

24	64-3B-1-3	32	21
ILLINOIS PROJECT			
MASSAC, IL. & McCRACKEN, KY.			

RETROFIT TYPE F5 AND TYPE F8

GENERAL PROCEDURE:

1. CUT VERTICAL STIFFENER ON BOTH SIDES OF THE FLOORBEAM AS SHOWN IN SECTION E - E. GRIND CUT SURFACE TO SMOOTH FINISH.
2. SANDBLAST CLEAN TO REMOVE PAINT FROM THE FLOORBEAM WEB AND TOP OF MANHOLE STIFFENER WITHIN 6" OF EACH SIDE OF CENTER LINE OF FLOORBEAM.
3. USE DYE PENETRANT TO CHECK THE FLOORBEAM WEB FOR CRACKS AT THE LOCATIONS SHOWN ON THE SHORT TRANSVERSE STIFFENER ABOVE THE ACCESS HOLE. IF THE WEB IS CRACKED, DRILL A 15/16" DIAMETER HOLE AT THE CRACK TIP AND DEBURR HOLE. USE DYE PENETRANT ON THE NEWLY EXPOSED (DRILLED) SURFACE OF THE FLOORBEAM WEB TO ENSURE THAT THE CRACK DOES NOT EXTEND PAST THE HOLE. IF THE CRACK EXTENDS PAST THE HOLE, GRIND TO REMOVE CRACK OR DRILL ANOTHER HOLE. REPEAT DYE PENETRANT CHECK.
4. BLAST CLEAN TO REMOVE PAINT FROM FLOORBEAM WEB WITHIN AN AREA 6" IN DIAMETER AND CENTERED AT THE TOP OF THE EXISTING CUT SHORT TRANSVERSE STIFFENERS ON BOTH SIDES OF THE MANHOLE.
5. USE DYE PENETRANT TO CHECK THE FLOORBEAM WEB FOR CRACKS AT THE TOP OF THE EXISTING CUT SHORT TRANSVERSE STIFFENERS ON BOTH SIDES OF THE MANHOLE. IF THE WEB IS CRACKED, DRILL A 15/16" DIAMETER HOLE AT THE CRACK TIP AND DEBURR HOLE. USE DYE PENETRANT ON THE NEWLY EXPOSED (DRILLED) SURFACE OF THE FLOORBEAM WEB TO ENSURE THAT THE CRACK DOES NOT EXTEND PAST THE HOLE. IF THE CRACK EXTENDS PAST THE HOLE, GRIND TO REMOVE CRACK OR DRILL ANOTHER HOLE. REPEAT DYE PENETRANT CHECK.
6. REPEAT STEPS 2, 3, 4 AND 5 FOR THE OPPOSITE SIDE OF THE FLOORBEAM WEB.
7. SECURE NEW WELDMENT TO THE TOP FLANGE SO THAT THE VERTICAL LEG IS TIGHT AGAINST THE OUTSTANDING LEG OF THE EXISTING VERTICAL STIFFENER ANGLE. USING THE NEW WELDMENT AS A TEMPLATE, DRILL HOLES IN THE TOP FLANGE AND THE OUTSTANDING LEG OF THE VERTICAL ANGLE.
8. REMOVE WELDMENT AND SOLVENT CLEAN ALL FAYING SURFACES. REMOVE CUTTING OIL FROM FAYING SURFACES ON EXISTING VERTICAL, FLOORBEAM FLANGE AND WELDMENT. SANDBLAST TO REMOVE PAINT FROM ALL NEW FAYING SURFACES.
9. PLACE WELDMENT IN FINAL POSITION AND INSTALL BOLTS.
10. PAINT RETROFIT AREA.
11. REPEAT STEPS 7, 8, 9 AND 10 FOR ATTACHING WELDMENT TO BOTTOM FLANGE.

RETROFIT F8 ONLY

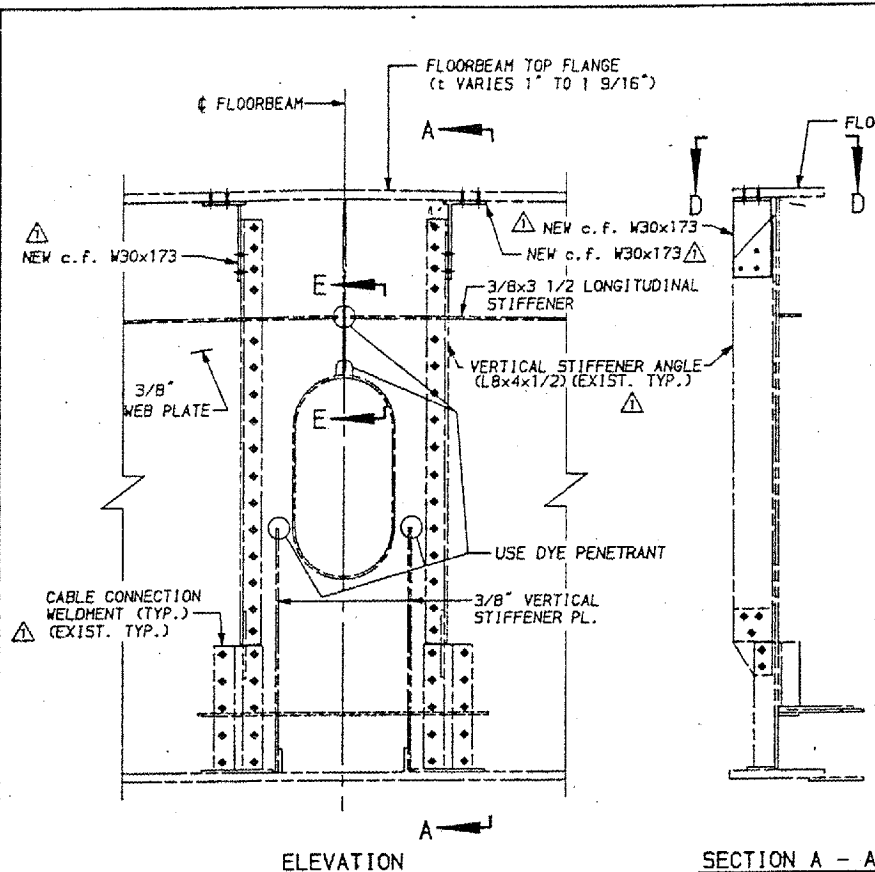
NOTES:

- FOR GENERAL NOTES, SEE SHEET 3.
- FOR RETROFIT LOCATIONS, SEE SHEET 18.
- ALL WORK SHALL BE DONE IN ACCORDANCE WITH THE SPECIAL PROVISIONS.
- DENOTES EXISTING 7/8" H.S. BOLT IN EXISTING HOLE.
- DENOTES NEW 7/8" H.S. BOLT IN NEW HOLES.

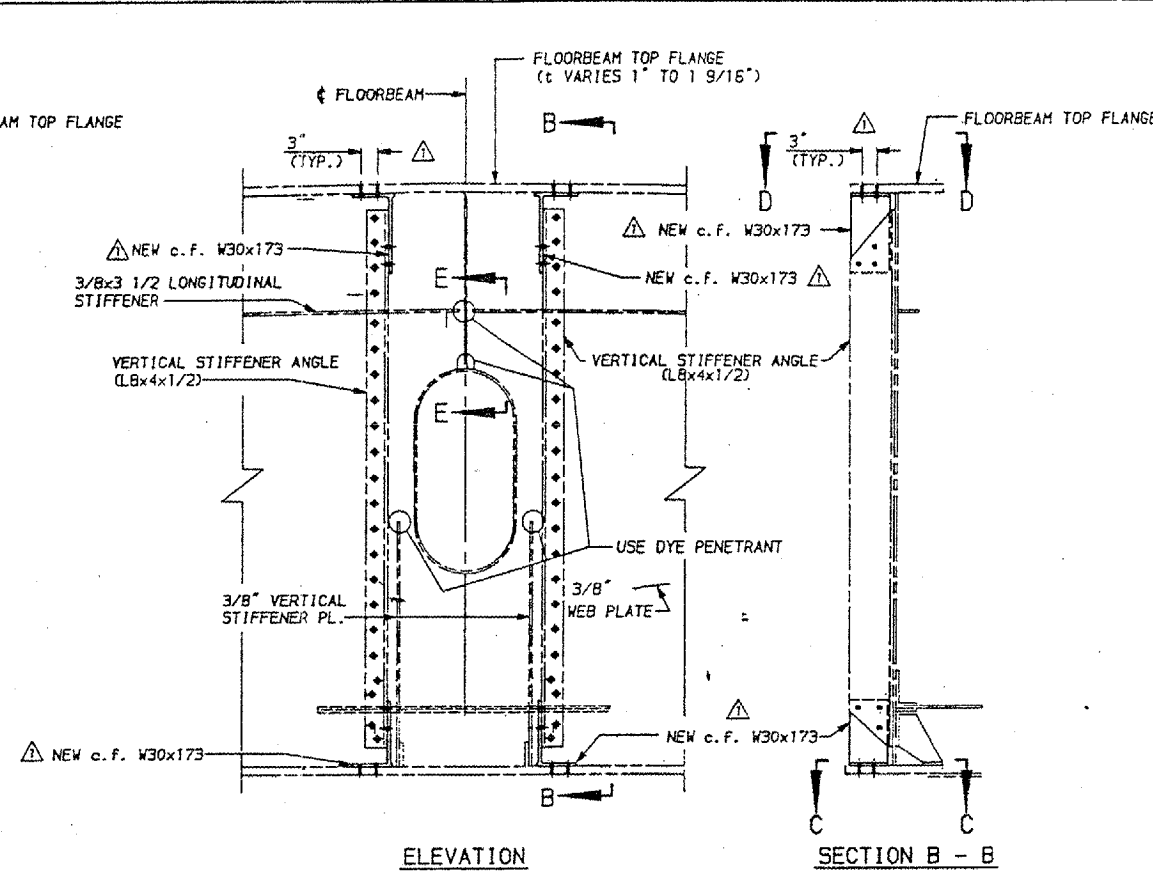
REV. NO.	DRAWN	CHKD.	APPD.	DESCRIPTION	DATE

**F A I ROUTE 24 (INTERSTATE 24)
 OVER OHIO RIVER
 MASSAC COUNTY ILLINOIS**

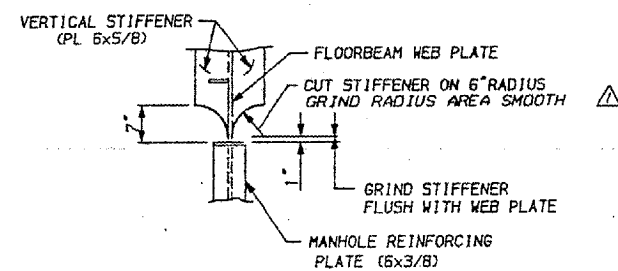
RETROFIT DETAILS 3



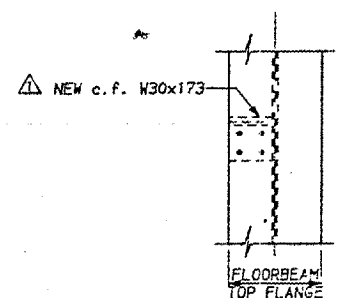
RETROFIT TYPE F5



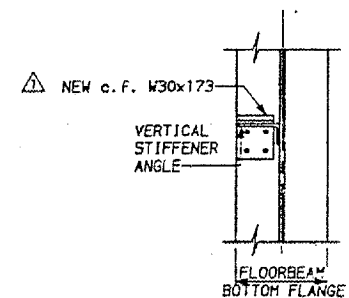
RETROFIT TYPE F8



SECTION E - E



SECTION D-D



SECTION C-C

QUANTITIES				
RETROFIT	ITEM	UNIT	UNIT II	UNIT V
TYPE F5	STRUCTURAL STEEL	LBS.	100	200
TYPE F8	STRUCTURAL STEEL	LBS.	900	900

PREPARED BY
MODJESKI AND MASTERS
 CONSULTING ENGINEERS

DRAWN: CMH
 CHKD: TBM
 APPD: JEP
 DATE: 10/11/88