

**4100000 –Precast Concrete Box Culvert  
Response To Comments From Industry Review**

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**Comments:**

Recommend consolidating the requirements for obtaining precast structures from plants listed on the Departments list of Producers with Accepted Quality control Programs into 1 place, it is repeated in sections 407, 410 , 430 and 449 currently in industry review.

The revision to section 449 includes the same verbiage, however it does not mention a notarized statement, if needed suggest adding it to 449-1. Also, suggest deleting the 3rd paragraph of 410-1.

**Response:** That is the purpose of this change. 407, 410, 430 and 449 will only make mention of the general requirement. The details have been moved to Section105.

Add "Precast Concrete Drainage Products ....Article 449-1' to 410-2.

**Response:** Change made.

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**Comments:**

Reword sentence in 410-4.1.2, second sentence: "Perform a bridge load rating in accordance with the Structures Design Guidelines for any multiple barrel culverts with a total span equal to or greater than 20 feet; culvert measurement shall be from the inside face of end supports along the centerline of the roadway crossing."

**Response:** This sentence is consistent with the last sentence in Section 410-4.1.3 and shall not be changed at this time.

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**Sam K. Joseph**  
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**Comment**

Revision date 10-15-07, Spec. #410-1, at the third paragraph, the last sentence should be modified to add “Quality Control” in front of the word “signed”.

**Response:** Change made.

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**Comments:**

Comment 1 - Re: 105-"8"5.11.1.4.1 Testing Personnel We understand that the proposed change to this section is administrative. However, we are seeking clarification of how laboratory strength testing is defined. We concur that ACI certification is needed for the personnel that are operating compressive strength cylinder breaking equipment and interpreting the results in the lab. However, for the plant that produces cylinders and then transfers them to a certified lab, it is not necessary that the said plant personnel making the cylinders have that certification. Incidentally, the technique for preparing dry cast concrete cylinders is discussed in the Level I and II QC training.

**Response: Moved to 105 comments and responses.**

Comment 2 - Re: 105-"8"5.11.1.4.2: Batch Plant Operator Again, we understand that the proposed change to this section is administrative in nature. However, we are seeking a clarification. The State Materials Office indicated in December 2006 that “dry-cast concrete box culvert plants do not need the plant operator training. The proposed Levels I and II courses include the necessary information for their specific needs.” Would the Department consider inserting this clarification into the Section 410 specification or issuing a memo to District offices so that there is no confusion down the road?

**Response: Qualification requirements are included in 105 and should not be added to 410. No change made to 410.**

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**Rick Amlin**  
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**Comments**

410-4.1 limits 2-piece cuolverts to >2’ earth cover. We have produced many culverts for < 2’ earth cover that are performing adequately. We propose 2 piece culverts be accepted regardless of earth cover.

410-4.1 Paragraph 3 requires doublesided tongue and grove joints for 2-piece culverts. The detail on Index 291 Pg. 2/5 requiring 3” min component thickness would need revised for culverts with base slabs less than 10” thick.

**Response: Response (Steve Nolan):**

1. For FDOT projects 2 feet minimum cover will be required over two piece culverts to limit the potential for top slab lift-off and vibration from traffic loads on the grouted joints. 410-1 will not be revised.
2. Approximately 10” min thick base slabs will need to be provided if a two-piece culvert is proposed. Index No. 291 will not be revised.

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