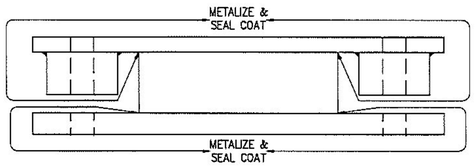
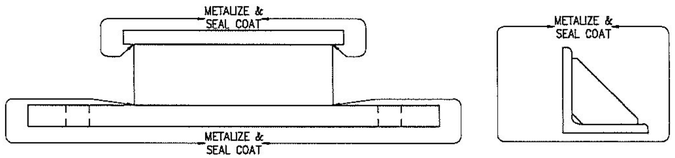
EPOXY BONDING PROCEDURE:

1. BLAST CLEAN MATING SURFACE OF STEEL PLATE PER SSPC-SP10.
2. ROUGHEN MATING SURFACE OF ELASTOMERIC PAD WITH SANDING DISC.
3. SOLVENT CLEAN MATING SURFACES PER SSPC-SP1.
4. APPLY 3 COATS OF 7701 PRIMER TO MATING SURFACES, ALLOWING TO DRY BEFORE APPLYING SUBSEQUENT COATS.
5. MIX 310A & B AS PER MANUFACTURER'S INSTRUCTIONS.
6. APPLY 310 ADHESIVE TO MATING SURFACES AND ASSEMBLE PIECES.
7. CURE UNDER PRESSURE. FULL STRENGTH ATTAINED IN 24 HOURS.



FIXED BEARING COATING LIMITS



EXPANSION BEARING COATING LIMITS

Vermont Agency of Transportation
RECEIVED
May 15, 2013
CK'D BY J.E.L. OK'D BY J.E.L.
RESUBMIT Approved
BY J.E.L. DATE 03.18.2013

GENERAL NOTES:

1. PAD AND MATERIALS SHALL CONFORM TO STATE OF VERMONT, AGENCY OF TRANSPORTATION STANDARD SPECIFICATIONS FOR CONSTRUCTION, DATED 2011 AND ITS LATEST REVISIONS, AND THE AASHTO LRFD BRIDGE DESIGN SPECIFICATIONS, FIFTH EDITION AND ITS LATEST REVISIONS, THE CONTRACT PLANS, AND THE SPECIAL PROVISIONS. GENERAL SHOP PRACTICES, STRUCTURAL FABRICATION, WELDING AND ASSEMBLY SHALL BE GOVERNED BY ANSI/AASHTO/AWS D1.5 BRIDGE WELDING CODE.

2. THESE SHOP DRAWINGS ARE PREPARED IN ACCORDANCE WITH THE CONTRACT PLANS AND SPECIFICATIONS. THE D.S. BROWN COMPANY DOES NOT ACCEPT LIABILITY FOR THE DESIGN OF THE PRODUCTS DETAILED IN THESE SHOP DRAWINGS.

3. THE D.S. BROWN COMPANY TO SUPPLY ONLY THE PARTS SHOWN ON THESE DRAWINGS.

4. ALL STEEL SHALL BE PRODUCED IN THE UNITED STATES OF AMERICA.

5. THE BEARING SHALL BE SUBJECT TO RANDOM IN-HOUSE ELASTOMER TESTING AND IN-HOUSE PROOF LOAD TESTING IN ACCORDANCE WITH AASHTO DIVISION I, SECTION 14 (METHOD "A") AND AASHTO DIVISION II, SECTION 18.

6. THE TEMPERATURE OF THE STEEL ADJACENT TO THE ELASTOMER SHALL NOT EXCEED 93°C (200°F). TEMPERATURE SHALL BE CONTROLLED BY THE USE OF A TEMPERATURE INDICATING CRAYON OR OTHER DEVICES APPROVED BY THE ENGINEERS.

7. ALL CORNERS AND EDGES OF STEEL PLATES SHALL BE GROUND TO A 0.063" RADIUS.

8. ALL STRUCTURAL STEEL SURFACES TO BE METALIZED SHALL BE CLEANED IN ACCORDANCE WITH SSPC-SP5.

9. ALL SPECIFIED STEEL TO BE ZINC METALIZED IN ACCORDANCE WITH AWS C 2.18 SPECIFICATIONS TO A MINIMUMM THICKNESS OF 6 MILS. THE COATING SHALL CONSIST OF 99.9% PURE ZINC (MINIMUM PURITY). THE METALIZATION SHALL OCCUR AFTER THE VULCANIZATION PROCESS. THE FIRST COATING SHALL BE APPLIED WITHIN ONE HOUR OF BLAST CLEANING AND THE SURFACE MUST BE COMPLETELY COATED TO THE SPECIFIC THICKNESS WITHIN TWO HOURS OF BLASTING. EXTERIOR SURFACES SHALL BE SEALED WITH CARBOLINE SEALER "RUSTABOND" WITH A MINIMUM DRY FILM THICKNESS 2 MILS. SEE COATING LIMITS FOR LOCATIONS. REPAIR DAMAGED METALIZATION PER ASTM A780.

10. TESTING SHALL BE IN ACCORDANCE WITH SPECIAL PROVISION TABLE 731.03A-REQUIRED TESTS.

⚠ 11. FIXED ELASTOMERIC BEARING MASONRY PLATES SHALL BE EPOXY BONDED TO THE ELASTOMER BEARING USING LORD 310 ADHESIVE. SURFACE PRIMER SHALL BE CHEMLOK 7701. SEE EPOXY BONDING PROCEDURE THIS SHEET.

MARKING NOTES:

1. EACH BEARING SHALL BE MARKED IN INDELIBLE INK OR FLEXILE PAINT. THE MARKING SHALL CONSIST OF THE ORDER NUMBER, LOT NUMBER, BEARING IDENTIFICATION NUMBER, LOCATION, UP STATION ARROW, AND ELASTOMER TYPE AND GRADE. THE MARKING SHALL BE ON A FACE THAT IS VISIBLE AFTER ERECTION OF THE BRIDGE.

TOLERANCE TABLE	
DESCRIPTION (ELASTOMER)	TOLERANCE
ELASTOMERIC BEARING DESIGN THICKNESS > 1.250"	+ 1/4", -0
ELASTOMERIC BEARING PLAN ≤ 36"	+ 1/4", -0
ELASTOMERIC COVER TOP & BOTTOM	+ 1/8", -0
ELASTOMERIC COVER SIDES	+ 1/8", -0
THICKNESS OF INDIVIDUAL LAYERS OF ELASTOMER (LAMINATED) BEARINGS	
ONLY) AT ANY POINT WITHIN THE BEARING	± 1/8"
VARIATION FROM A PLANE PARALLEL TO THE THEORETICAL SURFACE	
(AS DETERMINED BY MEASUREMENTS AT THE EDGE OF THE BEARINGS)	
TOP	0.005 RAD
SIDES	± 1/4"
POSITION OF EXPOSED CONNECTION MEMBERS	± 1/8"
EDGE COVER OF EMBEDDED LAMINATES OF CONNECTION MEMBERS	+ 1/8", -0
SIZE OF HOLES, SLOTS, OR INSERTS	± 1/8"
POSITION OF HOLES, SLOTS, OR INSERTS	± 1/8"
MASONRY PL. PLAN DIMENSIONS	±1/4"
MASONRY PL. UNDERSIDE SURFACE FLATNESS	CLASS C
MASONRY PL. UPPERSIDE SURFACE FLATNESS	CLASS A
MASONRY PL. THICKNESS	±1/16"
HOLE LOCATION	±1/16"
SOLE PL. PLAN DIMENSIONS	±1/4"
SOLE PL. UNDERSIDE SURFACE FLATNESS	CLASS A
SOLE PL. UPPERSIDE SURFACE FLATNESS	CLASS C
SOLE PL. BEVEL SLOPE	± 0.002 RAD
SOLE PL THICKNESS	±1/16"
MASONRY & SOLE PLATE SURFACE FINISH (BEARING SIDE)	125 RMS

FLATNESS TOLERANCE	
CLASS	X NOM. DIM.
A	0.001
B	0.002
C	0.005

REV.	DESCRIPTION	DATE	DET.	CKD.
⚠	ADDED EPOXY BOND PROCEDURE NOTES.	02/18/13	KTG	–

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LOCATION — TH 7 (BRIDGE ST.), 0.10 MI WEST OF RTE. 14
BRIDGE — 11
PROJECT — BRF 6100(7)
PROJECT NAME — BARRE TOWN
—
DESIGNER — VTDOT
CUSTOMER — MILLER CONSTRUCTION

ITEM	QUANTITY
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DESCRIPTION: GENERAL NOTES & COATING LIMITS
WASHINGTON CO., VT

SCALE:	DRAWN BY:	DESIGNED BY:	DATE:	
N.T.S.	AND	KTG	12/4/12	–

PROJECT NUMBER	PROJECT CODE	RELEASE	SHEET
38782	1104	1	GN1