

OVERHEAD SIGN SUPPORTS

DESCRIPTION

Design, fabricate, furnish and erect various types of overhead sign assemblies with maintenance walkways, when specified in the plans, in accordance with the requirements of the plans. Fabricate supporting structures using tubular members of either aluminum or steel. Tubular members made of aluminum are not allowed for Dynamic Message Sign (DMS) structures. Only one type of material may be used throughout the project. The types of overhead sign assemblies included in this specification are span structures, cantilever structures, and sign structures attached to bridges.

MATERIALS

Structural Steel.....	Section 1072
Overhead Structures.....	Section 1096
Signing Materials	Section 1092
Organic Zinc Repair Paint	Article 1080-9
Reinforcing Steel	Section 1070

CONSTRUCTION METHODS

A. General

Fabricate overhead sign assemblies in accordance with the details shown in the approved working drawings and the requirements of these specifications.

No welding, cutting, or drilling in any manner will be permitted in the field, unless approved by the Engineer.

Drill bolt holes and slots to finished size. Holes may also be punched to finished size, provided the diameter of the punched holes is at least twice the thickness of the metal being punched. Flame cutting of bolt holes and slots will not be permitted.

Erect sign panels in accordance with the requirements for Type A or B signs as indicated in the plans or roadway standard drawings. Field drill two holes per connection in the Z bars for attaching signs to overhead structures. Use two bolts at each connection.

Use two coats of a zinc-rich paint to touch up minor scars on all galvanized materials.

B. Shop Drawings

Design the overhead sign supports, including foundations, prior to fabrication. Submit computations and working drawings for the designs to the Engineer for review and acceptance.

Have a professional engineer registered in the State of North Carolina perform the computations and render a set of sealed, signed, and dated drawings detailing the construction of each structure.

Submit to the Engineer for review and acceptance complete design and fabrication details for each overhead sign assembly, including foundations and brackets for supporting the signs, maintenance walkways (when specified in the plans), electrical control boxes, and lighting luminaires. Base design upon the revised structure line drawings, wind load area and the wind speed shown in the plans, and in accordance with the "Standard Specifications for Structural Structures for Highway Signs, Luminaires and Traffic Signals".

Submit thirteen (13) copies of completely detailed working drawings and one (1) copy of the design computations including all design assumptions for each overhead sign assembly to the Engineer for approval prior to fabrication. Working drawings include complete design and fabrication details (including foundations); provisions for attaching signs, maintenance walkways (when applicable), lighting luminaires to supporting structures; applicable material specifications, and any other information necessary for procuring and replacing any part of the complete overhead sign assembly.

Allow 40 days for initial working drawing review after the Engineer receives them. If revisions to working drawings are required, additional time will be required for review and approval of final working drawings.

Approval of working drawings by the Engineer will not relieve the Contractor of responsibility for the correctness of the drawings, or for the fit of all shop and field connections and anchors.

C. Design and Fabrication

The following criteria governs the design of overhead sign assemblies:

Design shall be in accordance with the Standard Specifications for Structural Supports for Highway Signs, Luminaires and Traffic Signals, 5th Edition, 2009 and 2010 and 2011 Interim Revisions.

Within this Specification, there are several design criteria that are owner specified. They include:

- The wind pressure map that is developed from the 3-second gust speeds, as provided in Article 3.8, shall be used.
- Overhead cantilever sign structures shall include galloping loads (exclude four-chord horizontal trusses), truck-induced gust loading and natural wind gust loading in the fatigue design, as provided for in Article 11.7.1, 11.7.4 and 11.7.3 respectively.
- The natural wind gust speed in North Carolina shall be assumed to be 5 meters per second or 11.6 mph for inland areas, and 7 meters per second or 15.7 mph for coastal areas. The coastal area shall be defined as any area within 2 miles from the

waterfront facing the ocean or sound and all area where the design basic wind speed is above 120 mph, as shown in Figure 3-2.

- The fatigue importance category used in the design, for each type of structure, as provided for in Article 11.6, Fatigue Importance Factors, shall be Category II unless otherwise shown on the contract plans.
- Wind drag coefficient for Dynamic Message Sign enclosures shall be 1.7.

The following Specification interpretations or criteria shall be used in the design of overhead sign assemblies:

- For design of supporting upright posts or columns, the effective length factor for columns "K", as provided for in Appendix B, Section B.5, shall be taken as the following, unless otherwise approved by the Engineer:

Case 1 For a single upright post of cantilever or span type overhead sign structure, the effective column length factor, "K", shall be taken as 2.0.

Case 2 For twin post truss-type upright post with the post connected to one chord of a horizontal truss, the effective column length factor for that column shall be taken as 2.0.

Case 3 For twin post truss-type upright post with the post connected to two truss chords of a horizontal tri-chord or box truss, the effective column length factor for that column shall be taken as 1.65

- For twin post truss-type upright post, the unbraced length shall be from the chord to post connection to the top of base plate.
- For twin post truss-type upright post, that is subject to axial compression, bending moment, shear, and torsion the post shall satisfy Standard Specifications for Structural Supports for Highway Signs, Luminaries and Traffic Signals Equations 5-17, 5-18 and 5-19. To reduce the effects of secondary bending, in lieu of Equation 5-18, the following equation may be used:

$$\frac{f_a}{F_a} + \frac{f_b}{\left(1 - \frac{0.6f_a}{F_e}\right)F_b} + \left(\frac{f_v}{F_v}\right) \leq 1.0$$

Where

f_a = Computed axial compression stress at base of post

- The base plate thickness for all uprights and poles shall be a minimum of 2” but not less than that determined by the following criteria and design.

Case 1 Circular or rectangular solid base plates with the upright pole welded to the top surface of base plate with full penetration butt weld, and where no stiffeners are provided. A base plate with a small center hole, which is less than 1/5 of the upright diameter, and located concentrically with the upright pole, may be considered as a solid base plate.

The magnitude of bending moment in the base plate, induced by the anchoring force of each anchor bolt shall be, $M = (P \times D_1) / 2$.

Case 2 Circular or rectangular base plate with the upright pole socketed into and attached to the base plate with two lines of fillet weld, and where no stiffeners are provided, or any base plate with a center hole that is larger in diameter than 1/5 of the upright diameter

The magnitude of bending moment induced by the anchoring force of each anchor bolt shall be $M = P \times D_2$.

- M, bending moment at the critical section of the base plate induced by one anchor bolt
 - P, anchoring force of each anchor bolt
 - D_1 , horizontal distance between the center of the anchor bolt and the outer face of the upright, or the difference between the radius of the bolt circle and the outside radius of the upright
 - D_2 , horizontal distance between the face of the upright and the face of the anchor bolt nut
- The critical section shall be located at the face of the anchor bolt and perpendicular to the radius of the bolt circle. The overlapped part of two adjacent critical sections shall be considered ineffective.
 - The thickness of base plate of Case 1 shall not be less than that calculated based on formula for Case 2.
 - Uprights, foundations, and trusses that support overhead signs or dynamic message signs shall be designed in accordance with the Overhead Sign Foundation Special Provision for the effects of torsion. Torsion shall be considered from dead load eccentricity of these attachments, as well as for attachments such as walkways, supporting brackets, lights, etc., that add to the torsion in the assembly. Truss vertical and horizontal truss diagonals in particular and any other assembly members shall be appropriately sized for these loads.

- Uprights, foundations, and trusses that support overhead mounted signs or dynamic message signs shall be designed for the proposed sign wind area and future wind areas. The design shall consider the effect of torsion induced by the eccentric force location of the center of wind force above (or below) the center of the supporting truss. Truss vertical and horizontal truss diagonals in particular and any other assembly members shall be appropriately sized for these loads.

Fabricate all overhead sign assemblies, including foundations in accordance with the details shown in the approved shop drawings and with the requirements of these specifications.

Fabricate the span and cantilever supporting structures using tubular members of either aluminum or steel, using only one type of material throughout the project. Sign support structures that are to be attached to bridges may be fabricated using other structural shapes.

Horizontal components of the supporting structures for overhead signs may be of a truss design or a design using singular (monotube) horizontal members to support the sign panels. Singular (monotube) horizontal members will not be allowed for DMS signs. Truss or singular member centerline must coincide with centerline of sign design area shown on the structure line drawing. Provide permanent camber in addition to dead load camber in accordance with the "Standard Specifications for Structural Supports for Highway Signs, Luminaires, and Traffic Signals". Indicate on the shop drawings the amount of camber provided and the method employed in the fabrication of the support to obtain the camber.

For all U-bolt connections of hanger beams to overhead assembly truss chords, provide all U-bolts with a flat washer, a lock washer and double nuts at each end of the U-bolts. All double nuts that are on any U-bolt shall be the same thickness and weight. When assembled, the double nuts shall be brought tight against each other by the use of two wrenches.

Use cantilever sign structures that meet the following design criteria:

- a. Do not exceed an $L/150$ vertical dead load deflection at the end of the arm due to distortions in the arm and vertical support, where L is the length of the arm from the center of the vertical support to the outer edge of the sign.
- b. Do not exceed an $L/40$ horizontal deflection at the end of the arm due to distortions in the arm and vertical support, as a result of design wind load.

Attach the overhead sign assemblies to concrete foundations by the use of galvanized anchor bolts with galvanized nuts, flat washers, and lock washers. For cantilever structure use a minimum of eight anchor bolts. Provide anchor bolts that have an anchor plate with nut at the end to be embedded in concrete.

Fabricate attachment assemblies for mounting signs in a manner that allows easy removal of sign panels for repair. Provide adequate supporting frames for mounting the lighting luminaires in the positions shown in the plans or approved shop drawings for all overhead sign assemblies to be illuminated.

MAINTENANCE WALKWAYS

When plans require maintenance walkways, provide maintenance walkways with an open, skid-resistant surface, and safety railings on all overhead structures unless specifically stated otherwise in the plans. Requirements for design and fabrication of the walkways are shown in the plans. Provide a walkway that is continuous and extends from 3 feet (1m) outside the edge of pavement over the shoulder to the farthest edge of any sign on the structure. If a sign is to be located such that it extends more than three feet outside the edge of pavement, extend the walkway for the full length of that sign. Provide walkways with a safety railing along the front side that can be folded, when not in use, to a horizontal position that will not obscure the signs.

To accommodate lighting luminaires, (when required by the plans), extend supports for the walkways in front of the walkway and railing. If external ballast is required, make provisions adjacent to the walkway and between the walkway and sign to accommodate ballast boxes for lighting circuits in a manner readily accessible from the walkway. Provide ballast box, brackets, and fastening devices which will withstand the loading requirements for the walkway, and mount so that the top of the box will be flush with the top of the walkway.

The walkway sections are to be connected rigidly where sections join to avoid an uneven walking surface. Attach the walkway directly to the walkway brackets.

Install a 4-inch x 4-inch safety angle in back of and parallel to the walkway and extend it the entire length of the walkway, except in the area occupied by ballast boxes. Design the safety angle to withstand a loading in keeping with the walkway.

Fabricate folding safety railing in lengths not exceeding 10 feet and install for the full length of the walkway. Join each folding safety railing post to walkway supports through a hinge support of appropriate design that will rotate freely. Provide a hinge support that has a locking or latching device and holds the railing in a steady manner, free of movement while in the raised position. Maximum allowable displacement from vertical at the top of the railing will be 1 inch.

Install fixed safety railing along the sign side of the walkway from the beginning of the walkway to the edge of the first sign. Provide fixed safety rails between signs when they are greater than 12 inches apart. Provide one fixed safety rail below any sign having a clearance between the bottom of the sign and the walkway grating of greater than 24 inches and less than 42 inches. Provide two fixed rails when the clearance between the bottom of a sign and the walkway exceeds 42 inches.

Provide a walkway in which the open ends have a galvanized steel coil safety chain attached on one end near the top of the safety railing, and on the other end to the walkway hanger, or other fixed member of the structure. When the railing is folded, the chain must not hang below the walkway bracket.

Where offsets in the walkway and safety railing are necessitated by variable luminaires provide safety chains between the offset handrail sections.

Anchor Rod Assembly

Attach the overhead sign structure to concrete foundations by the use of straight galvanized anchor bolts with galvanized heavy hex nuts and flat washers. The rods and nuts shall be galvanized in accordance with AASHTO M232. The washers shall be galvanized in accordance with AASHTO M298 Class C. For cantilever structures, use a minimum of eight anchor rods. Provide anchor rods that have an anchor plate with nut at the end to be embedded in concrete.

Ensure material used in steel anchor rods conforms to AASHTO M 314 or ASTM F1554, and the specified yield strength does not exceed 55,000 psi. Compute the required projection of the anchor rod above the foundation top. Compute the total projection based on the following:

- Provide between 3 and 5 threads of anchor rod projection above the top nut after tightening is complete. Avoid any additional projection, or a normal depth socket torque wrench shall not be used on top nuts.
- Include the sum of the thickness of top nut, top nut flat washer or top nut beveled washers, base plate, leveling nut flat washer or leveling nut beveled washers, leveling nut.
- Set the maximum distance between the bottom of the leveling nut and the foundation top to one nut height to avoid excessive bending stresses in the anchor rod under service conditions.
- Do not use lock washers.

ANCHOR ROD NUT TIGHTENING REQUIREMENTS

Prior to installation:

1. Protect the anchor rod threads from damage prior to and during installation.
2. Prior to installation of the rods in the foundation, turn nuts onto and off the rods, well past the elevation of the bottom of the leveling nuts. Turn by the effort of one worker using an ordinary wrench without a cheater bar. Report to the Engineer thread damage requiring unusually large effort.

During installation:

1. Place leveling nuts (bottom nuts) on the anchor rod.
2. Place leveling nut washers on top of the anchor rod leveling nuts.
3. Place a rigid template on top of the leveling nuts to check the level of the nuts. If the anchor nut and washer cannot be brought into firm contact with the template, then beveled washers shall be used.
4. Verify that the distance between the bottom of the leveling nut and the top of the concrete foundation is no more than one anchor rod diameter. If an upright is required to be back-raked, then the distance between the bottom of the leveling nut and the top of the concrete foundation shall be no more than one anchor rod diameter, averaged over the anchor rod group.
5. Place the base plate and structural element to which it is attached. However, do not attach to the upright element, during tightening of the anchor nuts, cantilever beams or arms with span in excess of 10 feet. Luminaire arms and fixtures may be attached prior to standing the pole on the foundation.
6. Place top nut washers.
7. Do not use lock washers.
8. Lubricate threads and bearing surfaces of top nuts. Lubricant shall be beeswax, stick paraffin, or other lubricant approved by the Engineer.
9. Place top nuts. If the anchor nut and washer cannot be brought into firm contact with the base plate, then beveled washers shall be used.
10. Tighten top nuts to snug-tight. A snug-tight condition is defined as the washer and nut being in full contact with the base plate, and the application of the full effort of a workman on a 12-inch wrench. Turn top nuts in increments following a star pattern (using at least two full tightening cycles).

11. To ensure proper pretensioning, after all top nuts have been brought to snug-tight condition, repeat the procedure on the leveling nuts. Turn leveling nuts in increments following a star pattern (using at least two full tightening cycles).
12. At this point, verify if beveled washers are required. Beveled washers shall be required under the leveling nut or top nut if any face of the base plate has a slope greater than 1:20 and / or any nut can not be brought into firm contact with the base plate.
13. Before further nut turning, mark the reference position of the nut in the snug-tight condition with a suitable marking (ink or paint that is not water-soluble). Mark on the corner at the intersection of two flats with a corresponding reference mark on the base plate at each nut. After tightening, verify the nut rotation.
14. Achieve pretensioning by turn-of-nut method. Turn the top nuts to 1/6 of a turn. Do so in a star pattern using at least two full-tightening cycles.
15. After installation, ensure that firm contact exists between the anchor rod nuts, washers, and base plate on any anchor rod installed.
16. For overhead sign assemblies: The span type truss or the cantilever truss may be placed on the uprights or attached to the upright at this time. For signal support structures: The span wires or mast arms may be attached to the upright at this time.
17. After a period of no less than 4 days, and no more than 2 weeks, and in the presence of the Engineer, use a torque wrench to verify that a torque at least equal to 600 foot-pounds is provided on each top nut. For cantilever structures, verify the torque after erection of the remainder of the structure and any heavy attachments to the structure.
18. If any top nut torque reveals less than 600 foot-pounds of effort is required to move the nut, then tighten the nut to no less than 600 foot-pounds.
19. Calibrate the torque indicator, and obtain corresponding certification, for all torque wrenches used for anchor nut tightening. The calibration and certification shall have occurred no more than 12 months prior to use of the torque wrench. Torque wrenches that were calibrated and certified more than twelve months prior to anchor nut tightening shall be re-calibrated and re-certified prior to use. Provide the Engineer a certification of such calibration.

- 20. Because inspection or re-tightening of the leveling nuts would be prevented, and to reduce moisture retention and associated corrosion, grout shall not be allowed under the base plate.

COMPENSATION

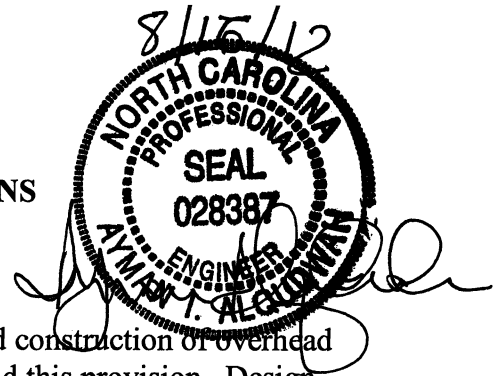
The work covered by this section will be paid for at the contract lump sum for each Overhead Structure “_____”. Such price will be full compensation for all work covered by this specification includes all design, fabrication, construction, transportation, and erection of the complete overhead sign structure, supporting structure, hardware, lighting support brackets, preparing and furnishing shop drawings, and attaching the signs to the overhead assembly.

Payment will be made under:

Supports, Overhead Sign Structure @ Sta. “_____”

Lump Sum

OVERHEAD SIGN FOUNDATIONS



DESCRIPTION

The work covered by this provision consists of the design and construction of overhead sign foundations in accordance with the submitted approved plans and this provision. Design and construct either spread footing type foundations and/or drilled pier type foundations for each overhead sign unless otherwise directed by the Engineer.

MATERIALS

- Portland Cement Concrete Production and DeliverySection 1000
- Reinforcing SteelSection 1070
- Anchor BoltsArticle 1072-6
- Structural Steel and Overhead Sign StructuresSection 1072 and 1096

CONSTRUCTION METHODS

1. General

A North Carolina Licensed Professional Engineer must seal all design calculations, drawings and recommendations. Design foundations for the effects of dead, wind and ice loads in accordance with the wind zone load shown on the plans and Section 3 of the AASHTO Standard Specifications for Structural Supports for Highway Signs, Luminaries and Traffic Signals (including interims). Use either spread footing or drilled pier foundations. In some instances, conflicts with drainage structures may dictate a certain type of foundation. Spread footings or dual drilled pier foundations are required for full span overhead signs (no single drilled pier foundations). When designing dual drilled pier foundations, a rectangular grade beam with a moment of inertia approximately equal to either of the drilled piers is required to connect the pier tops.

Provide reinforced concrete design in accordance with either Section 13.7.2 or 13.6.2 (whichever is applicable), allowable stress design method, of the AASHTO Standard Specifications for Structural Supports for Highway Signs, Luminaries and Traffic Signals (including interims).

Consider sloping ground in the design, if applicable. Do not exceed an allowable bearing pressure of 3 ksf for spread footings. For drilled pier foundations, do not exceed an allowable lateral soil pressure of 4 ksf for AASHTO Group II Loading. Use the following default soil parameters and groundwater elevation for foundation design in the absence of a site-specific subsurface investigation in accordance with this provision.

- Total Unit Weight = 120 pcf
- Friction Angle = 30 degrees
- Cohesion = 0 psf

Assume the groundwater elevation is at a depth of 7 feet below the ground surface. If the groundwater is encountered at a depth shallower than 7 feet, the overhead sign foundation must be redesigned based upon the actual field conditions. The default soil parameters and allowable

pressures do not apply to very soft or loose soil, muck (generally, SPT blow counts per foot less than 4), weathered rock or hard rock (generally, SPT refusal). If soft or loose soil, muck, weathered rock or hard rock conditions are present, a site-specific subsurface investigation and foundation design is required in accordance with this provision.

Design spread footings in accordance with Sections 4.4.1 through 4.4.10, allowable stress design method, of the AASHTO Standard Specifications for Highway Bridges (including interims). Restrict uplift due to the eccentricity of the loading to one corner of the footing and the tension area may not exceed 25% of the total bearing area of the spread footing.

Design drilled piers in accordance with Sections 4.6.1 through 4.6.5, allowable stress design method, of the AASHTO Standard Specifications for Highway Bridges (including interims). If drilled piers are designed for skin friction only, increase the required length of each drilled pier a minimum of 6 inches to allow for sediment. If drilled piers are designed for end bearing, no additional length is required; however, the drilled piers will be subject to the cleanliness requirements in Section B under "Drilled Pier Construction:" below. Clearly state on the plans whether end bearing was accounted for in the foundation design.

Calculate expected vertical, lateral and torsional movements for single drilled pier foundations. Provide drilled pier foundations that result in a horizontal lateral movement of less than 1 inch at the top of the pier and a horizontal rotational movement of less than 1 inch at the edge of the pier. Also, use a factor of safety of 2.0 for lateral and torsion failure. Preliminary design methods described in Section 13.6.1.1 of the AASHTO Standard Specifications for Structural Supports for Highway Signs, Luminaries and Traffic Signals (including interims) may be used to incorporate a factor of safety in foundation design for lateral failure. Wings are required to increase torsion resistance for cantilever signs supported by a single drilled pier.

If a site-specific subsurface investigation is performed, use only an NCDOT Highway Design Branch Pre-Qualified Geotechnical Engineering Firm to provide a site specific foundation design.

2. Subsurface Investigation

If the default soil parameters or allowable pressures referenced above are not applicable for a given overhead sign foundation site, the Engineer may require a site-specific subsurface investigation. If the Engineer requires a site-specific subsurface investigation, the Department will perform the borings and provide the data to the Contractor. The subsurface investigation will be provided within two weeks of being notified by the Contractor that the site is at rough grade and accessible to a drill rig.

The Contractor may elect to conduct a site specific subsurface investigation at each proposed overhead sign foundation location in accordance with the requirements listed below, in lieu of using the default soil parameters and allowable pressures referenced above. If the Contractor elects to conduct a site-specific subsurface investigation, the costs of the investigation will be considered incidental to the "Overhead Footing" pay item.

Perform a boring at each overhead sign foundation location and provide boring data on an NCDOT Standard Boring Log form. Download this form from the NCDOT site at <http://www.ncdot.org/doh/preconstruct/highway/geotech/contractserv/investigation/Documents/BoringLogs.zip>. A licensed geologist or a professional engineer registered in the State of North Carolina and employed by an NCDOT Highway Design Branch pre-qualified Geotechnical Engineering Firm must seal each boring log. Use only an NCDOT Highway Design Branch pre-qualified Geotechnical Engineering Firm to conduct the subsurface investigation. Perform the investigation only after rough grade (within 3 feet of final grade) is achieved. Locate each boring within 3 feet of the center of the overhead sign foundation. Drill the boring to a minimum depth of 10 feet below the required spread footing bearing or drilled pier tip elevation, whichever is deeper. Conduct Standard Penetrating Tests at 1 ft, 2.5 ft, 5 ft, 7.5 ft, 10 ft, and every 5-ft after 10 ft below the rough grade in accordance with ASTM D-1586. A boring may be terminated above the minimum depth required (10 ft below the foundation elevation) if one of the following conditions occur: (a) a total of 100 blows have been applied in any 2 consecutive 6-in.intervals; (b) a total of 50 blows have been applied with less than 3-in. penetration.

3. Foundation Construction

Excavate footings for overhead sign structures in accordance with the applicable provisions of Section 410 of the 2006 Standard Specifications. Construct footings for overhead sign structures in accordance with Section 825 of the 2006 Standard Specifications. Construct all footings with Class A concrete. Where rectangular forms are used, use forms that have a chamfer strip at all corners for at least that distance protruding above finished ground. Use chamfers, which measure one-inch along the diagonal face.

Securely brace anchor bolts positioned in the form and hold in proper position and alignment. Provide a rubbed finish on concrete surfaces to be exposed above finished ground in accordance with Section 825-6 (D) of the 2006 Standard Specifications. Do not erect overhead sign structures on foundations until the concrete has reached a minimum compressive strength of 3000 psi. Determine concrete compressive strength by nondestructive test methods or compressive strength tests made in accordance with AASHTO T22 and T23. Furnish equipment used for nondestructive tests and obtain Engineer's approval before performing the tests.

4. Drilled Pier Construction

A. Excavation

Perform excavations for drilled piers to the required dimensions and lengths including all miscellaneous grading and excavation necessary to install the drilled pier. Depending on the subsurface conditions encountered excavation in hard rock, weathered rock or removal of boulders and debris may be required.

Dispose of drilling spoils as directed by the Engineer and in accordance with Section 802 of the 2006 Standard Specifications. Drilling spoils consist of all material excavated including water or slurry removed from the excavation either by pumping or with augers.

Construct drilled piers within the tolerances specified herein. If tolerances are exceeded, provide additional construction as approved by the Engineer to bring the piers within the tolerances specified. Construct drilled piers such that the axis at the top of the piers is no more than 3 inches in any direction from the specified position. Build drilled piers within 1% of the plumb deviation for the total length of the piers. When a grade beam is not required at the top of a pier, locate the top of pier elevation between 18 inches above and 6 inches above the finished grade elevation. Form the top of the pier such that the concrete is smooth and level.

If unstable, caving or sloughing soils are anticipated or encountered, stabilize drilled pier excavations with steel casing and/or polymer slurry. Steel casing may be either the sectional type or one continuous corrugated or non-corrugated piece. All steel casings should consist of clean watertight steel of ample strength to withstand handling and driving stresses and the pressures imposed by concrete, earth or backfill. Use steel casings with an outside diameter equal to the specified pier size and a minimum wall thickness of 1/4 inch. . Extract all temporary casings during concrete placement in accordance with this provision unless the Contractor chooses to leave the casing in place in accordance with the requirements below.

Any steel casing left in place will be considered permanent casing. When installing permanent casing do not drill or excavate below the tip of the permanent casing at any time such that the permanent casing is against undisturbed soil. The Contractor may excavate a hole with a minimum diameter of 12 inches smaller than the specified size of the pier in order to facilitate permanent casing installation provided the sides of the excavation do not slough during drilling such that the hole diameter becomes larger than the inside diameter of the casing. Permanent steel casings are only allowed for full span overhead signs as approved by the Engineer and prohibited for cantilever overhead signs. No additional compensation will be paid for permanent casing. If the Contractor chooses to use permanent steel casing, include all casing costs in the "Overhead Footing" pay item.

If the Contractor elects to use polymer slurry to stabilize the excavation, use one of the polymers listed in the table below or an approved equal:

PRODUCT	MANUFACTURER
SlurryPro EXL	KB Technologies Ltd 3648 FM 1960 West Suite 107 Houston, TX 77068 (800) 525-5237
Super Mud	PDS Company 105 West Sharp Street El Dorado, AR 71730 (800) 243-7455
Shore Pac GCV	CETCO Drilling Products Group 1500 West Shure Drive

	Arlington Heights, IL 60004 (800) 527-9948
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Use slurry in accordance with the manufacturer's guidelines and recommendations unless approved otherwise by the Engineer. The Contractor should be aware that polymer slurry might not be appropriate for a given site. Polymer slurry should not be used for excavations in very soft or loose soils. If the excavation can not be stabilized with polymer slurry, the Engineer may require a site-specific subsurface investigation (if not done during design) and the use of steel casing. No additional time or compensation will be provided if both steel casing and polymer slurry are required to stabilize the excavation.

Construct all drilled piers such that the piers are cast against undisturbed soil. If a larger casing and drilled pier are required as a result of unstable or caving material during drilling, backfill the excavation before removing the casing to be replaced. No additional time or compensation will be provided for substituting a larger diameter drilled pier in order to construct a drilled pier cast against undisturbed soil.

Any temporary steel casing that becomes bound or fouled during pier construction and cannot be practically removed may constitute a defect in the drilled pier. Improve such defective piers to the satisfaction of the Engineer by removing the concrete and enlarging the drilled pier, providing a replacement pier or other approved means. All corrective measures including redesign as a result of defective piers will not be cause for any claims or requests for additional time or compensation.

B Bottom Cleanliness:

After a drilled pier excavation is complete and immediately before concrete placement, demonstrate acceptable bottom cleanliness of the drilled pier excavation to the Engineer for approval if the plans indicate end bearing was used in the design. Provide any equipment, personnel and assistance required for the Engineer to inspect the drilled pier excavation. The pier excavation bottom is considered clean if no portion of the bottom area has more than 3 inches of sediment as determined by the Engineer.

C. Reinforcing Steel:

Completely assemble a cage of reinforcing steel consisting of longitudinal and spiral bars and place cage in the drilled pier excavation as a unit immediately upon completion of drilling unless the excavation is entirely cased. If the drilled pier excavation is entirely cased down to the tip, immediate placement of the reinforcing steel and the concrete is not required.

Lift the cage so racking and cage distortion does not occur. Keep the cage plumb during concrete placement operations and casing extraction. Check the position of the cage before and after placing the concrete.

Securely crosstie the vertical and spiral reinforcement at each intersection with double wire. Support or hold down the cage so that the vertical displacement during concrete placement and casing extraction does not exceed 2 inches.

Do not set the cage on the bottom of the drilled pier excavation. Place plastic bolsters under each vertical reinforcing bar that are tall enough to raise the rebar cage off the bottom of the drilled pier excavation a minimum of 3 inches.

In order to ensure a minimum of 3 inches of concrete cover and achieve concentric spacing of the cage within the pier, tie plastic spacer wheels at five points around the cage perimeter. Use spacer wheels that provide a minimum of 3 inches "blocking" from the outside face of the spiral bars to the outermost surface of the drilled pier. Tie spacer wheels that snap together with wire and allow them to rotate. Use spacer wheels that span at least two adjacent vertical bars. Start placing spacer wheels at the bottom of the cage and continue up along its length at maximum 10-foot intervals. Supply additional peripheral spacer wheels at closer intervals as necessary or as directed by the Engineer.

D. Concrete:

Begin concrete placement immediately after inserting reinforcing steel into the drilled pier excavation.

1) Concrete Mix

Provide the mix design for drilled pier concrete for approval and, except as modified herein, meeting the requirements of Section 1000 of the 2006 Standard Specifications.

Designate the concrete as Drilled Pier Concrete with a minimum compressive strength of 4500 psi at 28 days. The Contractor may use a high early strength mix design as approved by the Engineer. Make certain the cementitious material content complies with one of the following options:

- Provide a minimum cement content of 640 lbs/yd³ and a maximum cement content of 800 lbs/yd³; however, if the alkali content of the cement exceeds 0.4%, reduce the cement content by 20% and replace it with fly ash at the rate of 1.2 LB of fly ash per LB of cement removed.
- If Type IP blended cement is used, use a minimum of 665 lbs/yd³ Type IP blended cement and a maximum of 833 lbs/yd³ Type IP blended cement in the mix.

Limit the water-cementitious material ratio to a maximum of 0.45. Do not air-entrain drilled pier concrete.

Produce a workable mix so that vibrating or prodding is not required to consolidate the concrete. When placing the concrete, make certain the slump is between 5 and 7 inches for dry placement of concrete or 7 and 9 inches for wet placement of concrete.

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Use Type I or Type II cement or Type IP blended cement and either No. 67 or No. 78M coarse aggregate in the mix. Use an approved water-reducer, water-reducing retarder, high-range water-reducer or high-range water-reducing retarder to facilitate placement of the concrete if necessary. Do not use a stabilizing admixture as a retarder in Drilled Pier Concrete without approval of the Engineer. Use admixtures that satisfy AASHTO M194 and add admixtures at the concrete plant when the mixing water is introduced into the concrete. Redosing of admixtures is not permitted.

Place the concrete within 2 hours after introducing the mixing water. Ensure that the concrete temperature at the time of placement is 90°F or less.

2) Concrete Placement

Place concrete such that the drilled pier is a monolithic structure. Temporary casing may be completely removed and concrete placement may be temporarily suspended when the concrete level is within 42 to 48 inches of the ground elevation to allow for placement of anchor bolts and construction of grade beam or wings. Do not pause concrete placement if unstable caving soils are present at the ground surface. Remove any water or slurry above the concrete and clean the concrete surface of all scum and sediment to expose clean, uncontaminated concrete before inserting the anchor bolts and conduit. Resume concrete pouring within 2 hours.

Do not dewater any drilled pier excavations unless the Engineer approves the dewatering and the excavation is entirely cased down to tip. Do not begin to remove the temporary casing until the level of concrete within the casing is in excess of 10 feet above the bottom of the casing being removed. Maintain the concrete level at least 10 feet above the bottom of casing throughout the entire casing extraction operation except when concrete is near the top of the drilled pier elevation. Maintain a sufficient head of concrete above the bottom of casing to overcome outside soil and water pressure. As the temporary casing is withdrawn, exercise care in maintaining an adequate level of concrete within the casing so that fluid trapped behind the casing is displaced upward and discharged at the ground surface without contaminating or displacing the drilled pier concrete. Exerting downward pressure, hammering or vibrating the temporary casing is permitted to facilitate extraction.

Keep a record of the volume of concrete placed in each drilled pier excavation and make it available to the Engineer.

After all the pumps have been removed from the excavation, the water inflow rate determines the concrete placement procedure. If the inflow rate is less than 6 inches per half-hour, the concrete placement is considered dry. If the water inflow rate is greater than 6 inches per half-hour, the concrete placement is considered wet.

- **Dry Placement:** Before placing concrete, make certain the drilled pier excavation is dry so the flow of concrete completely around the reinforcing steel can be certified

by visual inspection. Place the concrete by free fall with a central drop method where the concrete is chuted directly down the center of the excavation.

- **Wet Placement:** Maintain a static water or slurry level in the excavation before placing concrete. Place concrete with a tremie or a pump in accordance with the applicable parts of Sections 420-4 and 420-5 of the 2006 Standard Specifications. Use a tremie tube or pump pipe made of steel with watertight joints. Passing concrete through a hopper at the tube end or through side openings as the tremie is retrieved during concrete placement is permitted. Use a discharge control to prevent concrete contamination when the tremie tube or pump pipe is initially placed in the excavation. Extend the tremie tube or pump pipe into the concrete a minimum of 5 feet at all times except when the concrete is initially introduced into the pier excavation. If the tremie tube or pump pipe pulls out of the concrete for any reason after the initial concrete is placed, restart concrete placement with a steel capped tremie tube or pump pipe.

Once the concrete in the excavation reaches the same elevation as the static water level, placing concrete with the dry method is permitted. Before changing to the dry method of concrete placement, remove any water or slurry above the concrete and clean the concrete surface of all scum and sediment to expose clean, uncontaminated concrete.

Vibration is only permitted, if needed, in the top 10 feet of the drilled pier or as approved by the Engineer. Remove any contaminated concrete from the top of the drilled pier and wasted concrete from the area surrounding the drilled pier upon completion.

3) Concrete Placement Time:

Place concrete within the time frames specified in Table 1000-2 of the 2006 Standard Specifications for Class AA concrete except as noted herein. Do not place concrete so fast as to trap air, water, fluids, soil or any other deleterious materials in the vicinity of the reinforcing steel and the annular zone between the rebar cage and the excavation walls. Should a delay occur because of concrete delivery or other factors, reduce the placement rate to maintain some movement of the concrete. No more than 45 minutes is allowed between placements.

E. Scheduling and Restrictions:

If caving or sloughing occurs, no additional compensation will be provided for additional concrete to fill the resulting voids.

During the first 16 hours after a drilled pier has achieved its initial concrete set as determined by the Engineer, do not drill adjacent piers, do not install adjacent piles and do not allow any heavy construction equipment loads or "excessive" vibrations to occur at any point within a 20 foot radius of the drilled pier.

In the event that the procedures described herein are performed unsatisfactorily, the Engineer reserves the right to shut down the construction operations or reject the drilled piers. If the integrity of a drilled pier is in question, use core drilling, sonic or other approved methods at no additional cost to the Department and under the direction of the Engineer. Dewater and backfill core drill holes with an approved high strength grout with a minimum compressive strength of 4500 psi. Propose remedial measures for any defective drilled piers and obtain approval of all proposals from the Engineer before implementation. No additional time or compensation will be provided for losses or damage due to remedial work or any investigation of drilled piers found defective or not in accordance with this provision or the plans.

COMPENSATION

The work covered by this section to be paid for will be the actual number of cubic meters of concrete, which has been incorporated into the completed and accepted footing. Computing the number of cubic meters of concrete will be done from the dimensions shown in the plans or from revised dimensions authorized by the Engineer, calculated to the nearest 0.01 of a cubic meter.

Payment will be made under:

Overhead Footings.....Cubic Meters