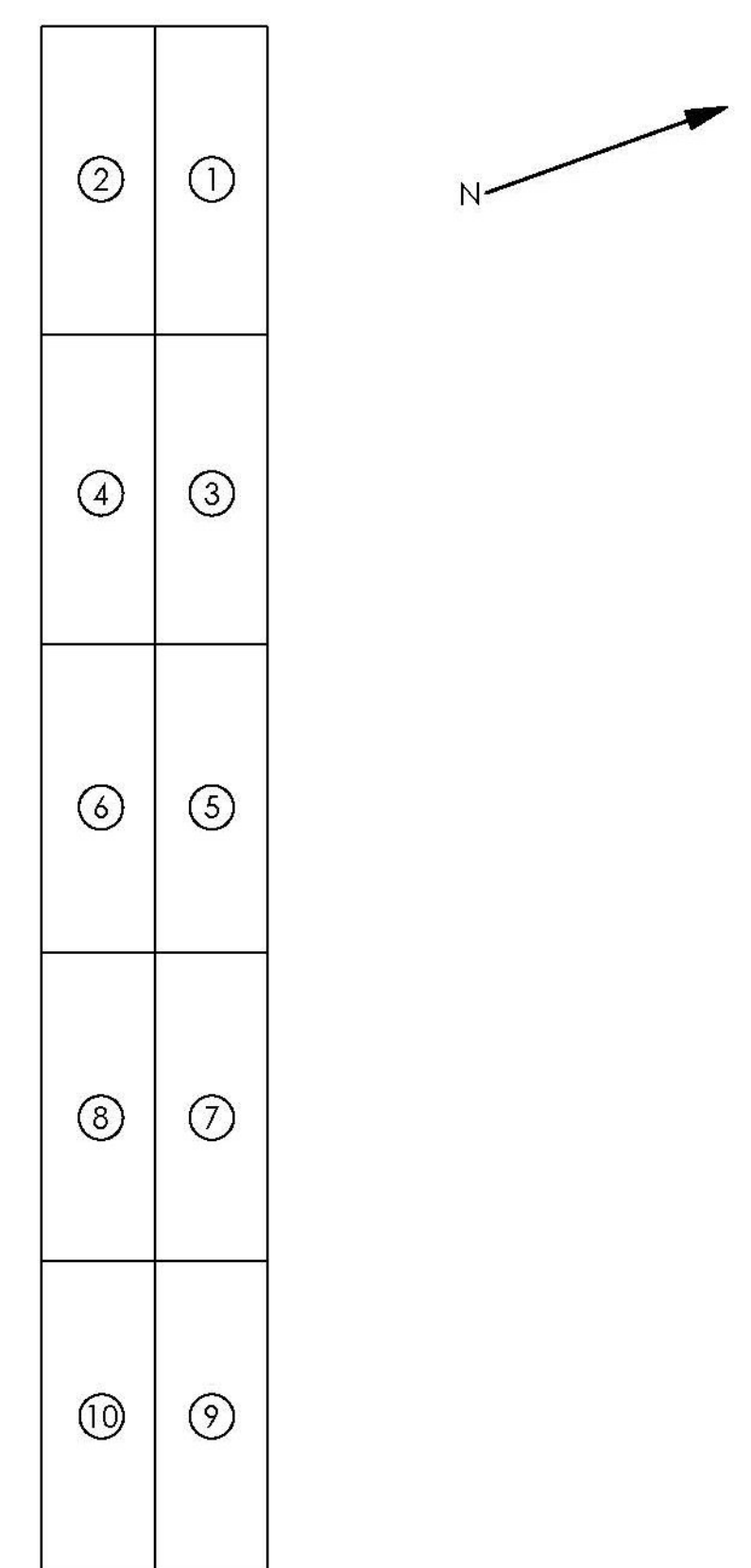


SHEET INDEX:

- 00 COVER SHEET
- 01 GENERAL NOTES
- 02 HULL 3 TO 8 DIMENSIONS
- 03 HULL 3 TO 8 MATERIAL LAYUP SCHEDULE
- 04 END HULL DIMENSIONS
- 05 END HULL MATERIAL LAYUP SCHEDULE
- 06 HULL INFUSION LAYOUT AND DETAILS
- 07 BULKHEAD DIMENSIONS
- 08 END BULKHEADS LAYUP SCHEDULE
- 09 TRANSVERSE ROD BULKHEAD LAYUP SCHEDULE
- 10 MIDDLE LONGITUDAL BULKHEAD LAYUP SCHEDULE
- 11 END LONGITUDAL BULKHEAD LAYUP SCHEDULE
- 12 BULKHEAD INFUSION LAYOUT AND DETAILS
- 13 HALF TOP PLATE DIMENSIONS
- 14 END HALF TOP PLATE DIMENSIONS
- 15 HALF TOP PLATE LAYUP SCHEDULE
- 16 HALF TOP PLATE INFUSION LAYOUT AND DETAILS

ASSEMBLY OF THE PONTOONS USING THE COMPONENTS FABRICATED FROM THIS DRAWING IS DESCRIBED IN DWG: 8420-8.



PONTOON NUMBERING

FABRICATION NOTES

**FABRIC:**  
VECTORPLY E-BXM 4008 ±45  
TEAM 54OZ 0/90 E-GLASS  
PPG C-VEIL E-GLASS

**FLOTATION FOAM:**  
PFPI 23-008(2) URETHANE FOAM

**RESIN:**  
INTERPLASTICS CORVE 8100-50 VINYL ESTER

**ADDITIVES:**  
BASF TINUVIN 328 ULTRAVIOLET LIGHT ABSORBER  
ADVANCED COATINGS A-8-14265 GRAY PIGMENT

**CATALYST:**  
SYRGIS NOROX MEKP 925

**PROMOTERS:**  
DURA CHEMICALS DUROCT COBALT  
PURITAN PRODUCTS DIMETHYLANILINE (DMA)

**TOLERANCES:**  
LENGTH: +/- 1/2"  
ADJACENT UNIT LENGTHS: +/- 1/2"  
DEPTH & WIDTH: +/- 1/4"  
WALL THICKNESS: + 1/16, - 0  
SURFACE FLATNESS: +/- 1/16 PER 48"  
SWEEP: +/- 1/8"  
CAMBER: + 1/2" - 1/4"  
DEVIATION FROM DIAGONALS: +/- 3/4"  
DEVIATION FROM END SQUARENESS: +/- 1/4"  
INSERT OR HOLE LOCATIONS: +/- 1/8"  
VERTICAL DIFFERENTIAL BETWEEN PONTON SURFACES: +/- 1/8"  
FLOATING SPAN OVERALL LENGTH: +/- 1/2"

**REPAIRS:**  
REPAIRS ARE NOT TO EXCEED DEFECTS IDENTIFIED BY ASTM D 2563 (MORE THAN 2 DEFECTS WITHIN A 1 FT RADIUS). TO BE REPAIRED PER KENWAY QA/QC PLAN.

**CURING:**  
PARTS ARE TO BE LEFT IN THE MOLD FOR A PERIOD OF NO LESS THAN 6 HOURS AFTER ALL HOSES HAVE BEEN CLAMPED. PARTS MUST BE UNDER FULL VACUUM PRESSURE FOR A PERIOD OF NO LESS THAN 6 HOURS. BARCOL HARDNESS READINGS OF NO LESS THAN 40 WILL BE ACCEPTABLE.

**SURFACE PREP:**  
CLEAN SURFACE OF CONTAMINENTS INCLUDING MOLD RELEASE AGENT, RESIN RIDGES AND/OR DRIPS.

**GRIT BLASTING:**  
VERTICAL SURFACE THAT MATES WITH ADJOINING PONTOON SHALL BE GRIT BLASTED USING 60-120 MESH GLASS BEADS AT 80 PSI - DURATION SHALL BE APPROXIMATELY 1 MINUTE PER SQ.FT.

**LABELING:**  
EACH PONTOON IS TO BE LABELED WITH KENWAY NAME PLATES ON THE UPSTATION END WALL. IT SHALL INCLUDE AT A MINIMUM THE FABRICATOR NAME, DATE OF MANUFACTURE, AND MARK NUMBER

**WITNESS PANELS:**  
PANELS HAVING A MINIMUM LENGTH AND WIDTH OF 2 FT SHALL BE FABRICATED AT THE SAME TIME AS THE HULL TO BE USED FOR RANDOM TESTING. THE LAYUP SHALL CONSIST OF THE FOLLOWING:  
(1) 1708  
(3) 54  
(1) 1708

**LAYUP REQUIREMENTS:**  
MINIMUM TRANSVERSE LAP SPLICE TO BE 2 INCHES FOR ALL VECTORPLY E-BXM 4008. ~~TEAM 54 OZ MATERIAL MAY BE BUTTED TOGETHER.~~ C-VEIL IS COSMETIC ONLY AND REQUIRES MINIMAL OVERLAP. LONGITUDINAL SEAMS ARE INCLUDED BY DESIGN. NO MORE THAN 2 SPLICES IN THE SAME LOCATION. LAP SPLICES TO BE PER KENWAY FABRICATION DRAWINGS.

**FINISHING:**  
GENERALLY, NO CUTTING OF FINISHED PARTS WILL BE ALLOWED EXCEPT FOR BOLT HOLES AND COPE CORNER IN BULKHEADS AS SHOWN IN DRAWINGS - EXPOSED GLASS SHALL BE FINAL COATED WITH RESIN

**LIFTING:**  
LIFTING OF FINISHED MOLDED PART SHALL ONLY BE BY THE ATTACHED LIFTING LUGS OR BASKET SLING. LIFTING BY ANY OTHER METHOD IS PROHIBITED UNLESS APPROVED BY THE ENGINEER.

**HANDLING/STORAGE:**  
ALL FINISHED PARTS MUST BE HANDLED WITH CARE IN ORDER TO PREVENT DAMAGE. FINISHED PARTS MUST BE PROTECTED FROM UV LIGHT AND SUPPORTED BELOW BULKHEADS. STACKING OF PONTOONS WILL BE ACCEPTABLE.

**INSPECTION:**  
ALL PONTOONS MUST BE INSPECTED BY KENWAY PROJECT ENGINEER & VERMONT DOT AGENCY REPRESENTATIVE PRIOR TO SHIPMENT.

**INFUSION NOTES**  
PERFORATED RELEASE FILM SHALL BE APPLIED OVER THE ENTIRE PART

SHADE CLOTH SHALL BE APPLIED OVER THE PART BUT WILL STOP 3" FROM THE EDGE OF THE PART UNLESS OTHERWISE NOTED

FEED LINES SHALL START AT THE CENTER OF THE PART AND BE SPACED NOMINALLY 16" APART UNLESS OTHERWISE NOTED - FEED TUBE INPUT LOCATIONS SHALL GENERALLY BE AT THE CENTER OF THE FEED LINE

VAC LINES SHALL BE LAID OUT IN SEPARATE ZONES AS NOTED IN THE DRAWING TO ALLOW FOR CLAMPING INDIVIDUAL ZONES IF REQUIRED AND SHALL PROVIDE AT LEAST 6" BETWEEN THE PART AND THE TUBE

RESIN BUCKETS SHALL BE PLACED SUCH THAT THE HEIGHT OF THE RESIN IS EVEN WITH OR UP TO 12" BELOW THE LOWEST POINT ON THE PART

PARTS SHALL BE FED STARTING FROM THE CENTER FEED LINE - ADJACENT LINES SHALL BE OPENED ONCE THE RESIN FLOW FRONT IS APPROXIMATELY 3-4" PAST THE NEXT FEED LINE

A MINIMUM AMOUNT OF RESIN SHALL BE KEPT IN THE BUCKET TO AVOID PULLING AIR INTO THE LINE - LINES WILL ONLY BE CLAMPED ONCE THE RESIN IN THE BUCKET HAS GELLED

FLOODED VAC LINES MAY BE CLAMPED IF NEEDED - HOWEVER, AT LEAST ONE VAC LINE MUST REMAIN OPEN FOR 6 HOURS AFTER THE PART IS FILLED

PART AND RESIN TEMPERATURE SHALL BE BETWEEN 70-90F AT TIME OF INFUSION - ADJUST CATALYST RATIO AS NEEDED TO ACHIEVE 40-60 MINUTE GEL TIME

ANTICIPATED PEAK EXOTHERM DURING CURE IS 230F +/-30F

Vermont Agency of Transportation  
**RECEIVED**  
ON: **June 30, 2014**  
and Checked for  
**CONFORMANCE**  
BY: Jennifer Fitch DATE: 07/07/2014

**T.Y. LIN INTERNATIONAL**  
THE STAMPED DOCUMENTS ARE HEREBY:

APPROVED AS NOTED  
 REVISE AND RESUBMIT

SEE TRANSMITTAL FOR ADDITIONAL INFORMATION AS APPLICABLE.

THIS REVIEW IS FOR GENERAL CONFORMANCE WITH DESIGN CONCEPT ONLY. ANY DEVIATION FROM THE PLANS OR SPECIFICATIONS NOT CLEARLY NOTED BY THE CONTRACTOR HAS NOT BEEN REVIEWED. REVIEW BY THE ENGINEER SHALL NOT RELIEVE THE CONTRACTOR OF THE CONTRACTUAL RESPONSIBILITY FOR ANY ERRORS OR DEVIATION FROM THE CONTRACT REQUIREMENTS.

JOSH OLUND 07/03/2014  
REVIEWER DATE

DATE 6/25/14	DATE 6/25/14
DESCRIPTION ADDED GRIT BLASTING, C-VEIL JOINT AND FINAL COAT NOTE	DESCRIPTION ADDED INFUSION AND CURE TEMP NOTE
REV 1	REV 1
SEAL	
DIMENSIONS ARE IN INCHES TOLERANCES: +0, -1/16" FRACTIONAL + ANGULAR, MACH + TWO PLACE DECIMAL + THREE PLACE DECIMAL ±	
DRAWN BY ML	DATE 6/4/14
CHKD BY JM	DATE 6/4/14
PROJECT BROOKFIELD FRP PONTOONS	CUSTOMER MILLER CONST. / VTRANS
GENERAL NOTES	
WEIGHT:	N/A
DESCRIPTION:	FABRICATION
SCALE:	1 : 64
WO NO.:	8420
CONTRACT NO.:	9185
DWG NO.:	8420-6
SHEET:	1 OF 16
PONTOON:	N/A
PART NO.:	N/A