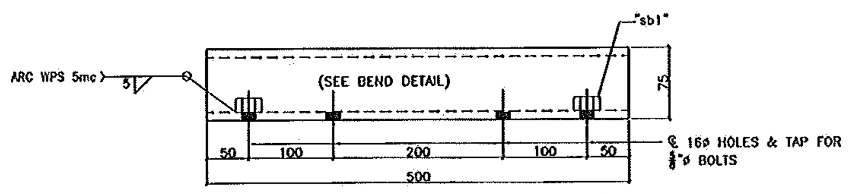
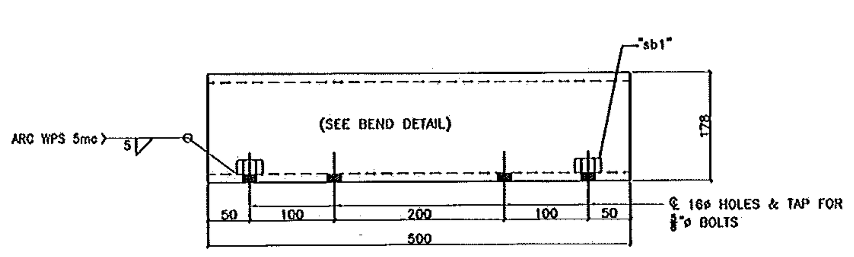
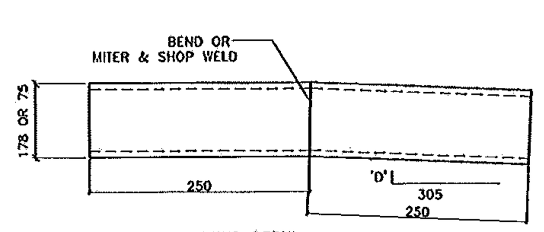


(4) REQ'D SPLICE TS75X75X8 MARK, "A1SP1"
(4) REQ'D SPLICE TS75X75X8 MARK, "A2SP1"
(4) REQ'D SPLICE TS75X75X8 MARK, "A3SP1"



(4) REQ'D SPLICE TS178X75X10 MARK, "AMSP1"

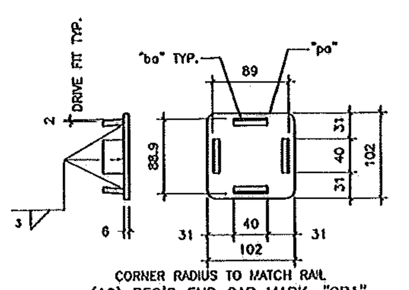


BEND DETAIL

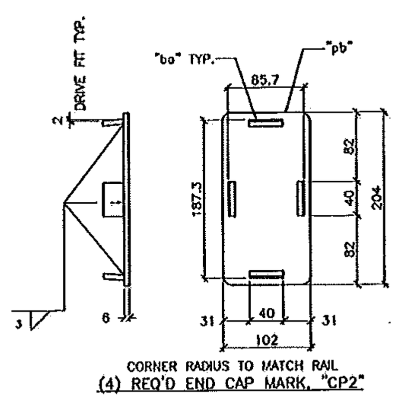
MARK	'D'
"A1SP1"	24
"A2SP1"	18
"AMSP1"	13
"A3SP1"	7

(4) EACH

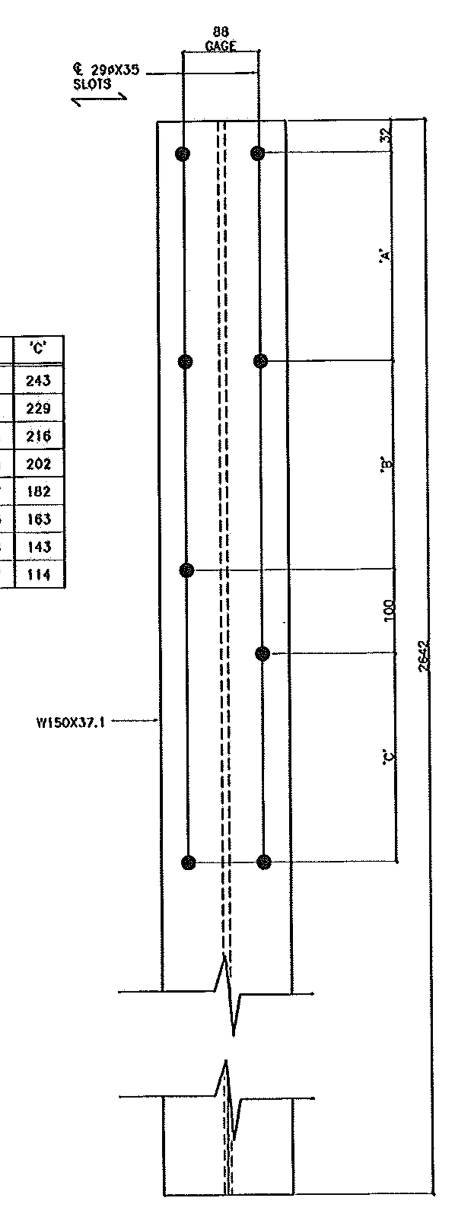
MARK	'A'	'B'	'C'
"AP1"	267	271	243
"AP2"	254	261	229
"AP3"	240	251	216
"AP4"	227	241	202
"AP5"	207	227	182
"AP6"	187	213	163
"AP7"	168	198	143
"AP8"	139	177	114



CORNER RADIUS TO MATCH RAIL
(12) REQ'D END CAP MARK, "CP1"



CORNER RADIUS TO MATCH RAIL
(4) REQ'D END CAP MARK, "CP2"



RECEIVED
CK'D BY HJS OK'D BY RSY
FEB 25 2011
RESUBMIT ____ APPROVED ✓
BY CPW DATE 3/23/11

BILL OF MATERIAL

SHIP	SHIP MARK	NO. PCS.	PIECE MARK	DESCRIPTION	LENGTH MM	REMARKS	MAT'L
AP1	THRU AP8	32		POST			
		32		W 150 X 37.1	2642	ASTM A709/A709M	Gr 345
	RB1	256		19Ø X 152 M164 ROUND	HEAD BOLT	HDG W/ FW F436	HDG
	CP1	12		END CAP			
		12	pa	℄ 6X102	102		
		48	ba	BAR 6 X 25	40		
	CP2	4		END CAP			
		4	pb	℄ 6X102	204		
		16	ba	BAR 6 X 25	40		
A1SP1	THRU A3SP1	12		SPLICE BAR			
		12		TS75X75X8	500		
		24	sb1	⅝"Ø LOCK NUT A194 HDG			
	AMSP1	4		SPLICE BAR			
		4		TS178X75X10	500		
		8	sb1	⅝"Ø LOCK NUT A194 HDG			

SHOP NOTE:

1. ALL EXPOSED CUT OR SHEARED EDGES SHALL BE ROUNDED & FREE OF BURRS. THE INSIDE WELD FLASH OF TUBING SHALL BE REMOVED AT SPLICE/EXP JOINTS.
2. TWENTY FIVE PERCENT OF THE POST-TO BASE WELDS IN A PRODUCTION LOT SHALL BE TESTED BY MT. IF REJECTABLE DISCONTINUITIES ARE FOUND, ANOTHER TWENTY FIVE PERCENT OF THE PRODUCTION LOT SHALL BE TESTED. IF REJECTABLE DISCONTINUITIES ARE FOUND IN THE SECOND TWENTY FIVE PERCENT, ALL POST TO BASE WELDS SHALL BE TESTED, ALL TESTING OF BASE TO POST WELDS SHALL CONFORM TO THE LATEST VERSION OF AWS D1.5.
3. CLEAN ALL THREADS AFTER GALVANIZING.
4. VERIFY THE FIT OF SPLICE BARS IN RAIL TUBES AFTER GALVANIZING AND BEFORE SHIPPING TO SITE.
5. HOLES IN RAIL BARS SHALL BE FIELD-DRILLED AND COATED WITH AN APPROVED ZINC-RICH PAINT PRIOR TO ERECTION.

ERECTION BOLTS W/NUT				WASHERS		FINISH
QUAN.	SIZE	LENGTH	TYPE	FLAT	BEV.	

FINISH: GALV. PER ASTM A123, HARDWARE ASTM A153
MATERIAL: [illegible]
HOLES: AS NOTED
ELECTRODES:
WELDS: PER WPS
SURFACE PREP: SSPC-SP6

NO	DATE	DESCRIPTION	BY
1	2/24/11	PER APPROVAL	JJC

REVISIONS

ARC ENTERPRISES, INC.

ADVANCED RESOURCES & CONST. ENTERPRISES, INCORPORATED
P.O. BOX 120 KNOXFIELD, ME. 04917
PHONE: (207) 265-2646 – FAX: (207) 265-4054

DRAFTER JJC
DATE 1/2/11
CHECKED MTD
JOB 10-163

APPROACH POST & SPLICE DETAILS
VERMONT D.O.T., STOCKBRIDGE
107 BRIDGE OVER STONY BROOK
AUSTIN CONSTRUCTION, INC.

PROJECT NO. BRF 022-1(20)
DWG. NO. 6 OF 7