

COMMENTS RECEIVED FROM INDUSTRY REVIEW

Jennifer Taylor

File: 6490000 -Steel Strain Poles,Steel Mast Arm and
Monotube Assemblies
Username: Jennifer Taylor
UserEmail: jennifer.taylor@dot.state.fl.us
UserTel: 386-740-3471
Date: Thursday, May 11, 2006
Time: 07:40:51 AM

Comments:

649-4.3 Painting: If we are telling them to paint in accordance with the contract documents- why are we getting paint samples after it was painted- We either need to get the paint chips prior to painting and approve or make the Contractor responsible for meeting the contract requirements - the way its currently worked I see problems with getting after the fact.

649-5 Installation: What about early break cylinders? If we require the full 7 days we need to look at this while setting contract time- a small job with only mast arms may run out of contract time Install bolt, nut and washer assemblies, except nuts on anchor rods, in accordance with Section 460. Install nuts on anchor rods in accordance with the following: use anchor bolt assemblies that are free of rust and corrosion, and lubricate these assemblies prior to installation so that the nut moves freely by hand through the full length of the thread. Bring the lower top anchor nuts on the anchor rods to a "snug tight" condition defined as: the tightness 6490000 that is attained with a few impacts of an impact wrench or the full effort of an ironworker using an ordinary spud wrench such that more than 75% of the faying surfaces are in firm contact. Before snugging the lower top anchor nuts, all bottom leveling nuts shall be leveled. After snugging the lower top anchor nuts, all bottom leveling nuts shall be tightened to the base plate by full effort of an ironworker using an ordinary spud wrench. Use a beveled washer if outer face of the base plate is sloped more than 1:40 or if necessary to attain "snug tight" condition. After attaining "snug tight" condition, additionally tighten the lower top anchor nuts on the anchor rods in accordance with Table A. Nut rotation is relative to anchor rod, tolerance is plus 20 degrees. Install the upper top anchor nuts on the anchor rods on top of the lower top anchor nuts using the tightness that is attained with a few impacts of an impact wrench or the full effort of an ironworker using an ordinary spud wrench. During the tightening of the upper top anchor nuts, the lower top anchor nuts shall be restrained from movement by using an ordinary spud wrench. previous table was more field friendly with turn references- this needs to be reworked to read so our folks can understand this.

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Username: Jennifer Taylor
UserEmail: jennifer.taylor@dot.state.fl.us
UserTel: 386-740-3471
Date: Wednesday, May 31, 2006
Time: 07:43:14 AM

Comments:

Section 649-3 Fabrication or 649-4 Coatings
Suggest add a section to describe what repair procedures for chipped or scratched paint should be or are acceptable without sending back to fabricator

Section 649-5 Installation
Suggest adding a statement "Erect Mast arms in an orientation so that proposed signal head assemblies will line up with proposed traffic lanes as shown in the plans." (or in accordance with whatever manual requires this)

Bob Dion

File: 6490000 -Steel Strain Poles,Steel Mast Arm and Monotube Assemblies
Username: Bob Dion
UserEmail: bob_dion@urscorp.com
UserTel: 386-740-0665
UserFAX: 386 740-1275
Date: Monday, May 15, 2006
Time: 04:14:34 PM

Comments:

Should 'zinc coating' in the 2nd paragraph of 649-4.2 be changed to 'galvanized coating'? Are you measuring the galvanized coating or only the zinc in it?

Pat McCann

File: 6490000 -Steel Strain Poles,Steel Mast Arm and Monotube Assemblies
Username: Pat McCann
UserEmail: cn406pm

UserTel: sc 436-4387 (954) 777-4387
UserFAX: (954) 777-4149
Date: Wednesday, May 24, 2006
Time: 01:02:18 PM

Comments:

A proposed spec. (7000243) was previously sent out for review. This spec. referenced 649.5 for installation. Question: does the author of 7000243 realize the changes proposed to 649-5 here?

Steven M Duke

Steve Duke/SM/FDOT
05/15/2006 09:30 AM

Re: Fw: Proposed Specification Revisions 6490000 Steel Strain Poles, Steel Mast Arm and Monotube Assemblies

Ghulam, all the fabricators for these products should be AISC certified in the appropriate category. They should also have a submitted quality control plan to this office and be on our approved fabricators list I think part of the problem with the coatings failure on the mast arms could have been avoided by a more thorough inspection process. By following these steps we should be able to alleviate future problems. Also most of the fabricators that are currently on the QPL list are AICS certified and on our list.

Regards

Steven M. Duke, CPM
Project Manager
Structural Steel & Timber
State Materials Office
Phone # 352-955-6682
Suncom # 625-6682
Fax # 352-955-6689
E-mail: steve.duke@dot.state.fl.us
The Pursuit of Quality Has No Finish Line

Late Comment from Industry Review
Sonny Sutton

File: 6490000 -Steel Strain Poles,Steel Mast Arm and Monotube Assemblies
Username: Sonny Sutton
UserEmail: ssutton@pbsj.com
UserTel: 386-755-1400
UserFAX: 386-755-1411
Date: Thursday, June 08, 2006

Time: 09:07:35 AM

Comments:

New/substitute verbiage seems to more accurately describe requirements and methods. Perhaps an additional column in Table A could include a minimum torque specified to serve as an "either/or" scenario with the "Nut Rotation from Snug Tight Condition" column.