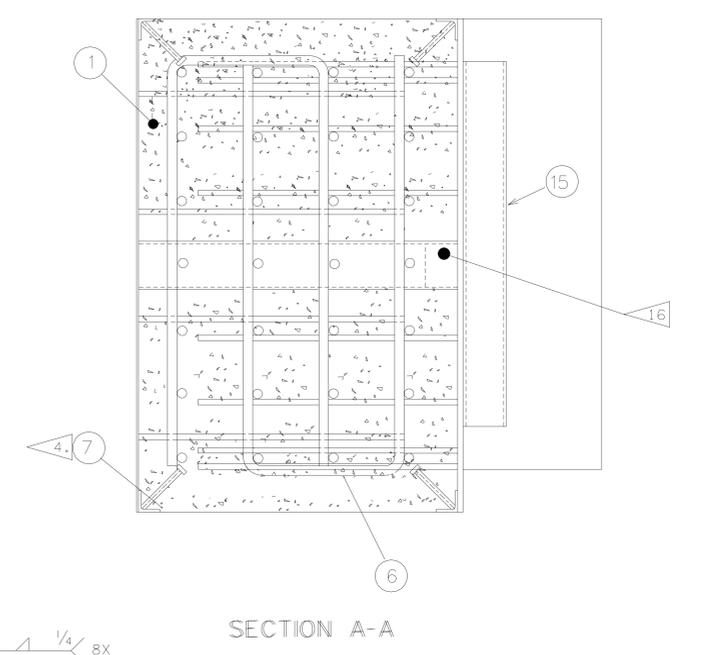
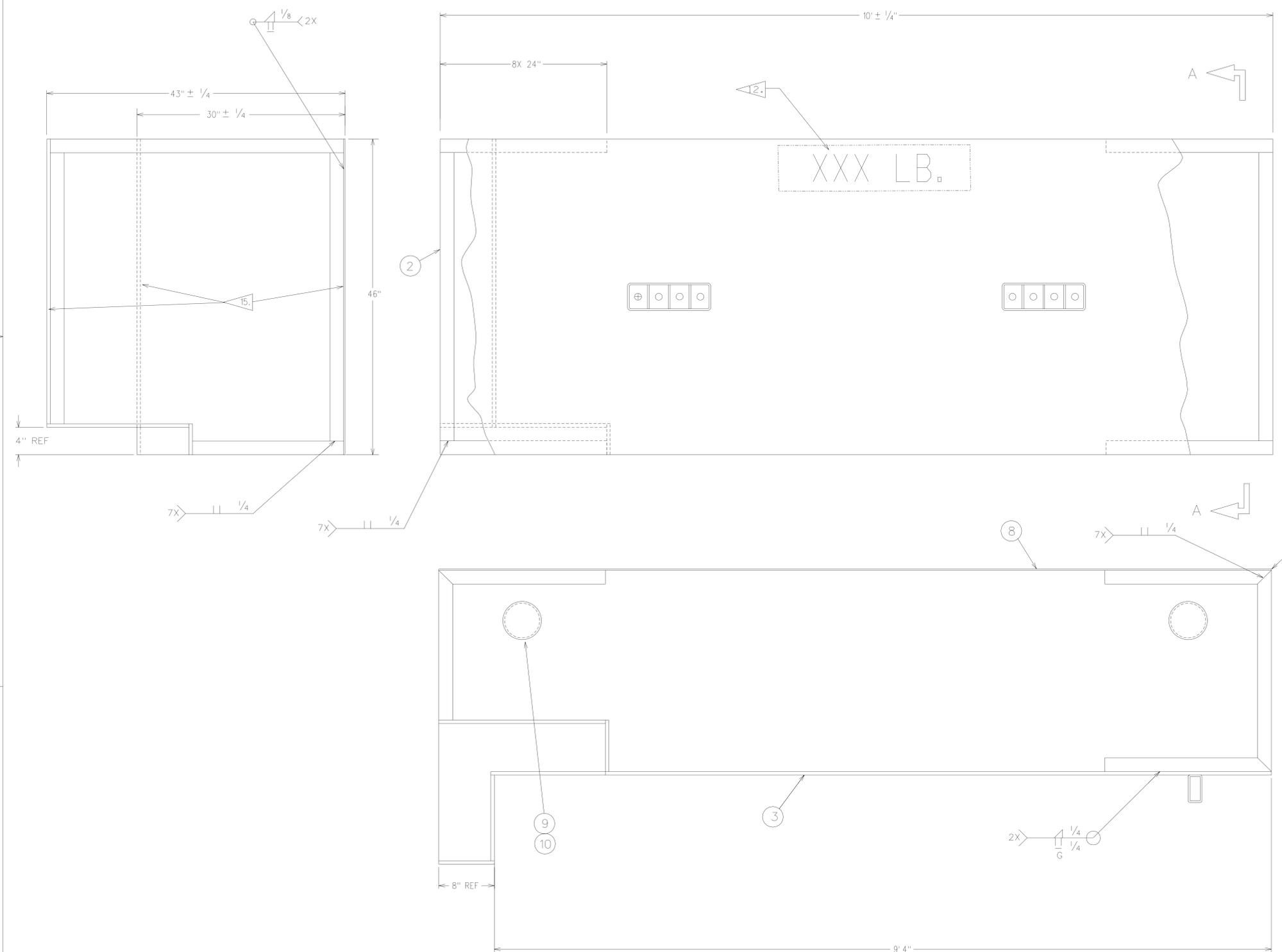


14. WIRE TIE ALL REBAR LAYERS AND WIRE TIE DEFORMED BAR RODS TO REBAR LAYERS.
15. FRONT AND REAR STEEL PLATES (ITEMS 3 AND 8) SHALL BE FLAT AND PARALLEL WITHIN  $\pm 1/4$ " FROM THEORETICAL PLANE.
16. AFTER ALL WELDING AND PAINTING IS COMPLETED, FILL VOIDS BETWEEN PLATES (ITEM 13) WITH POLYURATHANE FOAM (ITEM 14). FOAM IS:  
 "GREAT STUFF" MINIMAL EXPANDING  
 DOW CHEMICAL CO.  
 188 WEST OAK PARKWAY  
 MARIETTA, GA 30062  
 MAY BE PURCHASED AT HOME DEPOT
17. LIGHTLY SANDBLAST ALL EXPOSED STEEL SURFACES BEFORE CLEANING PER TT-C-490D. PRIME STEEL SURFACES PER MIL-PRF-23377, PRIMER COATINGS, EPOXY, HIGH-SOLIDS. TOPCOAT OF EPOXY PAINT PER MIL-PRF-22750F, COATING, EPOXY, HIGH-SOLIDS, COLOR: GRAY LUSTERLESS (36495) PER FED-STD-595. PAINTING ITEMS 9, 10, 12 AND 13 AFTER WELDING, BUT PRIOR TO FINAL BLOCK ASSEMBLY IS OPTIONAL.

8. DIMENSIONAL TOLERANCES SHALL BE AS FOLLOWS: UNLESS OTHERWISE NOTED.  
 A. LINEAR DIMENSIONS  $\pm 1/8$ ".  
 B. OUT OF SQUARE  $\pm 1/8$ ".  
 C. ALL SURFACES SHALL BE FLAT WITHIN  $\pm 1/8$ " FROM THEORETICAL PLANE.
9. PROVIDE AT LEAST  $1\frac{1}{2}$ " COVER BY CONCRETE OF REINFORCING STEEL.
10. MINIMUM CONCRETE REQUIREMENTS:  
 4000 PSI @ 28 DAYS, 4.5 - 6% ENTRAINED AIR, CURED CONCRETE SHALL NOT EXCEED 142 \* PER CUBIC FOOT (EXCLUSIVE OF STEEL REINFORCING). CUSTOMER MAY REQUEST TYPE III, HIGH EARLY STRENGTH CEMENT.
11. THE BASE OF ITEM 5 MAY BE BENT SLIGHTLY TO ALLOW PROPER PLACEMENT OF ITEM 9.
12. APPROX. LOCATION OF PAINTED 4" HIGH NUMBER : PAINT BLACK. PAINT FINISHED WEIGHT OF BLOCK ROUNDED TO THE NEAREST 100 POUNDS.
13. ALL PRE-CAST SURFACES SHALL BE TREATED WITH AN ACRYLIC SEALER AFTER COMPLETE CURING.

- NOTES:
- STEEL EDGES AND SURFACES TO BE GROUND OR PLACED FLUSH TO  $1/16$  INCH BELOW SURROUNDING CONCRETE SURFACES.
  - DO NOT CHAMFER CONCRETE EDGES, LEAVE SHARP.
  - MANUFACTURED BY NELSON STUD WELDING DIV., TRW INC. 7900 WEST RIDGE, P.O. BOX 4019, ELYRIA, OH 44036.
  - TWO ANCHORS (ITEM 7) PER ANGLE, LOCATED EQUALLY SPACED WITHIN RUN.
  - TACK WELD 80 RANDOM INTERSECTIONS OF ITEMS 4, 5, AND 6.
  - WELD DEFORMED BAR ANCHORS (ITEM 6) TO PLATES (ITEMS 3 AND 8); PER MANUFACTURERS INSTRUCTIONS; WELD HEADED ANCHORS (ITEM 7) TO ANGLES (ITEM 2).
  - WELD AND INSPECT PER 9912119, CLASS II, USING E70XX ELECTRODES PER AWS A5.5-81 OR E70S-X ELECTRODES OR RODS PER AWS A5.18-79.

DESIGN AGENCY PART NUMBER	ISS SHEET ZONE	REVISIONS			
		PREPARED BY	DESCRIPTION	DATE	CHKR APVD
R68658-000	A	C. MATTHEWS, 2996/D. SWAHLAN, 5832			DS



NO	REGRD	PART/CONTROL NO	DESCRIPTION/MATERIAL	NOTE	SHEET ZONE	ITEM
1			TUBE, RECTANGULAR, STEEL 4" X 2" X 1/4" WALL			15
AR			POLYURATHANE FOAM SEALANT		16	14
6	ASTM A36		STEEL PLATE, 1/4 THK			13
2			TUBE, RECTANGULAR, STEEL 4" X 12" X 1/4" WALL			12
5			DEFORMED BAR ANCHOR 1/2 X 36-1/8			11
4	ASTM A36		STEEL PLATE, 1/4 THK			10
4	ASTM A572		PIPE, STEEL, STANDARD WEIGHT, 5" NOM. DIA.			9
1	ASTM A572		PLATE 3/16 INCH STEEL, GRADE 50			8
28	101-053-005		HEADED ANCHOR 1/2 X 5-5/16		4	7
83	101-064-796		DEFORMED BAR ANCHOR 1/2 X 24-1/8			6
41	ASTM A615		BAR, REINFORCING, #7 GRADE 60			5
14	ASTM A615		BAR, REINFORCING, #6 GRADE 60			4
AR	ASTM A572		PLATE 1/2 INCH STEEL, GRADE 50			3
AR	ASTM A36		ANGLE 2 X 2 X 1/4 STEEL			2
AR	9906006		CONCRETE 4000 PSI COMPRESSIVE STRENGTH @ 28 DAYS			1
NA	9912119		WELDING STEEL			

SHEET	1	2	3	4	5	6	TITLE
ISSUE	A	A	A	A			BLOCK, LOCKING, MINOT 1840 (U)
PART CLASSIFICATION	UNCLASSIFIED						
DRAWING CLASSIFICATION	UNCLASSIFIED						
SIZE	E						DRAWING NUMBER
							R68658
	CAGEC 14213			SCALE 1:6		SHEET 1 OF 4	
STATUS	SA-REL-05/14/02			ORIGIN		SA-MSJ	