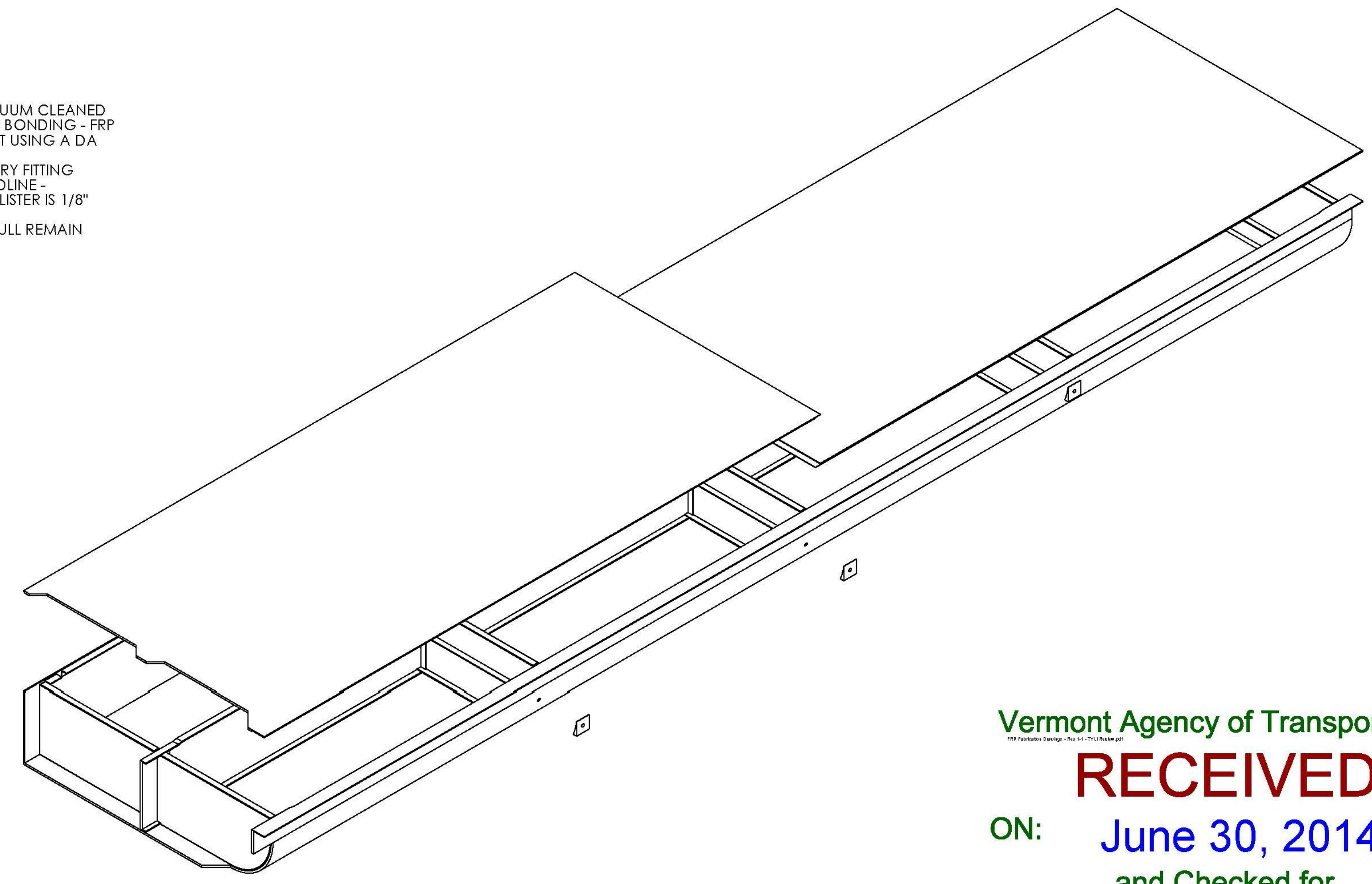




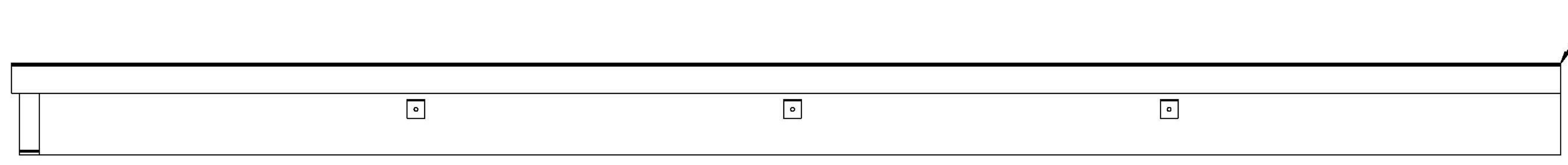
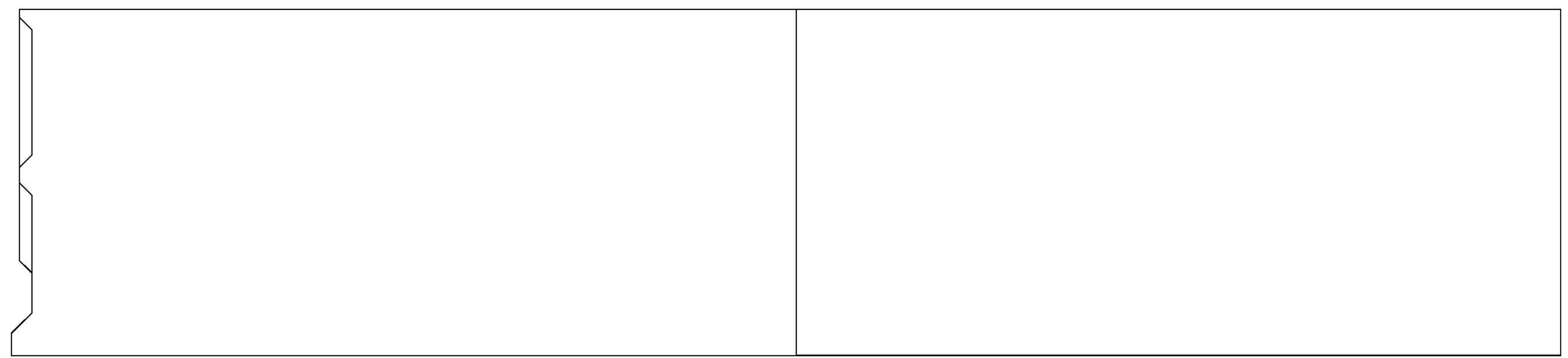
1. REMOVE LIFTING PLATES BY CUTTING FLUSH WITH TOP OF BULKHEAD FLANGE
2. DRY FIT TOP PLATES - PAY ATTENTION TO WHICH PLATE HAS THE LOWER LIP FOR THE LAP JOINT AND PLACE FIRST
3. PLACE 1/8" SPACERS BENEATH TOP PLATES WHEN DRY FITTING AND ENSURE ALL TOLERANCES ARE WITHIN SPEC - ADJUST SPACER THICKNESS AS NEEDED
4. APPLY A 1" WIDE BEAD OF MMA CENTERED ON THE 3" GLUE FLANGES AND A 1-1/2" WIDE BEAD ON THE 6" FLANGE FOR A 1/8" BOND LINE (SEE SHEET 1) AND PLACE FIRST TOP PLATE
5. REPEAT THE PROCESS FOR PLACING THE OTHER TOP PLATE - PLACE A 1" WIDE BEAD ACROSS THE LAP JOINT ON THE FIRST PLATE
6. WIPE OFF ANY EXCESS ADEHSIVE THAT SQUEEZES OUT - USE A SPATULA TO CREATE AN ADEHSIVE FILLET AT ALL INSIDE CORNERS AT EACH END
7. BOND THE FRP BLISTERS AT 3 LOCATIONS AS SHOWN ENSURING THE HOLE IN THE BLISTER IS CENTERED ON THE HOLE IN THE HULL (NOMINAL 1/8" BOND LINE)
8. APPLY LABEL TO UPSTATION END OF PONTOON AND MOVE TO STAGING AREA FOR RAFT ASSEMBLY AND DRILLING

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 TOP PLATE AND BLISTER IS 1/8"  
 ENSURE THRU HOLES IN BLISTER AND HULL REMAIN CLEAR OF ADHESIVE

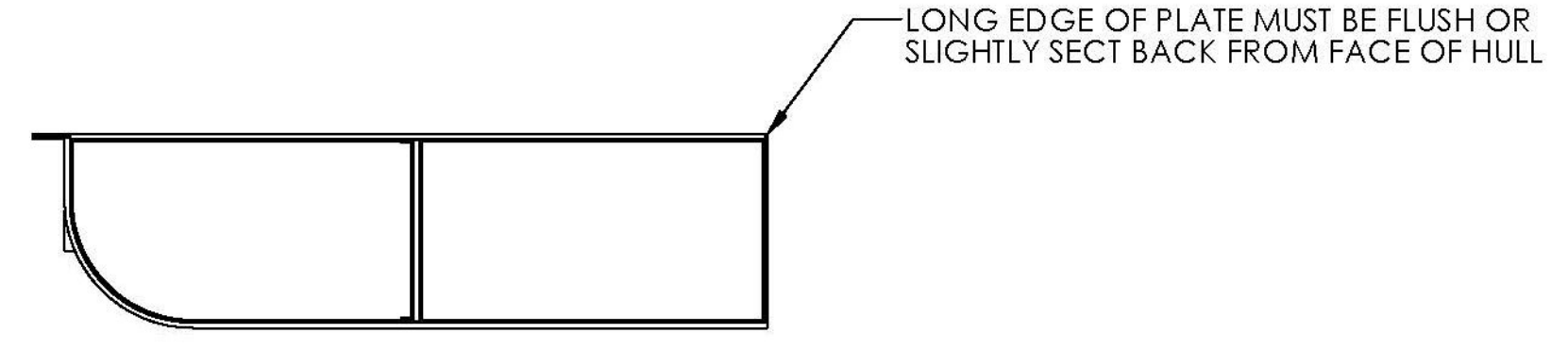


Vermont Agency of Transportation  
**RECEIVED**  
 ON: **June 30, 2014**  
 and Checked for  
**CONFORMANCE**  
 BY: Jennifer Fitch DATE: 07/07/2014

DATE	6/26/14
DESCRIPTION	CLARIFIED MMA BEAD SIZE FOR 3" AND 6" FLANGES
REV	1
DRAWN BY	JM
DATE	6/4/14
CHKD BY	XX
DATE	X/X/XX
PROJECT	BROOKFIELD FRP PONTOONS
CUSTOMER	MILLER CONST. / VTRANS
SHEET	PONTOON ASSEMBLY - STEP 4
WEIGHT:	12,735 lb
DESCRIPTION:	ASSEMBLY
SCALE	1 : 36
WO NO.	8420
CONTRACT NO.	9185
DWG NO.	8420-8
SHEET	4 OF 5
PONTOON	N/A
PART NO.	N/A



ENSURE PLATE IS FLUSH WITH HULL



LONG EDGE OF PLATE MUST BE FLUSH OR SLIGHTLY SECT BACK FROM FACE OF HULL

**T.Y. LIN INTERNATIONAL**  
 THE STAMPED DOCUMENTS ARE HEREBY:  
 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 07/03/2014  
 REVIEWER DATE