1. BOND 6 PIECES OF 3" FRP ANGLE TO TOP EDGE OF HULL AS SHOWN (SEE SHEET 1 FOR NOMINAL 1/8" BOND LINE) - CLAMP FLUSH TO TOP OF MOLD
2. BOND LIFTING PLATES TO OUTER TRANSVERSE BULKHEADS AS SHOWN ENSURING A MINIMUM OF 16 SQ.IN. OF BOND AREA (NOMINAL 1/8" BOND LINE)
3. FILL HULL WITH FLOTATION FOAM UP TO THE TOP EDGE OF THE HULL AND BULKHEADS

   3.1 DO A TEST SHOT OF THE FOAM AT START UP TO CHECK DENSITY AND CONSISTENCY OF FOAM

   3.2 ADD IN MULTIPLE LIFTS AS INDICATED IN NOTES BLOCK

   3.3 USE A STRAIGHT EDGE ACROSS THE BULKHEADS TO GAGE THE HEIGHT OF THE FINAL LIFT - CUT OR SAND ANY FOAM THAT EXCEEDS THE DESIRED HEIGHT

   3.4 USE THE STIFFENER TEMPLATE WHEN SPRAYING AND SHAPING FOAM TO ENSURE THERE IS NO INTERFERENCE BETWEEN THE FOAM AND TOP PLATE
4. RELEASE THE HULL FROM THE MOLD USING THE 4 LIFTING LOCATIONS - ENSURE EACH TROLLEY IS CENTERED OVER THE LIFTING POINT
5. PLACE THE PONTOON IN THE SHOP STAGING AREA WITH 8' LENGTHS OF 4X4 BENEATH EACH TRANSVERSE BULKHEAD

Vermont Agency of Transportation

RECEIVED

ON: June 30, 2014

and Checked for

CONFORMANCE

BY: Jennifer Fitch DATE: 07/07/2014

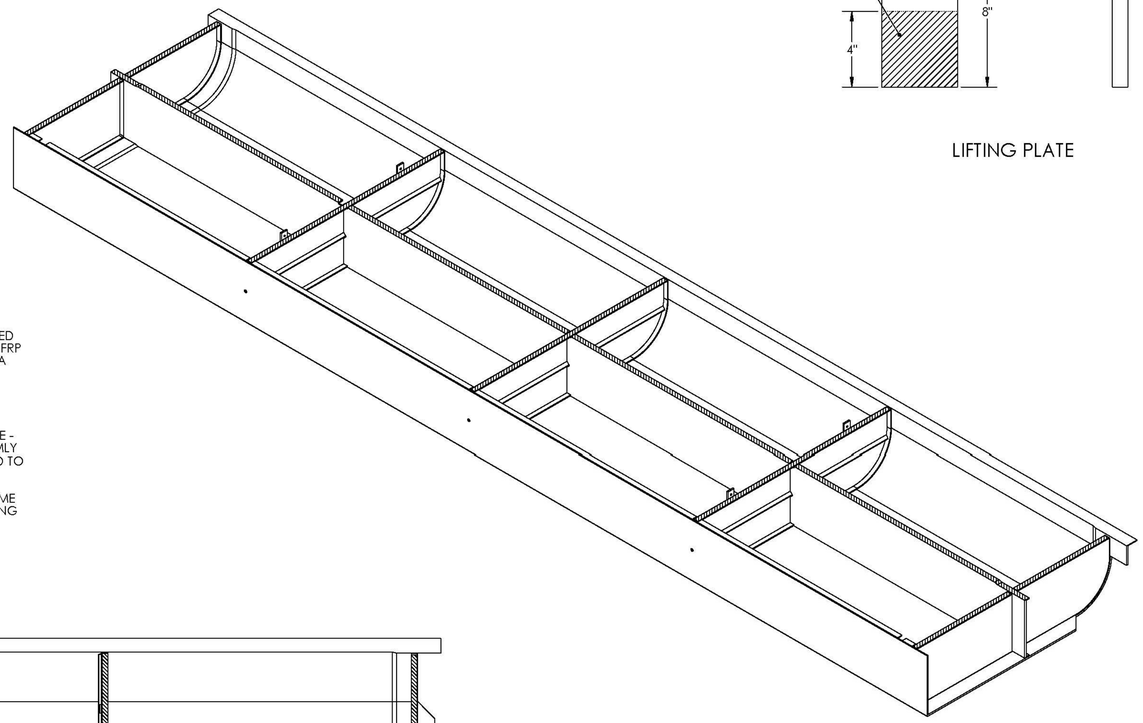
NOTES:

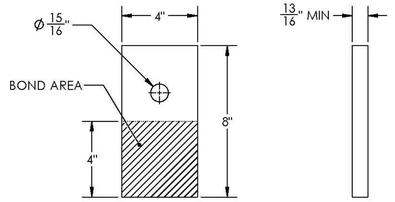
ALL GLUED SURFACES ARE TO BE VACUUM CLEANED AND WIPED WITH ALCOHOL PRIOR TO BONDING - FRP ANGLE MUST BE SCUFFED WITH 60-GRIT USING A DA

SELECT THE PROPER SPACERS WHEN DRY FITTING PARTS TO MAINTAIN NECESSARY BONDLINE - NOMINAL GAP FOR ANGLE AND LIFT PLATE IS 1/8"

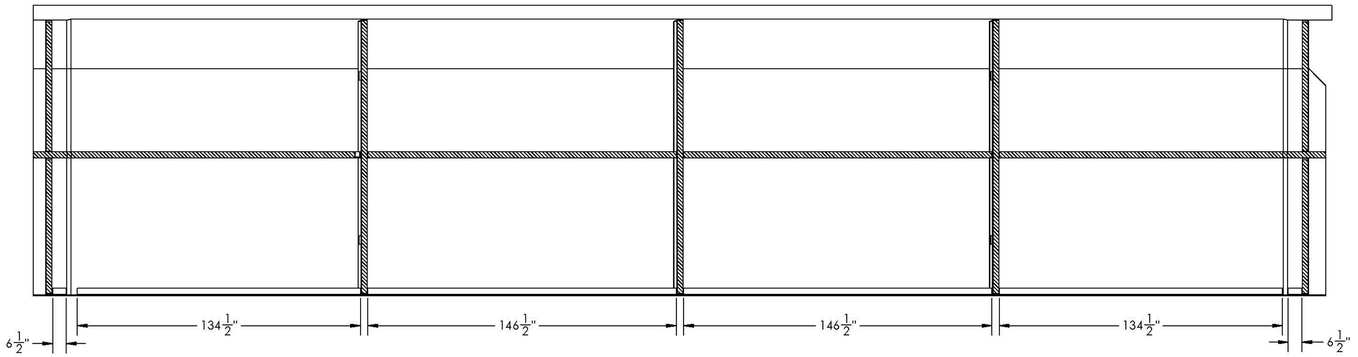
APPLY FOAM IN 10"-12" LIFTS (EXPANDED) AT A TIME - APPROX. 3" WET EXPANDS TO 12" - APPLY UNIFORMLY ACROSS THE BOTTOM OF THE HULL FROM ONE END TO THE OTHER THEN REPEAT FROM START POINT

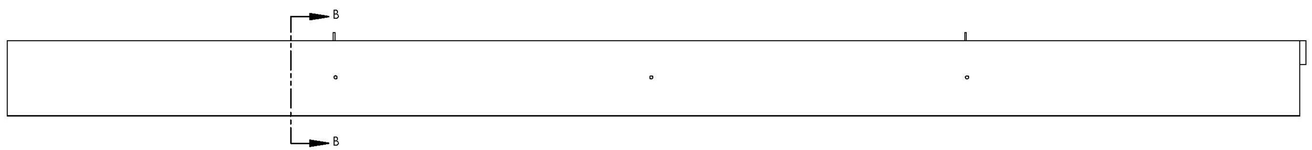
1 FOAM IS TACK FREE IN 120 SEC WITH A FREE RISE TIME OF 155 SEC - WAIT AT LEAST 10 MIN. BEFORE SHAPING

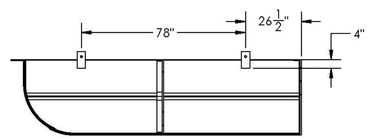





LIFTING PLATE




SECTION B-B
SCALE 1 : 36

**T.Y. LIN INTERNATIONAL**

THE STAMPED DOCUMENTS ARE HEREBY:

__X__ APPROVED
_____ 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 (REVIEWER) 07/03/2014 (DATE)

KENWAY CORP.

| REV | DESCRIPTION | DATE |
|---|---|---|
| | | |

SEAL

DIMENSIONS ARE IN INCHES
TOLERANCES: +0, -1/16"
FRACTIONAL ± BEND ±
ANGULAR MACH ± TWO PLACE DECIMAL ±
THREE PLACE DECIMAL ±

| DRAWN BY | DATE |
|---|---|
| JM | 6/3/14 |
| CHKD BY | DATE |
| XX | X/X/XX |

PROJECT: BROOKFIELD FRP PONTOONS

CUSTOMER: MILLER CONST. / VTRANS

SHEET: PONTOON ASSEMBLY - STEP 3

| | |
|---|---|
| WEIGHT: | 9,755 lb |
| DESCRIPTION: | ASSEMBLY |
| SCALE | 1 : 36 |
| WO NO. | 8420 |
| CONTRACT NO. | 9185 |
| DWG NO. | 8420-8 |
| SHEET | 3 OF 5 |
| PONTOON | PART NO. |
| N/A | N/A |