding	Midsouth Paving		
Steve	Flaherty	necoTech	~	~
Jean-Paul	FORT	Colas Inc.		~
Mawazo	Fortunatus	NCAT		
Stevenson	Ganthier	New Jersey Department of Transportation		
	GARBA DAN-			
LAWAN	ALHAJI	University Technology Mara		
Gregory	Garner	Self	~	~

Derek	Gaw	Tennessee DOT		1
mohammad	ghodsian			
Billy	Goins	TDOT Materials and Test	~	1
Amir	Golalipour	FHWA	~	1
Jhony	Habbouche	VTRC	1	1
John	Haddock	Purdue University	1	5
Elie	Hajj	University of Nevada, Reno		
Adam	Hand	UNR	w	1
Steve	Hefel	WisDOT	1	1
Jose	Hernandez	Gardner Asphalt Supply	1	~
Mohammed	Heyder	Iran university of Science & Technology		
Jason	HE	Rogers Group	1	~
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Wayne	Jones	Asphalt institute	~	2
Joyce	Kamau	Iowa State University		
Amir	Khan	Gardner Asphalt Supply		
Sungho	Kim	VDOT		
Abhilash	Kusam	Trimat Materials Testing		
Matthew	LaChance	Ingevity		
Andrew	LaCroix	NVI Advanced Materials Group		
Cheng	Ung	Pike Industries, inc.	~	1
Paul	Lum	Colas Inc.	~	1
Todd	Lynn	Lipscomb University	9	1
Cynthia	Lynn	Thunderhead Testing, LLC	~	~
Tiana	Lynn	NCAT	1	~
Charles	Mills	Asphalt Pavement Association of Michigan	1	~
fariborz	mohammadi			
Nathan	Moore	NCAT		
nikesh	Mundayat	Advanced Construction Technology Services		
Alex	Murchison	Tennessee Department of Transportation	~	V
Hadi	Nabizadeh			
Casey	Nash	Maine Department of Transportation	V	~
Tanya	Nash	ATS	1	1
Rasool	Nemati	AECOM		
Derek	Nener-Plante	FHWA	1	1
Barry	Nunez	Barry L Nunez LLC	~	1
Paul	Oel	George Reed Inc		
Mbakisya	Onyango	University of Tennessee at Chattanooga		
Brian	O'Toole	InstroTek, Inc.		

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