TENDON OVERALL ASSEMBLY

NOTES:
1. MINIMUM BEND RADIUS FOR 48MM DUCT IS 10'-0".
1. Cut duct to the correct length and prepare any required grout vents (see Sheet A461), if applicable.

2. Insert required number of strands through the duct.

3. Lay out duct in the rebar cage according to the plans.

4. Attach trumpets to each end of the duct with heat shrink (do not heat-shrink the duct to trumpet).

5. Bolt anchor heads to the trumpets.

6. Secure anchor heads to its final position to the formwork or pocket former.

7. Heat up the heat shrink to wrap the trumpet and duct connection.

8. Install grout caps; plug all open ports to provide an air-tight system.

9. Pressure test to 2 psi and lock-off outside air source; record pressure loss for one minute. If pressure loss exceeds 0.15 psi, or 10% of the test, and repair leaks in duct assembly using repair methods approved by the engineer and test/retest after testing, remove grout caps.

10. Ensure duct is test off every 2 feet.

11. Proceed with concreting.

12. Strip formworks and pocket formers, if applicable.

13. Lay out duct in the rebar cage according to the plans.

14. Proceed with wetting when concrete reaches required strength.

15. Cut a cap after elongation is confirmed within tolerance. Cut off strand tails and leave maximum 1 2/3 feet in length. Install grout cap.

16. Proceed with tendon pressure test as required by foot specifications in the presence of the Engineer or representative. Pressure test to 10 psi and lock-off outside air source; record pressure loss for one minute. A pressure loss less than 0.15 psi is acceptable for ducts with a length equal to or less than 150 feet and a pressure loss less than 0.5 psi is acceptable for ducts longer than 150 feet. If pressure loss exceeds allowable, repair leaking connections using methods approved by the Engineer.

17. Proceed with grouting operation within 14 days after strand installation (see cap grouting assembly).
GROUT INJECTION/VENT CONFIGURATION USING CORRUGATED GROUT PORT

EPOXY GROUT POUR-BACK AREA (TYPICAL) – REFER TO FDOT STANDARD PLANS INDEX FOR POST TENSIUNING ANCHORAGE AND TENSION FILLING DETAILS.

NOTES:
1. ITEMS MARKED WITH A "T" ARE TEMPORARY AND ARE NOT A PERMANENT PART OF THE SYSTEM.
2. ALL COMPONENTS MUST BE PRESSURE RATED FOR 150 PSI.
3. MINIMUM CONCRETE COVER SHALL BE 2" AND MUST MEET FDOT STRUCTURES DESIGN GUIDELINES SECTION 1.4.2.
4. COMPONENTS MAY BE ASSEMBLED AS A VENT OR A DRAIN AS REQUIRED.

ITEM | QTY | DESCRIPTION | MATERIAL | INVENTORY # | DWG # |
--- | --- | --- | --- | --- | --- |
1 | - | SILICONE GREASE | COMMERCIALLY AVAILABLE | - | - |
2 | 1 | 23MM GROUT HOSE CAP | HDPE BLACK PER ASTM D3350 | 02DT0314 | C586 |
3 | 1 | PVC 1/4 TURN BALL VALVE W/ 3/4" FNPT | WHITE SCH 80 PVC | 02DT01908 | C715 |
4 | 1 | 23MM GROUT EXTENSION | WHITE POLYPROPYLENE PER ASTM D4101 | 02DT01906 | C714 |
5 | 1 | BR PLATE BUSHING 3/4" NPT 23MM | BLACK POLYPROPYLENE PER ASTM D4101 | 02DT0316 | C715 |
6 | - | 23MM GROUT HOSE | HDPE BLACK PER ASTM D3350 | 02DT0310 | C587 |
7 | - | BONDUIT | COMMERCIALLY AVAILABLE | - | - |
8 | 1 | 3/4" SMOOTH HOSE | HDPE BLACK PER ASTM D3350 | 02DT01901 | C685 |
9 | 2 | 3/4" ONE EAR BAND CLAMP | (316L) STAINLESS PER ASTM A240 | 02DT01904 | C690 |
10 | 1 | 3/4" HOSE BAND TO 23MM FITTING | BLACK POLYPROPYLENE PER ASTM D4101 | 02DT01902 | C691 |
11 | 1 | 3/4" HOSE BAND TO 3/4" NPT FITTING | BLACK POLYPROPYLENE PER ASTM D4101 | 02DT01908 | C694 |
12 | 1 | REBAR CAP 3/4" NPT | BLACK POLYPROPYLENE PER ASTM D4101 | 02DT01910 | C692 |
13 | 1 | 3/4" NPT PP NIPPLE | SCH 80 POLYPROPYLENE PER ASTM D4101 | 02DT01912 | C701 |
14 | 1 | 3/4" NPT PP COUPLER | BLACK POLYPROPYLENE PER ASTM D4101 | 02DT01931 | C775 |
INSTALLATION NOTES:
1. MAKE ONE LONGITUDINAL CUT ALONG 59MM DUCT.
2. OPEN 59MM DUCT UP ALONG CUT AND FIT ONTO ENDS OF 48MM DUCT TO BE COUPLED.
3. ENSURE THAT THE RIBS MATCH AS SHOWN IN THE ELEVATION VIEW.
4. INSTALL HEAT SHRINK AS SHOWN, CENTERED ON CONNECTION.

ITEM | QTY | DESCRIPTION |
--- | --- | --- |
1 | DUCT WHT PP, 48MM PT-PLUS | WHITE POLYPROPYLENE PER ASTM D4101 |
2 | DUCT, WHT PP, 59MM PT-PLUS | WHITE POLYPROPYLENE PER ASTM D4101 |
3 | CANUSA PLA-55 Y, 2" X 9" HEAT SHRINK SLEEVE | POLYOLEFIN PER FDOT 960 TABLE 2.2.1.8-1 |
ITEM | QTY | DESCRIPTION | MATERIAL | INVENTORY # | DWG #
--- | --- | --- | --- | --- | ---
1 | 1 | DUCT WHT PP 48MM PT-PLUS | WHITE POLYPROPYLENE PER ASTM D4101 | 02DT0411 | C684E
2 | 1 | EXTERNAL GROUT PORT 23MM | BLACK POLYPROPYLENE PER ASTM D4101 | 02DT0250 | C685

**NOTES:**
1. MATERIALS MEET OR EXCEED FDOT SPECIFICATION 960.
2. FITTINGS ARE RATED TO 150 PSI.

---

**23MM EXTERNAL GROUT PORT INSTALLATION**

1. CLEAR DUCT PRIOR TO GROUT PORT INSTALLATION.
2. DRILL Ø7/8" HOLE INTO DUCT AT CORRUGATED LOCATION (OPTIONAL).
3. CONNECT THE SOCKET WELDING DEVICE TO THE POWER SOURCE.
4. ALLOW THE SOCKET WELDING DEVICE TO REACH ITS WORKING TEMPERATURE.
5. SIMULTANEOUSLY, INSERT MALE ADAPTER OF SOCKET WELDING DEVICE FROM DRILLED HOLE AND GROUT PORT FROM FEMALE ADAPTER.
6. APPLY LIGHT PRESSURE FOR 20-25 SECONDS BY PUSHING THE GROUT PORT WITH THE PALM OF HAND.
7. SIMULTANEOUSLY, REMOVE SOCKET WELDING DEVICE FROM DRILLED HOLE AND GROUT PORT FROM FEMALE ADAPTER.
8. INSERT GROUT PORT INTO HOLE UNTIL THE SHOULDER IS REACHED.
9. INSERT GROUT PORT INTO HOLE AS QUICKLY AND CAREFULLY AS POSSIBLE, WITHIN 5 SECONDS. FINALLY HOLD THE PIECES TOGETHER FOR A MINIMUM OF 10 SECONDS.
FUSION BUTT WELD
USE INSPECTED & APPROVED FUSION PIPE WELDER

PT-PLUS 48

ELEVATION VIEW

NOTES:
1. SEE VSL BUTT-WELDING PROCEDURE IN APPENDIX
INSTALLATION NOTES:
1. MAKE ONE LONGITUDINAL CUT ALONG 76MM DUCT.
2. OPEN 76MM DUCT UP ALONG CUT AND FIT ONTO ENDS OF 48MM DUCT TO BE COUPLED.
3. INSTALL HEAT SHRINK AS SHOWN, CENTERED ON CONNECTION.
NOTES:
1. FINAL DESIGN AND DETAILS OF LOCAL ZONE REINFORCEMENT ARE PROJECT SPECIFIC.
2. LOCAL ZONE REINFORCEMENT HAS SPACING PRIORITY.

DESCRIPTION | MATERIAL | INVENTORY #
-------------|----------|------------
VSLAB 6-4 LOCAL ZONE REINFORCEMENT | STEEL GR60 ASTM A615 | 02VS0625
1. Install anchor head and grout caps, plug all open ports to provide an air-tight system. Pressure loss less than 25 PSI or 50% is acceptable for ducts with a length exceeding 0.75 PSI, or 10%, find and repair leaks in duct assembly using repair methods approved by the end user and testing, remove anchor head & grind remaining bolt flush with concrete.
2. Ensure duct & tie off excess. Post-install procedure, for applicable.
3. Ensure duct & tie off excess. Post-install procedure, for applicable.
4. Follow procedure to properly grind flush, if bolts had to be ground flush, skip this step and use strands to align anchor head.
5. Apply epoxy compound on back of anchor head.
6. Ensure duct & tie off excess. Post-install procedure, for applicable.
7. Immediately begin stressing procedure, if applicable.
8. Remove bolts & outer nuts & washers from trumpet.
9. If bolts cannot be removed, cut off bolt heads & slide formwork off. Place anchor head & grind remaining bolt flush with concrete.
10. Insert (2) additional 3/8" nuts on end.
11. Install ANCHOR INSTALLATION.
12. Cut & cap. After elongations are confirmed within tolerance, cut off STRAND TAIL & secure washers to inside length. INSTALL GROUT CAP.
13. Proceed with tension pressure test as required by foot specifications. In the presence of the engineer or representative, pressure duct to 50 PSI & lock-off outside air source. Record pressure loss for one minute. A pressure loss less than 25 PSI or 5% is acceptable for ducts with a length equal to or less than 100 feet & a pressure less than 15 PSI is acceptable for ducts longer than 100 feet. If pressure loss exceeds 0.75 PSI, or 10%, find and repair leaks in duct assembly using repair methods approved by the end user & testing.
14. Ensure that threaded bolt end is flush with nut.
15. Post-install procedure, for applicable.

NPS: 3/8"Ø UNC X 6 1/2" LONG FULLY THREADED BOLT
P/N: 02VS06423

NPS: 3/8"Ø ALL THREAD
P/N: 02VS06424

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QUALITY CONTROL PLAN

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0.6" DIA. MULTIWEDGES
TYPE 1.6G

SECTION A-A
Bearing Plate Grout Plug 23mm

HDPE Black Per ASTM D3350

Be sure to use the correct material when ordering:

- NBR O-Ring (Parker #N1470 2-212)
- Install during manufacturing

NOTE: MATERIAL MEETS OR EXCEEDS FDOT SPECIFICATION 980
DESCRIPTION | MATERIAL |
---|---
EXTERNAL GROUT PORT 23MM | BLACK POLYPROPYLENE PER ASTM D4101 |

NOTE: MATERIAL MEETS OR EXCEEDS FDOT SPECIFICATION 980
DESCRIPTION | MATERIAL | INVENTORY #
--- | --- | ---
23MM GROUT HOSE | HDPE BLACK PER ASTM D3350 | 02DT0310

SIDE VIEW
VSLAB 6-4 GROUT CAP W/ 3/8" PORT

ABS LUSTRAN 633 PER ASTM D4673

02VS06415

3/8" NPT

SHOP DRILLED & TAPPED HOLE

SECTION A-A

SECTION B-B

VSL LOGO & TEXT "VSLAB 6-4" 0.02" PROUD

APPROX LOCATION - MONTH/YEAR/DATE
CODE 0.02" PROUD

12.0" THRU HOLE (TOP)

APPROVED FOR CONSTRUCTION

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VSL POST TENSIONING 0.6" BARE STRAND

DESCRIPTION
LOW RELAXATION STEEL SEVEN WIRE STRAND PER ASTM A416

INVENTORY #
VA225000013

VSL POST TENSIONING 0.6" BARE STRAND

ASTM A416, 270KSI
<table>
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<th>Duct Type</th>
<th>ØA - Duct Inner Diameter, Inches (mm)</th>
<th>ØC - Duct Major Diameter Nom., Inches (mm)</th>
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<th>Inventory #</th>
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<tr>
<td>VSL 48MM</td>
<td>1.89 (48)</td>
<td>2.49 (63)</td>
<td>White Polypropylene</td>
<td>02DTM411</td>
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</tbody>
</table>

Printed Notes:
- A printed running label may be used with or instead of molded notes.
- A running label will include at least:
  - VSL logo
  - Duct size
  - Date or batch code

Molded Notes:
- VSL logo, repeat every 6'-0".
- Replace "XX" with actual duct size (48, 59, 70, 85, 100, 115, 130, 150)

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3/4" SMOOTH HOSE

C685

SIDE VIEW

AS REQUIRED

NOTE: MATERIAL MEETS OR EXCEEDS FDOT SPECIFICATION 960
INSTALLATION INSTRUCTIONS:
1. Slide band over hose and align over barbs on fitting.
2. Crimp ear on band with pliers using either diagonal cutters or end nippers.
DESCRIPTION: 3/4" HOSE BARB TO 23MM FITTING

MATERIAL: BLACK POLYPORYLENE PER ASTM D4101

INVENTORY #: 02DT01903

NOTE: MATERIAL MEETS OR EXCEEDS FDOT SPECIFICATION 960

NBR O-RING (PARKER #N1470 2-212) INSTALL DURING MANUFACTURING.
3/4" HOSE BARB TO 3/4" NPT FITTING
BLACK POLYPROPYLENE PER ASTM D4101

NOTE: MATERIAL MEETS OR EXCEEDS FDOT SPECIFICATION 960

DESCRIPTION: 3/4" NPT THREAD

INVENTORY #: 02DT01908
THESE SHOP DRAWINGS ILLUSTRATE THE DETAILS OF THE STRUCTURAL TECHNOLOGIES, LLC POST-TENSIONING SYSTEM. THEY WERE PREPARED IN CONFORMANCE WITH THE STRUCTURAL DESIGN PROVIDED TO STRUCTURAL TECHNOLOGIES, LLC BY PROJECT OWNER OR ITS REPRESENTATIVE. STRUCTURAL TECHNOLOGIES, LLC TOOK NO PART IN THE PREPARATION OR REVIEW OF SAID STRUCTURAL DESIGN AND STRUCTURAL TECHNOLOGIES, LLC DISCLAIMS ANY LIABILITY FOR IT. THE STAMP OR SEAL OF A STRUCTURAL TECHNOLOGIES, LLC EMPLOYEE ON THESE SHOP DRAWINGS PERTAINS ONLY TO THE TRANSFER OF THE FORCES REQUIRED BY THE ENGINEER OF RECORD ON THE STRUCTURAL DRAWINGS, AND NOT TO THE ADEQUACY OF THE STRUCTURAL DESIGN. NO WARRANTY, EXPRESSED OR IMPLIED, AS TO THE ADEQUACY OF THE STRUCTURAL DESIGN IS MADE BY VIRTUE OF ANY SUCH STAMP OR SEAL.

**Table: Quad Rings Fabrication**

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<th>Material Description</th>
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<th>T</th>
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<td>VSLAB 6-4 GROUT CAP QUAD-RING (-241)</td>
<td>BUNA-N 70 D PER FDOT 960 TABLE 2.2.1.7-1</td>
<td>3.859&quot;</td>
<td>0.139&quot;</td>
<td>02VS06403</td>
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<tr>
<td>VSLAB 6-4 POCKET FORMER QUAD-RING (-242)</td>
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<td>3.984&quot;</td>
<td>0.139&quot;</td>
<td>02VS06412</td>
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</tbody>
</table>
NOTES:
1. DIMENSIONS PROVIDED FOR REFERENCE ONLY
2. CONTRACTOR MAY DESIGN AND BUILD POCKET FORMER TO SUIT
3. MATERIAL SELECTION AT CONTRACTOR'S DISCRETION
4. SEE SHEET C652 FOR ANCHORAGE DETAILS

DESCRIPTION | MATERIAL | INVENTORY #
--- | --- | ---
VSLAB 6-4 POCKET FORMER | MATERIAL AT CONTRACTOR'S DISCRETION | 02SV06404

USE GASKET SILICON OR OTHER METHOD TO SEAL POCKET FORMER TO ANCHORAGE

UTILIZE SQUARED (NOT SHOWN) OR ROUNDED GEOMETRY AS LONG AS ALL SURFACES OF POSITIVE DRAFT FOR CONCRETE RELEASE

SECTION A-A

END VIEW
RIBBED CAP W/ 3/4" FNPT

**NOTE:** MATERIAL MEETS OR EXCEEDS FDOT SPECIFICATION 960

**DESCRIPTION**

- **RIBBED CAP W/ 3/4" FNPT**
- **BLACK POLYPROPYLENE PER ASTM D4101**
- **INVENTORY #** 02DT01912

**TOP VIEW**

**SIDE VIEW**

23/32"
**DESCRIPTION**: BEARING PLATE GROUT EXTENSION

**MATERIAL**: WHITE POLYPROPYLENE PER ASTM D4101

**INVENTORY #**: 02D10318

**NOTE**: MATERIAL MEETS OR EXCEEDS FDOT SPECIFICATION 960

---

**SIDE VIEW**

**DETAIL A**

NBR O-RING (PARKER #N1470 2-212) INSTALL DURING MANUFACTURING

---

**SECTION**

- **BEARING PLATE GROUT EXTENSION**
- **WHITE POLYPROPYLENE PER ASTM D4101**
- **INVENTORY #**: 02D10318

**NOTE**: MATERIAL MEETS OR EXCEEDS FDOT SPECIFICATION 960
SECTION VIEW

NOTE: MATERIAL MEETS OR EXCEEDS FDOT SPECIFICATION 960
**Description:** PVC 1/4 TURN BALL VALVE W/ 3/4" FNPT

**Material:** WHITE SCH 80 PVC

**Inventory #:** 02DT01916

**Notes:**
- Material meets or exceeds FDOT specification 960
- This is a temporary item

---

**Diagram:**
- Side View

---

**System Drawing**
- Title: SYSTEM DRAWING
- Project Information:
  - Sheet No: I:\VSL System Drawings\Work In Progress Drawings\Work In Progress Drawings\Florida DOT Test 2017\Grouting Accessories
  - Electronic File Location: FILE NAME: C720 3-4in NPT 1-4 Turn Ball Valve FDOT 02DT01916.dwg
  - Plot Date/Time: 29Jan2020 11:53 AM

---

**Structural Technologies, LLC**
- Corporate Office
  - 10150 Old Columbia Rd
  - Columbia, MD 21046
  - Phone: (410) 850-7000
  - structuraltechnologies.com
3/4" NPT PP NIPPLE

SCH 80 BLACK POLYPROPYLENE PER ASTM D4101

NOTE: MATERIAL MEETS OR EXCEEDS FDOT SPECIFICATION 960
**Description:**

- **3/4" NPT PP F/F COUPLER**

**Material:**
- SCH 80 BLACK POLYPROPYLENE PER ASTM D4101

**Inventory #:** 02DT01931

**Note:** Material meets or exceeds FDOT specification 960.
END VIEW

SIDE VIEW

NOTE: THIS IS A TEMPORARY PART

DESCRIPTION | MATERIAL | INVENTORY # |
--- | --- | --- |
PVC 1/4 TURN BALL VALVE W/ 3/8" NPT | WHITE SCH 80 PVC | CH 80 PVC 02DT01933 |
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NOTE: MATERIAL MEETS OR EXCEEDS FDOT SPECIFICATION 960 13/16" TYP.

FRONT VIEW

SIDE VIEW

NOTE: MATERIAL MEETS OR EXCEEDS FDOT SPECIFICATION 960 13/16" TYP.
VSLAB 6-4 TRUMPET O-RING

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<th>DESCRIPTION</th>
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<tr>
<td>VSLAB 6-4 TRUMPET O-RING</td>
<td>BUNA-N 70 D PER FDOT 960 TABLE 2.2.1.7-1</td>
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</table>
HEAT SHRINK 55MM X 9" PLA-YE Polyolefin per foot 960 Table 2.2.1.8-1

DESCRIPTION

INVENTORY #

POLYOLEFIN PER FOOT 960 TABLE 2.2.1.8-1

C869

NO

DESCRIPTION

BY

CHK

DATE

TITLE:

SYSTEM DRAWING

PROJECT INFORMATION:

SHEET NO:

I:\VSL System Drawings\Work In Progress Drawings\Work In Progress Drawings\Florida DOT Test 2017\VSLAB 6-4 48mm Grouted

ELECTRONIC FILE LOCATION:

FILE NAME:

C869 PLA-55-YE 55mmx9in Heat Shrink Sleeve.dwg

11:37 AM

29Jan2020

PLOT DATE/TIME:

29JAN2020

ZX

CDL

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HEAT SHRINK SLEEVE CANUSA/PFA-55-YE (6" LONG)

MATERIAL: POLYOLEFIN PER FDOT 960 TABLE 2.2.1.8-1

INVENTORY #: 02DT0501

DESCRIPTION:
PLA-55-YE 55MMx6" HEAT SHRINK SLEEVE

ELECTRONIC FILE LOCATION:
FILE NAME: C870 PLA-55-YE 55mmx6in Heat Shrink Sleeve 02DT0501.dwg

PLOT DATE/TIME: 11:40 AM 29 Jan 2020

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VARIIES BY PROJECT

SIDE VIEW

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<td>SCH 80 WHITE PVC</td>
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