SPECIAL PROVISION
SECTION 502
STRUCTURAL CONCRETE
(Fiber Reinforced Polymer Bridge Drains)

Description

This work shall consist of design, fabrication and delivery of bridge drains using FRP (Fiber Reinforced Polymer) composite materials in accordance with the plans and this specification.

Specifications

Work shall be done in general accordance with the following specifications:

a. AASHTO LRFD Guide Specifications for Design of Concrete-Filled FRP Tubes for Flexural and Axial Members, 2012.
b. American Composites Manufacturing Association, ACMA Code of Standard Practice, First Edition, 2011.
c. ISO/IEC Guide 58, Calibration and Testing Laboratory Accreditation Systems - General Requirements for Operation and Recognition.
d. ISO/IEC 17025 General Requirements for the Competence of testing and Calibration Laboratories.
e. MaineDOT Standard Specifications.

2.3 Standards

A.) ASTM D 2584. Standard Test Method for Ignition Loss of Cured Reinforced Resins. American Society for Testing and Materials, West Conshohocken, PA.

B.) ASTM D 3039. Standard Test Method for Tensile Properties of Polymer Matrix Composite Materials. American Society for Testing and Materials, West Conshohocken, PA.

C.) ASTM D 3171. Standard Test Methods for Constituent Content of Composite Materials. American Society for Testing and Materials, West Conshohocken, PA.

D.) ASTM D 4385. Standard Practice for Classifying Visual Defects in Thermosetting Reinforced Plastic Pultruded Products. American Society for Testing and Materials, West Conshohocken, PA.

E.) ASTM D 570. Test Method for Water Absorption of Plastics. American Society for Testing and Materials, West Conshohocken, PA.

F.) ASTM E 1356. Standard Test Method for Assignment of the Glass Transition Temperatures by Differential Scanning Calorimetry. American Society for Testing and Materials, West Conshohocken, PA.

G.) ASTM E 1640. Standard Test Method for Assignment of the Glass Transition Temperature by Dynamic Mechanical Analysis. American Society for Testing and Materials, West Conshohocken, PA.

H.) ASTM C 582. Standard Specification for Contact-Mold Reinforced Thermosetting Plastic (RTP) Laminates for Corrosion-Resistant Equipment. American Society for Testing and Materials, West Conshohocken, PA.

Material

Materials shall conform to the following requirements:

1. FRP composite drain and pipe material shall meet the requirements of Appendix A.

2. All material and workmanship will meet or exceed the requirements of the ASTM Specifications above.

3. Drain support assembly shall meet the material and protective coating requirements specified in the Standard Details.

Construction Requirements

FRP Drain Manufacturers

The FRP bridge drains shall be supplied by one of the following companies:

1. Kenway Corporation
2. FRP Bridge Drain Pipe-Westfall Company
3. ACO USA

The above suppliers have been pre-certified by providing materials samples that have been tested in accordance with Appendix A. Other suppliers/manufacturers may become certified if FRP bridge drain samples are tested in accordance with the requirements in Appendix A along with meeting the following requirements.

All manufactures or fabricators of FRP bridge drain systems/components are required to have a minimum of 3 years of experience in providing FRP composite structural grade products to the general market. Manufacturers need to provide documentation that personnel involved in manufacture/fabrication hold and maintain American Composites Manufactures Association (ACMA) certifications in a minimum of one of the following disciplines; 1) Open Molding, 2) Corrosion, 3) Vacuum Infusion, 4) Closed Molding and that the Manufacturer/Fabricator have an

ISO 9001:(current year) or other independent certification to ensure that the Manufacturer's process has been independently audited for conformance.

Design Guide for FRP Composite Scupper Bodies/Drain Inlets

General

The bridge shall use a drain size specified on the plans. See Appendix B for additional details. The bottom of the downspout shall extend a minimum of 12 inches below the bottom of the beams. For bridge decks with an integral concrete wearing surface, the drain pan depth shall be reduced to provide adequate concrete cover.

Deck/interface drain holes.

For bridge decks with pavement and waterproofing membrane, drain holes are required on both sides of the scupper to capture moisture at the interface between the top of the deck and bottom of the asphalt pavement. Three holes one half inch in diameter spaced at 6 inches on center and three and one quarter inches on center below the top of the grate, or pavement thickness, shall be placed on both sides of the scupper. If the holes are created after the molding process by punching, drilling or other mechanical means the holes shall be sealed using a compatible epoxy compound.

Grates

Grates shall be bicycle friendly and designed for HL-93 Live Load unless otherwise specified. Any gaps in grates shall have a maximum clear width of two inches. The minimum clear opening size in any grating shall be 1 1/8” by 1 1/8“. Grates shall be stainless steel (ASTM A955) or FRP specifically designed and meeting the HL-93 Live Load requirements.

- Steel grating shall be commercial heavy - duty grating with 1 1/2" x 5/16" bearing bars spaced at 2 3/8” and 3/8" diameter cross bars spaced at 2”. The grating shall be centered in the drain top. The bearing bars shall run parallel to traffic.
- FRP grating if used shall provide an opening area at least 75% of steel grating noted above. FRP gratings that do not meet this requirement are not acceptable and shall not be used.

Grates shall be designed so that they can be removed by mechanical means. Fasteners for grates shall be stainless. Where selected grates require orientation to flow, the grates will have orienting features included as required, i.e. for orders of paired drains one drain would have left hand orientation and the other right-hand orientation.

Grate Frames

Grate frames may be either integrated FRP composite or of stainless steel construction attached to the scupper/inlet body in a matter consistent with the physical design parameters.

Anchoring provisions
Scupper/inlet anchoring shall be bonded to the grate framing in a manner that provides a load path into the concrete decking. Anchor details to be specified as part of the shop drawings for the bridge drains and be a non-corrosive material.

Cross and Longitudinal Slope Compensation
The scupper/inlet designs shall provide a means to match the grate to the deck angles while maintaining the downspout in a plumb orientation. If purchased in pairs, one left handed version will be required for each right handed version. This may be achieved when a down spout portion is bonded to the scupper body, through the frame attachment to the scupper body.

FRP Composite Drain Sections
Bridge deck downspouts, bridge drain deck extensions, elbows and pipe for under drains shall be constructed using a circular cross section; however other cross sections are allowed with approval of the Fabrication Engineer. Drain sections shall comply with the material requirements set forth in Appendix A and maintain wall thickness of no less than 1/4 inch.

FRP Composite Deck Drain Extensions.
Down spout drain extensions shall be integrated and bonded directly to the scupper bodies.

Transitions through Connections and Components.
All transitions and joints to be manufactured through the use of smooth radius molds. Miter joint and edged transitions are not allowed. All internal joint connections are to be smooth and continuous.

Pigmented FRP Composite Drain Components
Pipes, fittings, bodies and all FRP composite drain system components shall be pigmented through the wall. The color used shall match the color of the beams unless otherwise allowed by the Fabrication Engineer. Paint, gel-coat or any other exterior coating shall not be accepted.

Joint Connections
Joints may be welded using manufacturer recommended adhesives in accordance to the adhesive manufacturer's application procedures. Adhesives must be compatible with the FRP resins, applied in a way that ensures complete bonding and liquid tight sealing of the resins, and be compatible with the environmental conditions such as temperature, freeze thaw conditions, and wet alkaline environments.

Shop Drawings/Inspection

Drawings The Contractor shall prepare shop detail, erection and other necessary working drawings in accordance with Section 105.7 - Working Drawings. Drawings shall include dimensions and tolerances necessary for manufacture and installation, all hardware, orienting features, anchor details, fastener details, gasket details, cross and longitudinal matching features, joint details, transition details, and material lay-up/composition

Notice of Beginning Work The Contractor shall give the Fabrication Engineer a minimum of two weeks notice before the beginning of work. No work shall be performed before the Fabrication Engineer has been notified. Before beginning work, a pre-fabrication meeting may be held at the discretion of the Fabrication Engineer or, if requested, by the Contractor.

The Contractor shall advise the Fabrication Engineer of the production schedule and any changes to it. If the Contractor suspends work on a project, the Fabrication Engineer will require 48 hours notice prior to the resumption of work.

Inspection Quality Control (Q.C.) is the responsibility of the Contractor. The Quality Control Inspector (Q.C.I.) shall inspect all aspects of the work and shall supervise all nondestructive examination (NDE). The Q.C.I. shall record measurements and test results in a clear and legible manner. The Q.C.I. shall reject materials and workmanship that do not meet contract requirements. The Contractor may perform NDE in addition to the minimum required. The results of all measurements and testing shall be made available to the Quality Assurance Inspector (Q.A.I.).

Quality Assurance (Q.A.) is the prerogative of the Fabrication Engineer. The Q.A.I. will ensure that the Q.C. Department is performing properly, verify documentation, periodically inspect workmanship and witness NDE. Q.A. testing deemed necessary by the Fabrication Engineer in addition to the minimum testing requirements shall be scheduled to minimize interference with the production schedule.

Inspector's Authority The Q.A.I. will have the authority to reject material or workmanship that does not meet the contract requirements. The acceptance of material or workmanship by the Q.A.I. will not prevent subsequent rejection, if found unacceptable.

Rejections Rejected material and workmanship shall be corrected or replaced by the Contractor.

Bill of Materials The Contractor shall provide the Fabrication Engineer with copies of all bills of materials used in the fabrication of the FRP bridge drains.

Packaging, Storage and Shipping of Components
FRP drains shall be stored and handled in accordance with the manufacturer's recommendation. The drains shall be stored above the ground and not be allowed to come into contact with seawater, mud, grease, dirt or other deleterious materials that may be present on the job site.

Installation
The Contractor shall install the FRP drains in accordance with the manufacturer's installation procedures, Contract Plans, and in accordance with the Contractor's installation drawings. FRP bridge drains will be accurately placed at the locations shown on the Plans or as authorized by the Resident. Adequate means shall be provided for securely holding the drains in place during placement of concrete. Any damaged drain shall be repaired or replaced at the Resident’s discretion and at no additional cost to the Department.

Method of Measurement
FRP Bridge Drains will be measured by the number of units, for fabrication and delivery. Installation for the drains will be incidental to the Structural Concrete Superstructure item.

Basis of Payment
FRP Bridge Drains will be paid for at the contract unit price. Such payment will include compensation for the fabrication and delivery of the drains in accordance with this specification.

Payment will be under:

Pay Item		Pay Unit
502.77	FRP Bridge Drain –Type X	Each

SPECIAL PROVISION
SECTION 502
STRUCTURAL CONCRETE
(Fiber Reinforced Polymer Bridge Drains)

APPENDIX A

A.1 Scope
This section specifies the material composition, properties, test requirements and reports that shall be submitted and approved prior to and after product certification of each FRP composite drain component type, e.g. scupper body or pipe component. The manufacturer is responsible for testing using an approved independent lab per section A.5.3. Once certified the approved product may be manufactured with only internal testing provided the manufacturing process and laminate composition do not change. Changes to process and or composition do require additional testing and product certification. The manufacturer shall report the individual test results per section A.5.3. If the strength is less than the required properties certification will not be granted.

A.2 Material/Laminate Composition

A.2.1 Fibers
Fiber sizings and coupling agents shall be compatible with the resin system used to impregnate them.

A.2.2 Matrix Resins
Commercial grades of vinyl ester and epoxy resin systems are permitted provided the finished product meets the material property requirements before and after durability conditioning as set forth in Section A. Styrene is permitted to be added to the polymer resin during processing. Added styrene shall be less than 10 percent by mass of the polymer resin. The amount of styrene, as a mass percentage of the polymer resin, added during processing shall be reported per Section A.5.3.

A.2.3 Fillers and Additives
Commercial grade inorganic fillers such as kaolin clay, calcium carbonate, and alumina tri-hydrate shall not exceed 20 percent by mass of the polymer resin constituent. Commercial grade additives and process-aids, such as release agents, low profile shrink additives, initiators, promoters, hardeners, catalysts, pigments, fire-retardants, and ultra-violet inhibitors are permitted and depend on the processing method. Shrink additives, if used, shall be less than 20 percent by mass of the polymer resin. Commercial grade inorganic or organic non-woven surfacing mats or veils are permitted.

A.2.4 Fiber Content

Fiber content shall be measured by ASTM D 3171 or ASTM D 2584. Fiber content shall be high enough to meet the mechanical property requirements of the FRP system laminate. The manufacturer shall report the fiber content of the end product by volume or by mass in accordance to the method used. If fiber content is not provided by the manufacturer, then the manufacturer shall provide material data sheets with the weight per unit area of the fiber reinforcement used to manufacture the part.

A.2.5 Glass Transition Temperature

The characteristic value of the glass transition temperature of the composite system, determined in accordance with ASTM E1640, shall be at least 40 degrees Fahrenheit higher than the maximum design temperature, $T_{MaxDesign}$, defined in section 3.12.2.2 of the AASHTO LRFD Guide Specifications for Design of Concrete-Filled FRP Tubes for Flexural and Axial Members, 2012. FRP drain systems may not be used in environments with a service temperature higher than the glass transition temperature of the resin used for their manufacturing.

A.2.6 Longitudinal and Transverse Coefficients of Thermal Expansion (CTE)

The coefficient of Thermal Expansion (CTE) of the tube may vary in the longitudinal and circumferential directions of the component depending on the laminate architecture and type of fibers and resins.

A.3 Mechanical Properties

A.3.1 Tensile Properties

The tensile strength, tensile modulus of elasticity, and ultimate tensile strain shall be determined for both the axial and hoop directions of the tubular components or in transverse and longitudinal directions of inlet bodies, see Section A.5.1 Test Samples. The tensile strength as reported by the manufacturer for product certification shall be measured according to ASTM Test Method D 3039, or other tension test method designed to determine tensile properties of composite laminates at the approved frequency and number of specimens as specified in section A.5.

A.3.4 Compressive Properties

The compressive strength and ultimate compressive strain shall be determined for the longitudinal directions of the tube laminate. The compressive strength and ultimate compressive strains shall be derived from specimens tested in accordance with ASTM Test Method D 6641, or other approved compression test method designed to determine compressive properties of the composite.

A.4 Durability Properties

Material properties shall retain 85% of their baseline values for the material properties listed in Section 2.3 after conditioning for all the durability tests listed below. Durability test methods are adopted from AASHTO Guide Specifications for Design of Bonded FRP Systems for Repair and Strengthening of Concrete Bridge Elements.

Durability property testing is only required for initial product certification and not required for subsequent production orders. The testing is the responsibility of the manufacturer and shall be conducted by an approved independent testing lab per section A.5.2.

A.4.1 Moisture Absorption

Samples will be immersed in distilled water having a temperature of 100 +/-3 degrees Fahrenheit and tested after 1,000 hours of exposure.

A.4.2 Resistance to Alkaline Environment

Samples will be immersed in a saturated solution of calcium hydroxide (pH-11) at ambient temperature of 73 +/-3 degrees Fahrenheit for 1,000 hours prior to testing. The pH level will be monitored and the solution will be maintained as needed.

A.4.3 Alternating Ultraviolet Light and Condensation Humidity

Samples will be conditioned in an apparatus under Cycle I-UV exposure condition according to ASTM G154 Standard Practice. Samples will be tested within two hours after removal from the apparatus.

A.4.4 Freeze-Thaw

Samples will be exposed to 100 repeated cycles of freezing and thawing in an apparatus meeting the requirements of ASTM C666.

A.5 Sampling, Testing & Results.

A.5.1 Test Samples.

The manufacturer is responsible for testing and may use samples in accordance to the test methods and needs of test equipment available. Test coupons may be cut from manufactured products or prepared using identical processes e.g. wet lay-up, vacuum infusion, etc. in a flat sheet, or witness plate, in which test coupons may be cut. Approval of the Fabrication Engineer shall be required for acceptance of test specimens produced by a different manufacturing method. Samples derived from special coupon test sheets shall be taken interior to edge sections 1.5x the width of the required coupon width. Samples shall be prepared from samples oriented with the directions illustrated in figures 1 and 2 for scupper body and drain pipes. For samples from filament wound pipes, samples shall be constructed over polygon mandrels allowing for flat panels to be removed for test purposes. Each test shall use a quantity of three samples. See Tables A.5.4 for tests, material requirements and sample breakdown.

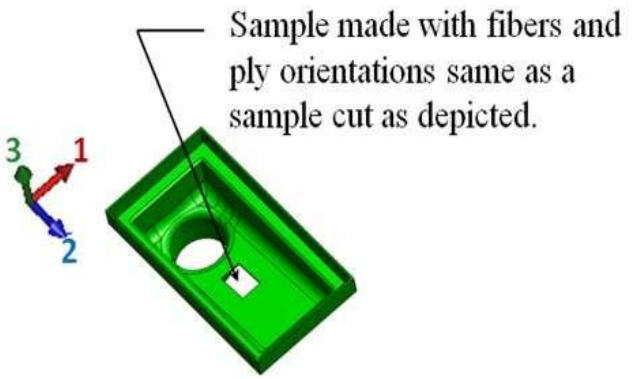


Figure 1.) Scupper Body Sample Orientations.

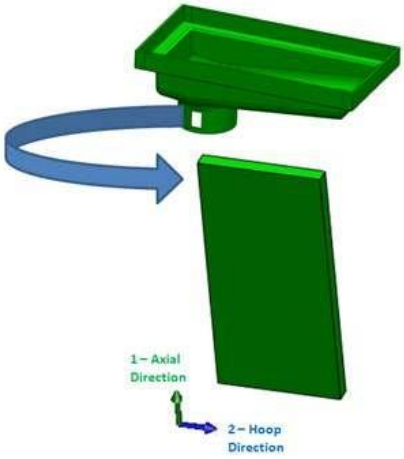


Figure 2.) Drain Pipe Sample Orientations.

A.5.2 Test Lab Requirements.
All testing of FRP material properties is being conducting in accordance to specified standards. Internal or external testing is to be conducted through laboratory facilities in accordance to ISO/IEC Guide 58, Calibration and Testing Laboratory Accreditation Systems - General Requirements for Operation and Recognition and ISO/IEC 17025 General Requirements for the Competence of testing and Calibration Laboratories as related by AASHTO document R18 "Recommended Practice for Establishing and Implementing a Quality System for Construction Materials Testing Laboratories."

A.5.3 Production Validation (PV) Testing.
Certification of materials used in FRP drain products must undergo PV testing of the specified material properties before and after environmental conditioning as set forth in Section A.5.4 by an independent lab. PV tests may be conducted internally by the manufacturer for development but are not acceptable for certification. Reported values for the material composition is be recorded and reported by the manufacturer, no independent audit is required.

A.5.4 Production Validation Sample Quantities, Minimum Material Properties and Reported Values
The following data shall be reported for material certification. Note that the tables shown use orientations related to FRP scupper or inlet bodies as set forth in Figure 1 of Section A.5.1. When evaluating tubular sections, orientation direction 2 as shown in Figure 2 of Section A.5.1 shall be substituted for orientation direction 3. The required number of samples have been reduced from ASTM requirements.

Table A.5.4.a PV reported material composition data. (Recorded by the manufacturer during the manufacturing process)

Section No.	Characteristic	Applicable Test Standard	Number of Samples	Tolerance	Reported
A.2.2	Styrene, mass percentage of polymer resin	per tolerance	N/A	10% max	
A.2.3	Inorganic fillers, mass percentage of polymer resin.	per tolerance	N/A	20% max	
	Shrink additives, mass percentage of polymer resin.	per tolerance	N/A	20% max	
A.2.4	Fiber Content	ASTM D3171 or ASTM D2584	3	Sufficient to meet mechanical properties	
A.2.5	Glass Transition Temperature	ASTM E1640	3	> Max Design Temperature	

Table A.5.4.b PV Reported Baseline Mechanical Properties

(Conducted by an independent laboratory. Samples as Manufactured w/o additional conditioning per Section A.3)

						Independent Lab Reported Values			
Section No.	Direction	Characteristic	Applicable Test Standard	No. of Samples	Minumum Allowable Values	Sample 1	Sample 2	Sample 3	Avg Value
A.3.1	1	Tensile Strength	ASTM D3039	3	10000 (psi)				
		Tensile Modulas of Elasticity			800000 (psi)				
		Ultimate Tensile Strain			0.003 in/ in				
	2	Tensile Strength		3	10000 (psi)				
		Tensile Modulas of Elasticity			800000 (psi)				
		Ultimate Tensile Strain			0.003 in/ in				
A.3.4	1	Compressive Strength	ASTM D6641	3	22000 (psi)				
		Ultimate Compressive Strain			0.003 in/ in				
	3	Compressive Strength		3	22000 (psi)				
		Ultimate Compressive Strain			0.003 in/ in				

Table A.5.4c PV Reported Mechanical Properties after 1000 hr. Moisture Immersion Condidtioning per Section A.4.1

(Conducted by an independent laboratory)

						Independent Lab Reported Values			
Section No.	Direction	Characteristic	Applicable Test Standard	No. of Samples	Minumum Allowable Values	Sample 1	Sample 2	Sample 3	Avg Value
A.3.1	1	Tensile Strength	ASTM D3039	3	8500 (psi)				
		Tensile Modulas of Elasticity			680000 (psi)				
		Ultimate Tensile Strain			0.0025 in/in				
	2	Tensile Strength		3	8500 (psi)				
		Tensile Modulas of Elasticity			680000 (psi)				
		Ultimate Tensile Strain			0.0025 in/in				
A.3.4	1	Compressive Strength	ASTM D6641	3	18700 (psi)				
		Ultimate Compressive Strain			0.0025 in/in				
	3	Compressive Strength		3	18700 (psi)				
		Ultimate Compressive Strain			0.0025 in/in				

Table A.5.4d PV Reported Mechanical Properties after 1000 hr. of Alkaline Environment Conditioning per Section A.4.2

(Conducted by an independent laboratory)

						Independent Lab Reported Values			
Section No.	Direction	Characteristic	Applicable Test Standard	No. of Samples	Minumum Allowable Values	Sample 1	Sample 2	Sample 3	Avg Value
A.3.1	1	Tensile Strength	ASTM D3039	3	8500 (psi)				
		Tensile Modulas of Elasticity			680000 (psi)				
		Ultimate Tensile Strain			0.0025 in/in				
	2	Tensile Strength		3	8500 (psi)				
		Tensile Modulas of Elasticity			680000 (psi)				
		Ultimate Tensile Strain			0.0025 in/in				
A.3.4	1	Compressive Strength	ASTM D6641	3	18700 (psi)				
		Ultimate Compressive Strain			0.0025 in/in				
	3	Compressive Strength		3	18700 (psi)				
		Ultimate Compressive Strain			0.0025 in/in				

Table A.5.4e PV Reported Mechanical Properties after UV Light Conditioning per Section A.4.3 (ASTM G154).

(Conducted by an independent laboratory)

						Independent Lab Reported Values			
Section No.	Direction	Characteristic	Applicable Test Standard	No. of Samples	Minumum Allowable Values	Sample 1	Sample 2	Sample 3	Avg Value
A.3.1	1	Tensile Strength	ASTM D3039	3	8500 (psi)				
		Tensile Modulas of Elasticity			680000 (psi)				
		Ultimate Tensile Strain			0.0025 in/in				
	2	Tensile Strength		3	8500 (psi)				
		Tensile Modulas of Elasticity			680000 (psi)				
		Ultimate Tensile Strain			0.0025 in/in				
A.3.4	1	Compressive Strength	ASTM D6641	3	18700 (psi)				
		Ultimate Compressive Strain			0.0025 in/in				
	3	Compressive Strength		3	18700 (psi)				
		Ultimate Compressive Strain			0.0025 in/in				

Table A.5.4f PV Reported Mechanical Properties after 100 Freeze-Thaw Cycle Conditioning per Section A.4.4 (ASTM C666).

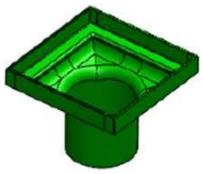
(Conducted by an independent laboratory)

						Independent Lab Reported Values			
Section No.	Direction	Characteristic	Applicable Test Standard	No. of Samples	Minumum Allowable Values	Sample 1	Sample 2	Sample 3	Avg Value
A.3.1	1	Tensile Strength	ASTM D3039	3	8500 (psi)				
		Tensile Modulas of Elasticity			680000 (psi)				
		Ultimate Tensile Strain			0.0025 in/in				
	2	Tensile Strength		3	8500 (psi)				
		Tensile Modulas of Elasticity			680000 (psi)				
		Ultimate Tensile Strain			0.0025 in/in				
A.3.4	1	Compressive Strength	ASTM D6641	3	18700 (psi)				
		Ultimate Compressive Strain			0.0025 in/in				
	3	Compressive Strength		3	18700 (psi)				
		Ultimate Compressive Strain			0.0025 in/in				

SPECIAL PROVISION
SECTION 502
STRUCTURAL CONCRETE
(Fiber Reinforced Polymer Bridge Drains)

APPENDIX B

Standard Details



Bridge Drain – Symmetric Inlet

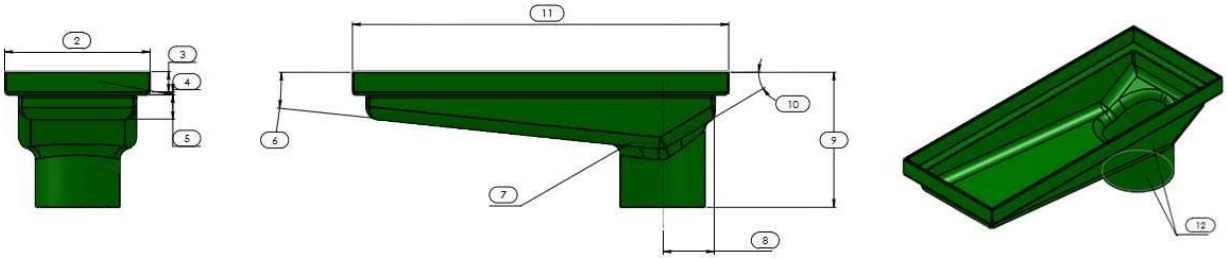
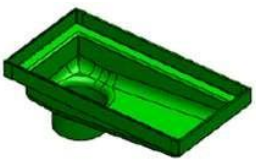


Table B1 Preferred Symmetric FRP Composite Inlet Bodies

	Size Designation	A	B	C		
	Size Dimensions (Grate Length x Width, Down Spout Diameter)	12x12xØ8	14x14xØ10	18x18xØ12		
Dimension		Nominal Dimensions			Nominal Design Tolerance	Manufacturing Tolerance
Number	Name					
1	Down Spout Inner Diameter	8"	10"	12"	min	+/- 0.015"
2	Grate Frame Width	12"	14"	18"	+/- 1"	+/- 0.025"
3	Grate Frame Height	As required to contain grate and recessed from deck surface				
4	Grate Frame Flange & Wall Thickness	0.25"	0.25"	0.25"	min	+/- 0.025"
5	Scupper Toe Depth	4"	4"	4"	+1"/-0"	+/- 0.1"
6	Scupper Toe Slope	1:10	1:10	1:10	min	+ 1 degree
7	Scupper Body Radii	2"	2"	2"	min	+0.1"
8	Down Spout Position to Heel	6"	6"	6"	+/- 0.5"	
9	Height	18"	18"	18"	Open	+/- 0.25"
10	Scupper Heel Slope	1:10	1:10	1:10	min	+0.1"
11	Grate Frame Length	12"	14"	18"	+/- 1"	+/- 0.025"
12	Scupper and Down Spout Wall Thickness	0.25"	0.25"	0.25"	min	+0.015"



Bridge Drain-Offset Scupper

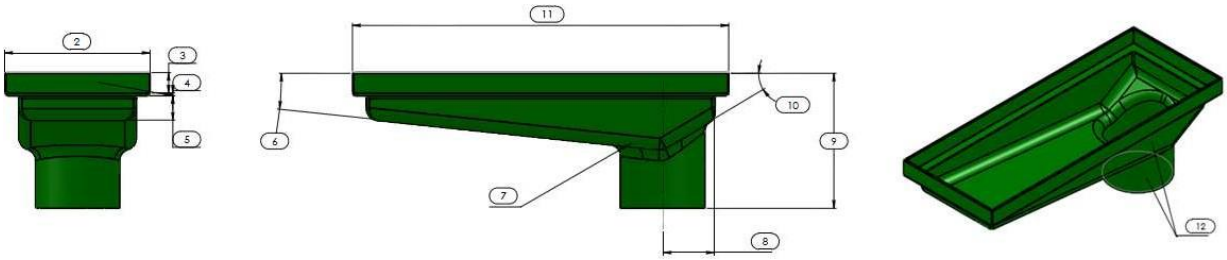


Table B2 Preferred Offset FRP Composite Scupper Bodies

	Size Designation	D	E	F	G		
	Size Dimensions (Grate Length x Width, Down Spout Diameter)	24x12xØ8	30x12xØ10	36x12xØ10	42x12xØ12		
Dimension		Nominal Dimensions				Nominal Design Tolerance	Manufacturing Tolerance
Number	Name						
1	Down Spout Inner Diameter	8"	10"	10"	12"	min	+/- 0.015"
2	Grate Frame Width	12"	12"	12"	12"	+ 2"/-0"	+/- 0.025"
3	Grate Frame Height	As required to contain grate and recessed from deck surface					
4	Grate Frame Flange & Wall Thickness	0.25"	0.25"	0.25"	0.25"	min	+/- 0.025"
5	Scupper Toe Depth	4"	4"	4"	4"	+1"/-0"	+/- 0.1"
6	Scupper Toe Slope	1:10	1:10	1:10	1:10	min	+ 1 degree
7	Scupper Body Radii	2"	2"	2"	2"	min	+0.1"
8	Down Spout Position to Heel	6"	6"	6"	6"	+/- 0.5"	
9	Height	13.5"	16"	18"	18"	Open	+/- 0.25"
10	Scupper Heel Slope	1:10	1:10	1:10	1:10	min	+0.1"
11	Grate Frame Length	24"	30"	36"	42"	+ 2"/-0"	+/- 0.025"
12	Scupper and Down Spout Wall Thickness	0.25"	0.25"	0.25"	0.25"	min	+0.015"