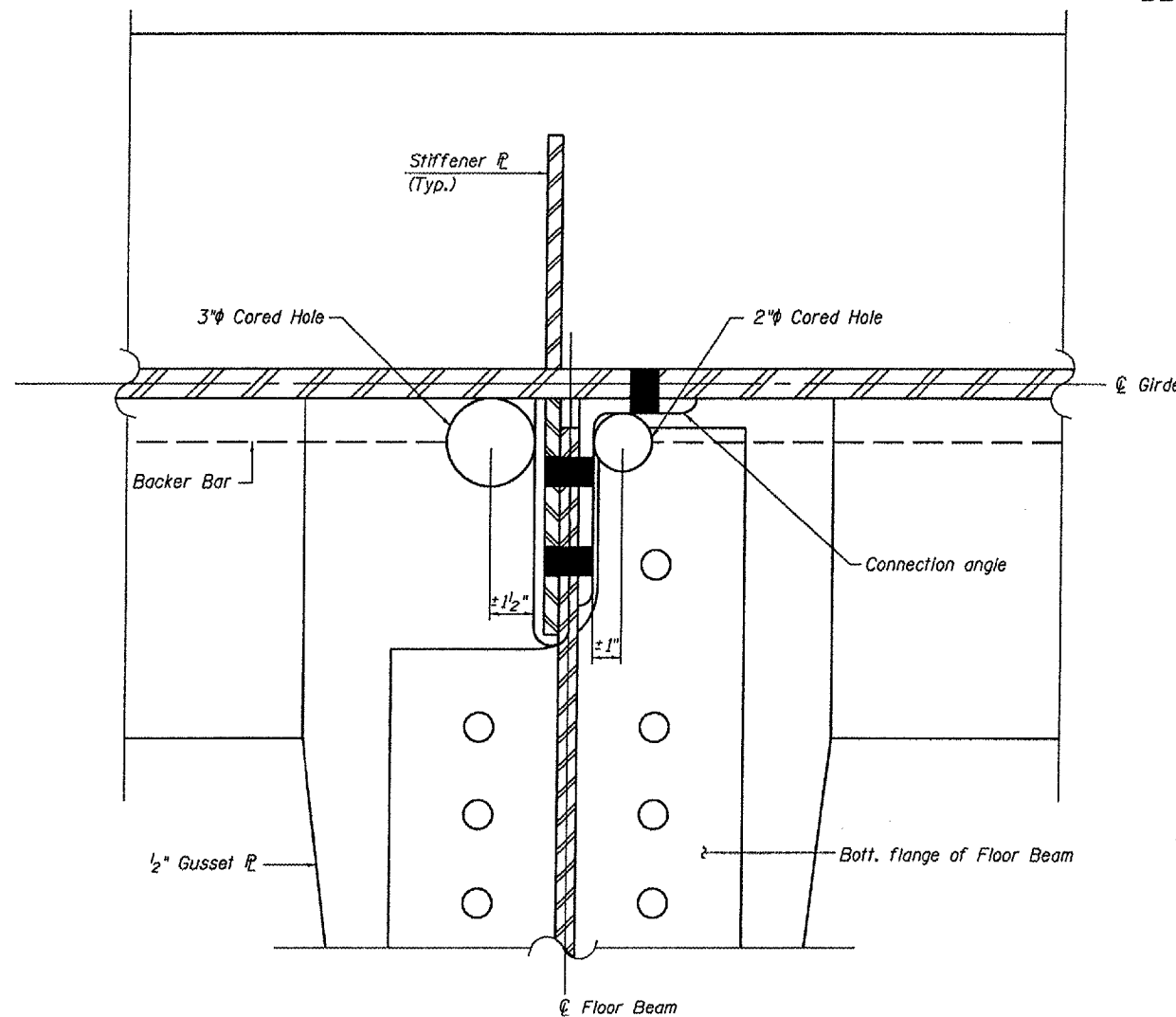


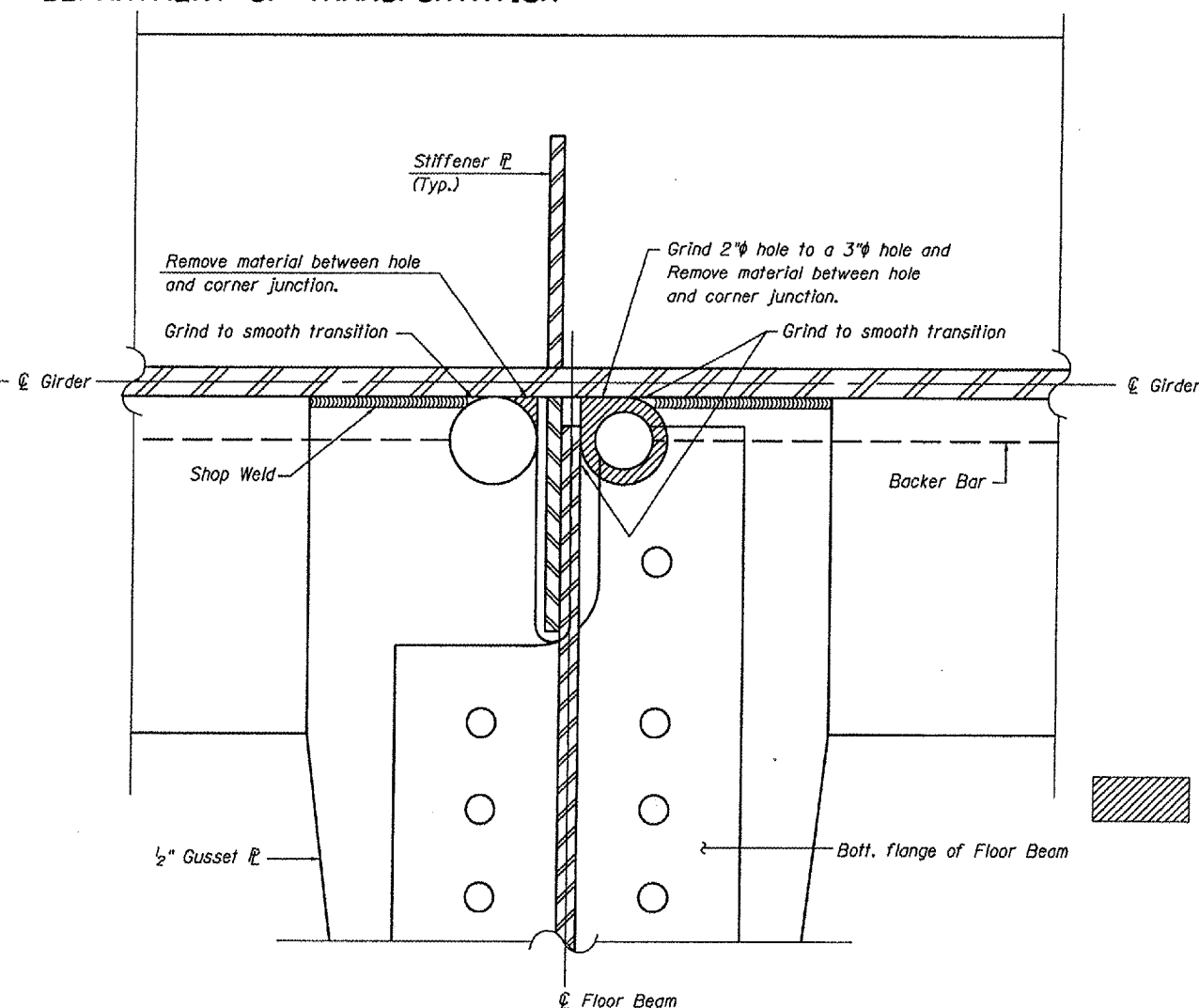
STATE OF ILLINOIS
DEPARTMENT OF TRANSPORTATION

ROUTE NO.	SECTION	COUNTY	SHEETS	SHEET	SHEET NO.
FAI Rt. 57		Alexander	6	6A	4
FED. ROAD DIST. NO. 7	ILLINOIS	FED. AID PROJECT-			OF 4 SHEETS

Contract 78002




DETAIL IA

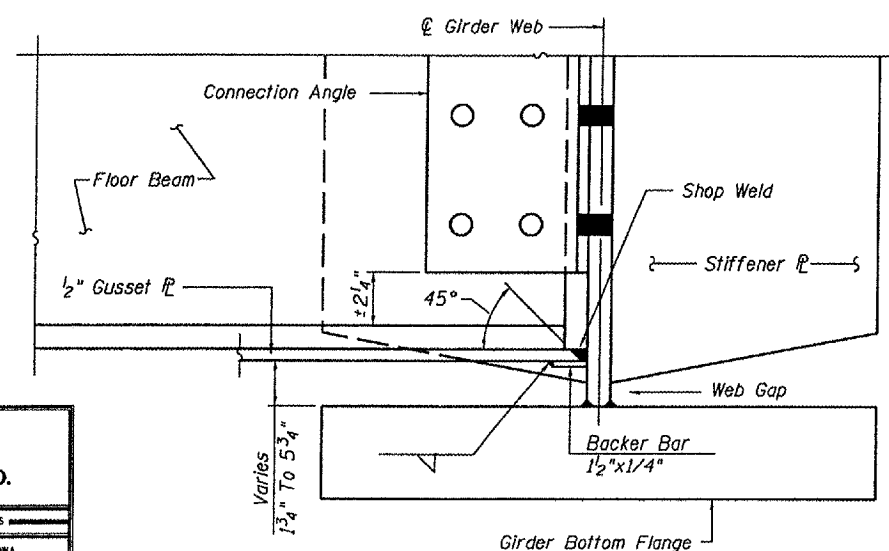


DETAIL IB

Connection angle not shown
for clarity.

 Indicates hand grinding of structural steel.

DETAIL I STIFFENER INTERSECTION MODIFICATION



DETAIL II

Procedure:

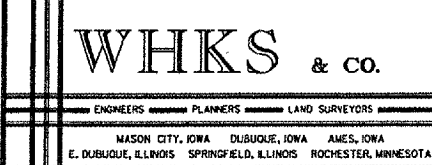
1. Core 2" or 3" holes, positioned close to corner junction as shown in Detail IA. Core 2" hole thru Bott. Flange, Gusset, and Backer Bar. Core 3" hole thru Gusset, and Backer Bar.
2. Enlarge diameter of 2" hole to 3" by symmetrically grinding around hole as shown in Detail IB.
3. Remove material between core and intersection junction by grinding with carbide tools and die grinder. Remove all burrs from cut edge and check for irregularities as shown in Detail IB.
4. Web plate surface shall have a roughness average (Ra) of 250µ-in. or less. Cored surfaces shall have an Ra to 250µ-in. or less. Check for symmetry on each side of stiffener. Repeat step 2 and 3 if necessary for symmetry.
5. After burr removal, the web area shall be inspected for cracks using magnetic particle (MT) or Dye Penetrant methods. Any cracks found shall be identified and reported to the Bureau of Bridges and Structures for further disposition.
6. The exposed steel surfaces shall be cleaned and painted using an aluminum epoxy mastic primer.

Note:

See Special Provisions for further details and payment information.

Cleaning & Painting shall be according to Cleaning and Painting Contact Surface Areas of Existing Steel Structures and shall be included in the cost of "Stiffener Intersection Modification".

MODIFICATION DETAILS
CNIC RAILROAD OVER INTERSTATE 57
ALEXANDER COUNTY
S.N. 002-0025

DESIGNED C.W.C.	 <p>WHKS & CO. ENGINEERS PLANNERS LAND SURVEYORS MASON CITY, IOWA DUBUQUE, IOWA AMES, IOWA E. DUBUQUE, ILLINOIS SPRINGFIELD, ILLINOIS ROCHESTER, MINNESOTA</p>
CHECKED S.D.S.	
DRAWN D.L.H.	
CHECKED C.W.C.	