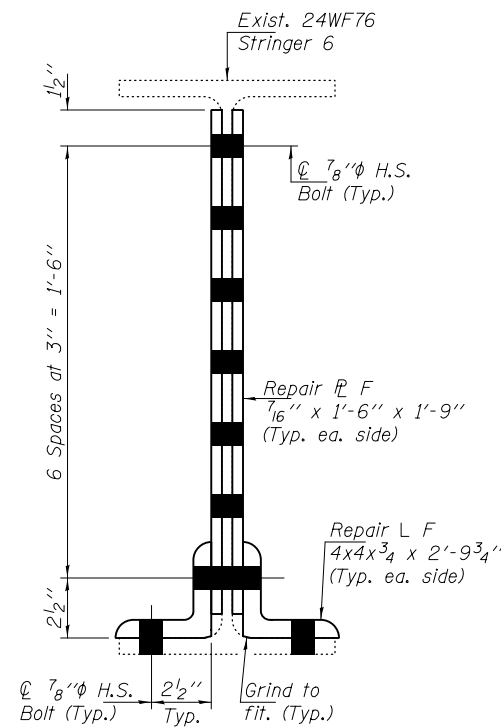
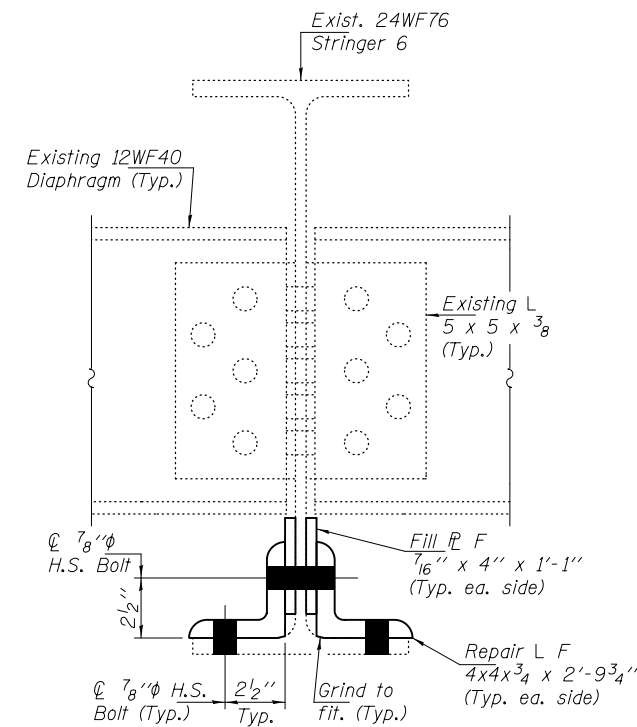


**REPAIR 20 ELEVATION**



**SECTION A-A**  
(Diaphragms & Clip L's not shown for clarity.)

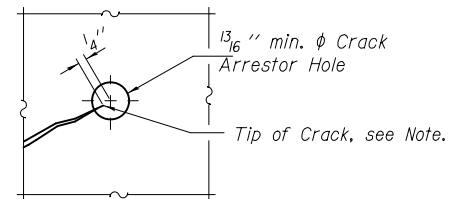


**SECTION B-B**

Notes:  
Remove and dispose of existing repairs plates.  
Place Crack Arrestor Hole at tip of crack if not present.

**BOLT HOLE LEGEND**

- - Field Drill holes using existing Stringer as template.
- - Shop or Field Drill holes.



**CRACK ARRESTOR HOLE DETAIL**

Note:  
Locate crack tip using liquid dye penetrant or magnetic particle testing. Drill 13/16 inch min. phi Crack Arrestor hole at the crack tip. After crack arrestor hole has been drilled, dye penetrant or magnetic particle testing shall be used to verify that the drilled hole has captured the crack tip. Cost included with Structural Steel Repair.

DESIGNED - GGE	EXAMINED - <i>Timothy A. [Signature]</i>	DATE - OCTOBER 17, 2014
CHECKED - TLC	ACTING ENGINEER OF STRUCTURAL SERVICES	
DRAWN - Kyle M. Steffen/balva	PASSED - <i>Carl [Signature]</i>	
CHECKED - GGE TLC	ACTING ENGINEER OF BRIDGES AND STRUCTURES	

**STATE OF ILLINOIS  
DEPARTMENT OF TRANSPORTATION**

**REPAIR DETAIL 20  
SN 099-0056**

SHEET NO. 10 OF 24 SHEETS

F.A.I. RTE.	SECTION	COUNTY	TOTAL SHEETS	SHEET NO.
80	99-3-BR-2	WILL	57	13
CONTRACT NO. 60Y64			ILLINOIS FED. AID PROJECT	