


GENERAL NOTES:

- 1) ALL MATERIAL AND WORKMANSHIP SHALL BE IN ACCORDANCE WITH THE VERMONT AGENCY OF TRANSPORTATION "STANDARD SPECIFICATIONS FOR CONSTRUCTION", 1990 EDITION, THE SUPPLEMENTAL SPECIFICATIONS AND THE SPECIAL PROVISIONS.
- 2) ALL STEEL SHALL CONFORM TO AASHTO M270 GRADE 50 (ASTM A709 GRADE 50) U.N.O.
- 3) MATERIAL FOR ANCHOR RODS AND PLATE WASHERS SHALL CONFORM TO AASHTO M183 (ASTM A36). NUTS FOR ANCHOR RODS SHALL BE HEAVY HEX A563A. GALVANIZE ANCHOR RODS, PLATE WASHERS AND NUTS PER AASHTO M232 (ASTM A153).
- 4) BEARING PADS SHALL MEET THE REQUIREMENTS OF STANDARD SPECIFICATION 731.01.
- 5) WELDING SHALL BE IN ACCORDANCE WITH AWS D1.5 AND SECTION 506.10 OF THE STANDARD SPECIFICATIONS AND SPECIAL PROVISIONS. REPAIR TORCH GOUGES PER REPAIR PROCEDURE F-REP-04 (1G-2G-3G).
- 6) TOLERANCES: AFTER FABRICATION AND APPLICATION OF OF SURFACE PROTECTION BEARING DEVICES OR COMPONENTS SHALL BE WITHIN THE FOLLOWING TOLERANCES:
  - a) DIMENSIONS (LENGTH, WIDTH, THICKNESS), HOLE LOCATIONS AND POSITION OF WELDED COMPONENTS, +/- 1/16".
  - b) SOLE PLATE: BEARING SURFACES SHALL BE FLAT WITH MAXIMUM PERMISSIBLE VARIATION OF 0.01 INCHES FROM A PLANE DETERMINED BY ANY THREE CORNERS OF THE PLATE.
  - c) MASONRY PLATE: BEARING SURFACES SHALL BE FLAT WITH A MAXIMUM PERMISSIBLE VARIATION OF 0.04 INCHES FROM A PLANE DETERMINED BY ANY THREE CORNERS OF THE PLATE.
  - d) CURVED SURFACES: THE CONTACT LENGTH ALONG THE AXIS OF ROTATION TIMES 0.0001.
- 7) METALIZING AND COATING:
  - a) ALL CORNERS AND EDGES OF STEEL PLATES SHALL BE CHAMFERED 1/16".
  - b) SURFACES TO BE METALIZED SHALL BE PREPARED AND COATED IN ACCORDANCE WITH AWS ~~C2.2~~<sup>C2.16</sup>. THE COATING SHALL BE PURE ZINC (99.9% PURITY MINIMUM). A MINIMUM OF 6 MILS SHALL BE APPLIED TO ALL SURFACES EXCEPT CURVED CONTACT SURFACES (THOSE WITH A 125 SURFACE FINISH). ALL SURFACES SHALL THEN BE SEALED WITH A SPAR URETHANE CONFORMING WITH THE RECOMMENDATIONS OF THE THERMAL SPRAY SUPPLIER. THE MINIMUM D.F.T. OF THE SEALANT SHALL BE 2 MILS.
  - c) ALL SURFACES TO BE METALIZED SHALL BE BLAST CLEANED TO WHITE METAL (~~ASTM D2200 GRADE SA-3~~<sup>(SSPC SP10)</sup>). THE FIRST COATING SHALL BE APPLIED WITHIN ONE HOUR OF BLAST CLEANING AND THE SURFACE MUST BE COMPLETELY COATED TO THE SPECIFIED THICKNESS WITHIN TWO HOURS OF BLASTING.
  - d) ADHERENCE OF THE METALIZED COATING TO THE BASE METAL SHALL BE TESTED IN ACCORDANCE WITH AASHTO M111, SECTION 9 "FINISH AND ADHERENCE OF COATING".

APPROVER PLEASE VERIFY: CURVED CONTACT SURFACES WHICH DO NOT RECEIVE METALIZING WILL STILL RECEIVE THE SPAR URETHANE SEAL COAT?

No. ONLY METALIZED SURFACES RECEIVE SPAL COAT.

RECEIVED  
 CWO BY WAS ORDER BY RAY  
 MAR 12 2001  
 REQUEST APPROVED As N/m  
 BY CPW DATE 3/29/01

REV.	DESCRIPTION	DATE	INT.
	ANY AND ALL BACKCHARGES WILL BE REJECTED UNLESS WRITTEN CONSENT IS GIVEN BY LEWIS ENGINEERING COMPANY PRIOR TO ANY WORK PERFORMED FOR OUR ACCOUNT. SUCH REJECTION MEANS THAT INVOICES WILL NOT BE HONORED OR DEDUCTIONS FROM PAYMENT WILL BE CHARGED BACK.		
 <b>LEWIS ENGINEERING COMPANY</b> 4201 NORE. DRIVE - CHASKA, MINNESOTA 55318 - (612) 368-3000			
SHOP	PROJECT	ROYALTON/ RTE. NO. TH 1, CL 1 BRIDGE NO. 3	
	STATE PROJECT	AC BRZ 1444(22)	
	FEDERAL PROJECT	-	
APPROVAL	CUSTOMER	ECK & BELLUCCI, INC.	
	LOCATION	WINDSOR COUNTY, VT	
	DESCRIPTION	PIER FIXED BEARING GENERAL NOTES	
CUST.	FOR	DATE	
	PRINTS ISSUED		
		SHEET NO. GN1 OF 1	Job. No. : 2034.1121.1

ORIG  
 W.P. ch'k'd N/R  
 Drawn By TSF  
 Ch'k'd. By NY  
 Date: 2/01