GENERAL NOTES:

1. MATERIAL AND WORKMANSHIP SHALL BE IN ACCORDANCE WITH THE VERMONT AGENCY OF TRANSPORTATION "STANDARD SPECIFICATIONS FOR CONSTRUCTION, 2001 EDITION" SECTIONS 531 AND 731, SPECIAL PROVISIONS, SUPPLEMENTAL SPECIFICATIONS AND THE CONTRACT PLANS. GENERAL SHOP PRACTICES, STRUCTURAL FABRICATION, WELDING AND ASSEMBLY SHALL BE GOVERNED BY ANSI/AASHTO/AWS D1.5 BRIDGE WELDING CODE.

2. THESE SHOP DRAWINGS WERE 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 THIS DRAWING.

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

5. PTFE (TEFLON) SHALL BE VIRGIN, UNFILLED POLYTETRAFLUOROETHYLENE SATISFYING THE REQUIREMENTS OF ASTM D4894.

6. PTFE IS TO BE PURCHASED ETCHED ON ONE SIDE FOR BONDING. THE BONDING PROCESS FOR LAMINATING PTFE TO THE FABRIC PAD IS AS FOLLOWS: THE FABRIC PAD SURFACE TO BE BONDED IS PREPARED FOR LAMINATION. A TWO-PART STRUCTURAL GRADE EPOXY IS THEN APPLIED PER THE MANUFACTURE'S INSTRUCTIONS. THE PTFE IS CUT SLIGHTLY OVERSIZE TO ACCOUNT FOR POSSIBLE DRIFT.

THE PTFE IS THEN APPLIED TO THE FABRIC PAD AND PUT INTO A VACUUM PRESS AT THE APPROPRIATE PRESSURE FOR THE NECESSARY TIME PERIOD. ONCE THE FABRIC PAD AND PTFE IS REMOVED FROM THE PRESS, THE PTFE IS TRIMMED TO PLAN SIZE AND THE PADS ARE SUBMITTED FOR QUALITY CONTROL REVIEW.

7. STAINLESS STEEL SHALL CONFORM TO ASTM A240 – TYPE 304 AND SHALL BE 14 GA. (0.078"). STAINLESS STEEL SLIDING SURFACES IN CONTACT WITH PTFE SHALL HAVE A NO. 8 MIRROR FINISH AND ALL OTHERS SHALL HAVE A 2B FINISH.

8. WELDING SHALL CONFORM TO AWS D1.5 BRIDGE WELDING CODE AS WELL AS ANY STATE STANDARD OR PROJECT SPECIAL PROVISION.

9. PRIOR TO INSTALLATION – THE PIN SHAFT, PIN THREADS, STEEL PLATE BORE, STEEL PLATE CRADLE AND MACHINED NUT SHALL BE LUBRICATED.

10. UNLESS SPECIFIED OTHERWISE, THE DIMENSIONAL TOLERANCES AND SURFACES FINISHES OF THE BEARING SHALL SATISFY THE REQUIREMENTS OF AASHTO STANDARD SPECIFICATIONS, DIVISION II, TABLE 18.5.1.5-1.

11. PINS SHALL CONFORM TO AASHTO STANDARD SPECIFICATION, DIVISION II, ARTICLE 11.4.9.1. BORING PIN HOLES SHALL CONFORM TO AASHTO STANDARD SPECIFICATION, DIVISION II, ARTICLE 11.4.9.2. THREADS FOR PINS SHALL CONFORM TO AASHTO STANDARD SPECIFICATION, DIVISION II, ARTICLE 11.4.9.3.

12. RADIUS ALL STEEL PLATE EDGES 1/16".

△ 13. SEAL WELD ALL CONNECTIONS WHEN POSSIBLE.

TOLERANCE TABLE	
DESCRIPTION	TOLERANCE
SOLE PL. PLAN DIMENSIONS	+0.063", -0.063"
SOLE PL. THICKNESS	+0.063", -0.063"
HOLE LOCATION	+0.063", -0.063"
STEEL STIFFENER PLATE PLAN DIMENSIONS	+0.063", -0.063"
STEEL STIFFENER PLATES WELDED LOCATIONS	+0.063", -0.063"
STEEL STIFFENER PLATE THICKNESS	+0.063", -0.063"

BEARING SURFACES SHALL BE FLAT WITH A MAXIMUM PERMISSIBLE VARIATION OF 0.01" FROM A PLANE DETERMINED BY ANY THREE CORNERS OF THE PLATE.

FOR STAINLESS STEEL MATING TO PTFE BONDED TO FABRIC BEARING PAD MATERIAL THE TOLERANCE SHALL BE 0.01" FROM A PLANE DETERMINED BY ANY THREE CORNERS OF THE PLATE.

PROTECTIVE COATING NOTES:

△ 1. PRIOR TO METALIZING, SURFACES SHALL BE ABRASIVE BLAST CLEANED TO A NEAR WHITE FINISH (SSPC-SP10) USING BLASTING MEDIA AND MESH / SIZE RANGE AS RECOMMENDED IN ANSI/AWS C2.18-93, SECTION 5.2 AND TABLE 6.

2. APPLICABLE SURFACES SHALL BE ZINC METALIZED IN ACCORDANCE WITH ANSI/AWS C2.18-93 TO A MINIMUM DFT OF 6 MILS. THE COATING SHALL BE PURE ZINC (99.9% PURITY MIN.). THE FIRST COATING SHALL BE APPLIED WITHIN ONE HOUR OF BLASTING AND THE SURFACE MUST BE COMPLETELY COATED WITHIN TWO HOURS OF BLASTING.

△ 3. SURFACES TO BE PAINTED SHALL BE COATED WITH A WASSER HIGH TECH COATINGS, TWO-COAT SYSTEM:

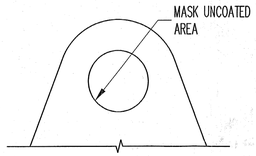
SEAL COAT: MC-FERROX B URETHANE, DFT 3.0-6.0 mils
TOP COAT: MC-FERROX A ALIPHATIC URETHANE, DFT 3.0-10.0 mils
APPROVED DFT PER VAOT QPL 2004
AFTER METALIZATION DS BROWN SHALL APPLY THE ABOVE SYSTEM.

(NOTE: WASSER PROTECTIVE COATINGS RECOMMENDATIONS;
SEAL COAT: MC-FERROX B URETHANE, DFT 3.0-5.0 mils
TOP COAT: MC-FERROX A ALIPHATIC URETHANE, DFT 2.0-4.0 mils)

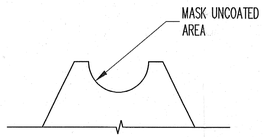
THE SEAL COAT SHALL BE APPLIED WITHIN 8 HOURS OF METALIZING. THE TOP COAT SHALL BE APPLIED AFTER THE SEAL COAT HAS CURED. BOTH COATS SHALL BE APPLIED IN ACCORDANCE WITH THE MANUFACTURERS RECOMMENDATIONS. COLOR FOR THE TOP COAT SHALL BE FEDERAL STANDARD 595, #27038 (BLACK).

4. ALL SURFACES DAMAGED BY FIELD WELDING OR HANDLING SHALL BE REPAIRED IN CONFORMANCE WITH SUPPLEMENTAL SPECIFICATION VAOT 513 (ASTM A760).

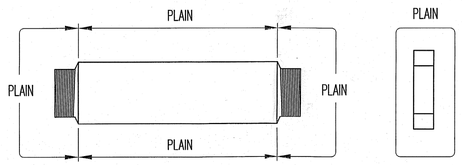
5. SUBSEQUENT PROTECTIVE COATING SHALL BE THE RESPONSIBILITY OF THE CONTRACTOR.



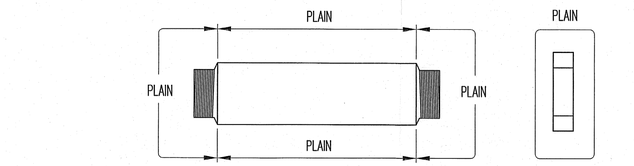
VIEW 'A-A'



VIEW 'B-B'



COATING LIMITS EXPANSION BEARING



COATING LIMITS FIXED BEARING

RECEIVED
CK'D BY MF CK'D BY CMC
MAR 15 2006
RESUBMIT APPROVED
BY DATE 3/14/06

REV.	DESCRIPTION	DATE	DET.	CKD.
△	REVISE GENERAL NOTES, PROTECTIVE COATINGS, BRG STIFFENERS, TITLE BLOCK	3/3/06	SP	PMG

RECEIVED
MAR 8 2006

CCS CONSTRUCTORS LLC
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	ITEM	QUANTITY
LOCATION — RAILROAD ST (TH 2) OVER LAMOILLE RIVER	–	–
BRIDGE — 6	–	–
△ PROJECT — AC BHO 1448(18) PROJECT NAME: JOHNSON	–	–
F.A.P. NO. — –	–	–
P.O. NO. — 996	–	–
DESIGNER — VAOT	–	–
CUSTOMER — CONTRACTORS CRANE SERVICE	–	–
	–	–

DESCRIPTION: GENERAL NOTES AND COATING LIMITS LAMOILLE CO., VT

SCALE:	DRAWN BY:	CHECKED BY:	DATE:	
N.T.S.	SP	PMG	1/06	–
PROJECT NUMBER	PRODUCT CODE	RELEASE	SHEET	
16225	1121	1	GN1	