

Preparing Activity: NAVFAC

UNIFIED FACILITIES GUIDE SPECIFICATIONS

References are in agreement with UMRL dated 22 December 2004

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DIVISION 03 - CONCRETE

SECTION 03420N

CONCRETE FLOATING PIER FOR SMALL CRAFT

08/04

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Preparing Activity: NAVFAC

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SECTION 03420N

CONCRETE FLOATING PIER FOR SMALL CRAFT 08/04

NOTE: This guide specification covers the requirements for precast non-prestressed concrete floating piers and associated hardware and accessories.

Comments and suggestion on this specification are welcome and should be directed to the technical proponent of the specification. A listing of the technical proponents, including their organization designation and telephone number, is on the Internet.

Recommended changes to a UFGS should be submitted as a Criteria Change Request (CCR).

Use of electronic communication is encouraged.

Brackets are used in the text to indicate designer choices or locations where text must be supplied by the designer.

PART 1 GENERAL

1.1 REFERENCES

The publications listed below form a part of this specification to the extent referenced. The publications are referred to in the text by the basic designation only.

ACI INTERNATIONAL (ACI)

ACI 211.2	(1998) Standard Practice for Selecting Proportions for Structural Lightweight Concrete
ACI 304R	(2000) Guide for Measuring, Mixing, Transporting, and Placing Concrete
ACI 305R	(1999) Hot Weather Concreting
ACI 306.1	(1990; R 2002) Standard Specification for Cold Weather Concreting

ACI 309R	(1996) Guide for Consolidation of Concrete
ACI 318/318M	(2002) Building Code Requirements for Structural Concrete

AMERICAN WELDING SOCIETY (AWS)

AWS D1.4	(1998) Structural Welding Code - Reinforcing Steel
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AMERICAN WOOD-PRESERVERS' ASSOCIATION (AWPA)

AWPA C1	(2000) All Timber Products - Preservative Treatment by Pressure Processes
AWPA C18	(2003) Standard For Pressure Treated Material in Marine Construction
AWPA C2	(2001) Lumber, Timber, Bridge Ties and Mine Ties - Preservative Treatment by Pressure Processes
AWPA C28	(1999) Standard for Preservative Treatment of Structural Glued Laminated Members and Lamination Before Gluing of Southern Pine, Coastal Douglas Fir, Hemfir and Western Hemlock by Pressure Processes
AWPA C33	(2003) Standard for Preservative Treatment of Structural Composite Lumber by Pressure Processes
AWPA P5	(2002) Standard for Waterborne Preservatives

ASTM INTERNATIONAL (ASTM)

ASTM A 123/A 123M	(2002) Zinc (Hot-Dip Galvanized) Coatings on Iron and Steel Products
ASTM A 153/A 153M	(2004) Zinc Coating (Hot-Dip) on Iron and Steel Hardware
ASTM A 185	(2002) Steel Welded Wire Reinforcement, Plain, for Concrete
ASTM A 27/A 27M	(2003) Steel Castings, Carbon, for General Application
ASTM A 307	(2004) Carbon Steel Bolts and Studs, 60 000 PSI Tensile Strength
ASTM A 36/A 36M	(2004) Carbon Structural Steel
ASTM A 47/A 47M	(1999) Ferritic Malleable Iron Castings
ASTM A 497/A 497M	(2002) Steel Welded Wire Reinforcement, Deformed, for Concrete

ASTM A 563	(2004a) Carbon and Alloy Steel Nuts
ASTM A 563M	(2004) Carbon and Alloy Steel Nuts (Metric)
ASTM A 615/A 615M	(2004b) Deformed and Plain Billet-Steel Bars for Concrete Reinforcement
ASTM A 706/A 706M	(2004b) Low-Alloy Steel Deformed and Plain Bars for Concrete Reinforcement
ASTM A 780	(2001) Repair of Damaged and Uncoated Areas of Hot-Dipped Galvanized Coatings
ASTM C 1107	(2002) Packaged Dry, Hydraulic-Cement Grout (Nonshrink)
ASTM C 150	(2004a) Portland Cement
ASTM C 260	(2001) Air-Entraining Admixtures for Concrete
ASTM C 272	(2001) Water Absorption of Core Materials for Structural Sandwich Constructions
ASTM C 330	(2004) Lightweight Aggregates for Structural Concrete
ASTM C 494/C 494M	(2004) Chemical Admixtures for Concrete
ASTM C 578	(2004) Rigid, Cellular Polystyrene Thermal Insulation
ASTM C 595	(2003) Blended Hydraulic Cements
ASTM C 618	(2003) Coal Fly Ash and Raw or Calcined Natural Pozzolan for Use as a Mineral Admixture in Concrete
ASTM C 94/C 94M	(2004a) Ready-Mixed Concrete
ASTM C 989	(2004) Ground Granulated Blast-Furnace Slag for Use in Concrete and Mortars
ASTM D 1535	(2001) Specifying Color by the Munsell System
ASTM D 1894	(2001) Static and Kinetic Coefficients of Friction of Plastic Film and Sheet
ASTM D 2240	(2004) Rubber Property - Durometer Hardness
ASTM D 256	(2004) Determining the Izod Pendulum Impact Resistance of Plastics
ASTM D 4020	(2001a) Ultra-High-Molecular-Weight Polyethylene Molding and Extrusion Materials

ASTM D 5456	(2003) Evaluation of Structural Composite Lumber Products
ASTM D 570	(1998) Water Absorption of Plastics
ASTM D 638	(2003) Tensile Properties of Plastics
ASTM D 792	(2000) Density and Specific Gravity (Relative Density) of Plastics by Displacement
ASTM F 844	(2004) Washers, Steel, Plain (Flat), Unhardened for General Use
ASTM G 109	(1999; Rev. A) Determining the Effects of Chemical Admixtures on the Corrosion of Embedded Steel Reinforcement in Concrete Exposed to Chloride Environments E(2000)

EUROPEAN COMMITTEE FOR STANDARDIZATION (CEN)

EN 60309-1	(1999) Plugs, Socket-Outlets and Couplers for Industrial Purposes Part 1: General Requirements - IEC 60309-1
EN 60309-2	(1999) Plugs, Socket-Outlets and Couplers for Industrial Purposes Part 2: Dimensional Interchangeability Requirements for Pin and Contact-Tube Accessories - IEC 60309-2
EN 60529	(1997) Degrees of Protection Provided By Enclosures (IP Code)

NATIONAL ELECTRICAL MANUFACTURERS ASSOCIATION (NEMA)

NEMA C57.12.29	(1999; E 2000) Pad-Mounted Equipment - Enclosure Integrity for Coastal Environments
NEMA ICS 6	(1993; R 2001) Industrial Control and Systems: Enclosures

PRECAST/PRESTRESSED CONCRETE INSTITUTE (PCI)

PCI MNL-116	(1999) Quality Control for Plants and Production of Structural Precast Concrete Products
PCI MNL-120	(1999) Design Handbook - Precast and Prestressed Concrete

SOCIETY OF AUTOMOTIVE ENGINEERS INTERNATIONAL (SAE)

SAE AMS-QQ-A-200/8	(1997) Aluminum Alloy 6061, Bar, Rod, Shapes, Tube, and Wire, Extruded
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U.S. DEPARTMENT OF DEFENSE (DOD)

MIL-I-24768/14 (1992) INSULATION, PLASTIC, LAMINATED,
THERMOSETTING, COTTON-FABRIC-BASE,
PHENOLIC-RESIN (FBG)

U.S. GENERAL SERVICES ADMINISTRATION (GSA)

A-A-55619B (2003) Casters, Industrial, Heavy Duty

UNDERWRITERS LABORATORIES (UL)

UL 1686 (1998; R 2001) Pin and Sleeve
Configurations

UL 231 (1998; R 1999) Power Outlets

UL 489 (2002; Rev thru May 2003) Molded-Case
Circuit Breakers, Molded-Case Switches,
and Circuit-Breaker Enclosures

UL 943 (1993; Rev thru Feb 2004) Ground-Fault
Circuit-Interrupters

UL 98 (2004) Enclosed and Dead-Front Switches

1.2 MODIFICATIONS TO REFERENCES

In the ACI publications, the advisory provisions shall be considered to be mandatory, as though the word "shall" has been substituted for "should" wherever it appears; reference to the "Building Official," the "Structural Engineer" and the "Architect/Engineer" shall be interpreted to mean the Contracting Officer.

1.3 SUBMITTALS

NOTE: A "G" following a submittal item indicates that the submittal requires Government approval. Some submittals are already marked with a "G". Only delete an existing "G" if the submittal item is not complex and can be reviewed through the Contractor's Quality Control system. Only add a "G" if the submittal is sufficiently important or complex in context of the project.

For submittals requiring Government approval on Army projects, a code of up to three characters within the submittal tags may be used following the "G" designation to indicate the approving authority. Codes for Army projects using the Resident Management System (RMS) are: "AE" for Architect-Engineer; "DO" for District Office (Engineering Division or other organization in the District Office); "AO" for Area Office; "RO" for Resident Office; and "PO" for Project Office. Codes following the "G" typically are not used for Navy projects.

Submittal items not designated with a "G" are considered as being for information only for Army projects and for Contractor Quality Control approval for Navy projects.

Government approval is required for submittals with a "G" designation; submittals not having a "G" designation are [for Contractor Quality Control approval.] [for information only. When used, a designation following the "G" designation identifies the office that will review the submittal for the Government.] The following shall be submitted in accordance with Section 01330 SUBMITTAL PROCEDURES:

SD-02 Shop Drawings

Drawings of Precast Floats; G, [_____]

Gangways

[Receptacle Stations; G, [_____]
]

SD-03 Product Data

Anchorage and lifting inserts and devices

[Receptacle Stations; G, [_____]
]

Guide Pile Caps

SD-05 Design Data

Precast Concrete Floats Design Calculations; G, [_____]

Gangway Design

Concrete Mix Design

SD-06 Test Reports

Contractor-Furnished Mix Design

Submit copies of test reports showing that the mix has been successfully tested to produce concrete with the properties specified and will be suitable for the job conditions. Obtain approval before concrete placement.

SD-07 Certificates

Fabrication

Rubbing Surface

[Paint Coating System
]

Submit quality control procedures established in accordance with PCI MNL-116 by the precast manufacturer.

1.4 PRECAST FLOATS

The work includes the provision of precast, non-prestressed concrete floating pier modules herein referred to as precast floats, and all other items relating to the precast floating pier system. Precast floats shall be the product of a manufacturer specializing in the production of precast concrete floats with a minimum of 10 years experience in the manufacture of precast concrete floating piers.

1.5 QUALITY CONTROL

1.5.1 Precast Concrete Float Design

ACI 318/318M and the PCI MNL-120. Design precast floats (including connections) for the design load conditions and spans indicated, and for additional loads imposed by the work of other trades. Design precast floats for handling without cracking in accordance with the PCI MNL-120.

1.5.1.1 Pier Loading

Float and anchorage systems shall be designed for the following load conditions as a minimum. Load cases shall be combined based upon their probability of simultaneous occurrence, and in accordance with applicable codes and standards. Wind and current exposure areas shall be based on average vessel profile and draft, respectively. To account for sheltering effects, 15 percent of the full load shall be applied to all vessels sheltered by the vessels exposed to full load. Calculations shall be performed for wind and current loads both parallel and perpendicular to the pier.

NOTE: Designer should consult with a manufacturer of precast concrete floats to determine maximum allowable loadings for a given float size. The use of values exceeding the recommended default maximums should be confirmed with a reputable manufacturer prior to inclusion.

Environmental loadings (wind, wave, current & tide surge) will be site specific.

Default values for berthing and mooring loads are recommended maximum values, based on limitations of the precast modules. Berthing load is vessel and pier configuration specific. Mooring load is maximum, based on anchorage strength of (default) cleat size (confirm with manufacturer). The designer should input berthing and mooring loads based on the actual vessels berthed.

- a. Dead load, including all work of other trades (utilities, ect.)
- b. Live load: [____] [3.83] kPa [80 PSF]
- c. Wind pressure: As indicated on drawings
Acting on the projected area of the pier and moored vessels, assuming full occupancy. For vessel area, assume an average height of [____] m feet above the waterline.

- d. Minimum current pressure: [] kPa[PSF] [FPS velocity]
Acting on the projected area of the pier and moored vessels,
assuming normal occupancy.
- e. Berthing load: [] [136] N/m[100] PLF horizontal
- f. Mooring load: [] [1.78] kN[400] lb.
Line pull acting in any direction at a 45 degree angle from the
horizontal.
- g. Vertical wave load: As determined from a [] [0.9] m[3]
ft. wave height
- h. Lateral wave load: As determined from a [] [0.9] m[3]
ft. wave height
- i. Lateral pile loads
at maximum surge level: For surge level indicated on drawings

1.5.1.2 Performance

- a. Precast float modules shall be sized so that a single module
(excluding walers) is used to attain the indicated pier width.
The use of more than one module connected side by side to attain
pier width is unacceptable.
- b. Freeboard under dead load only shall not be less than [] 610mm24
in. nor exceed [] 762mm30 in. . Precast floats shall be
designed to float level under dead load only. Maximum out of
level tolerance for transverse and longitudinal slope is [] 25mm
per 3m1 in. per 10 ft. . Freeboard under dead and live load shall
not be less than [] 203mm8 in. .
- c. Special precast floats must be designed to support the additional
concentrated loads as imposed by gangways, transformers, or other
equipment. Modules with special loadings shall have the same
freeboard as standard modules without special loading, so that
there will be no residual stresses or tilting when modules are
interconnected.
- d. Flotation units shall be located within the structure so as to be
capable of supporting a [] 136 kg300 lb. moving point load in
any area without causing excessive rolling or tilting
of the pier. The pier shall be capable of supporting a [] 181 kg
400 lb. point load at 305mm1 Ft. from the offshore end of the pier
and loose no more than 101mm4 in. of freeboard; and supporting a
[] 136 kg300 lb. point load applied to the corner of the
offshore end of the pier and loose no more than 51mm2 in. of
freeboard differential per 914mm3 Ft. of pier width between the
offshore corners.
- [e. Precast floats shall have PVC sleeves and pull boxes embedded as
required for electrical and communications systems. Pull boxes
shall have a nominal 25mm1 in. concrete bottom with a light
brushed, slip resistant finish. All bolts and inserts for pull
box lids shall be 316 stainless steel. Pull box lids shall be
flush with the deck surface and rated for the pier deck loading.
Sleeves shall remain above water surface under dead load

conditions and shall be designed to facilitate installation, removal, and servicing of utilities. Pull boxes and access openings shall be sized and located as indicated on the drawings.

]

1.5.2 Gangway Design

Provide gangways of prefabricated aluminum for floating pier access, including connections at the bulkhead and bearing on the floating pier. Gangway shall be designed in accordance with "Specifications for Aluminum Structures", AA, latest edition, using allowable stresses for bridges.

1.5.2.1 Gangway Loading

Gangways shall be subject to the same load conditions identified in the paragraph titled "Pier Loading", except for berthing, mooring, current, wave, and pile loading conditions. Additionally, the gangway bulkhead end connections shall be designed to withstand a lateral force equal to 20 percent of the total dead load and 50 percent of the live load acting simultaneously with the dead and live loads. Handrails shall be designed for the following independent load cases: 1) a continuous horizontal load of 27.1 N/m20 PLF applied along the full length of the top rail, and 2) a horizontal point load of 113.4 kg250 lbs acting at any point along the top rail.

1.5.2.2 Performance

- a. Gangways shall have a minimum clear walkway width of [___]1.07m3.5 ft., and an overall outside width not to exceed [___]1.37m4.5 ft.. Length of gangways shall be as indicated on the drawings. Gangways shall have continuous handrails that are a minimum of 1.07m3.5 ft. above the walking surface, but not to exceed 1.14m 3.75 ft. .
- b. Walking surface shall be skid resistant.
- c. Gangway pier end connections shall allow unrestricted vertical movement through tidal variation. Gangway bearing on floating piers shall be fitted with UHMW polyurethane rollers of adequate bearing area. Gangways shall be fitted with hinged apron plates to assure a safe uniform transition between gangway and deck surfaces. Apron plates will be designed so as to not damage or mar the floating pier surface.
- d. Maximum midspan deflection under live load shall not exceed $L/240$.
- e. Contact between aluminum and dissimilar metals or concrete shall be avoided, except for the use of compatible stainless steel pins. Where potential for galvanic corrosion exists, the aluminum shall be isolated from direct contact with other metals or concrete by use of suitable non-conducting insulators or bushings.

1.5.2 PCI Quality Certifications

NOTE: For normal routine projects, use the first paragraph. For complex or large precast/prestressed projects, use the second paragraph. Note that use of the second paragraph may limit competition. Verify the availability of certified PCI precasters

in the bidding area.

PCI MNL-116. At the precast manufacturer's option, in lieu of core samples, ACI 318/318M, full scale load tests may be performed. Perform on randomly selected precast floats, as directed by the Contracting Officer.

[1.5.2.1 Product Quality Control

PCI MNL-116 for PCI enrolled plants. Where precast floats are manufactured by specialists in plants not currently enrolled in the PCI "Quality Control Program," provide a product quality control system in accordance with PCI MNL-116 and perform concrete and aggregate quality control testing using an approved, independent commercial testing laboratory. Submit test results to the Contracting Officer.

]1.6 DELIVERY AND STORAGE

Lift and support precast floats at the lifting and supporting points indicated on the shop drawings. Store precast floats off the ground. Separate stacked precast floats by battens across the full width of each bearing point. Protect from weather, marring, damage, and overload.

1.7 FACTORY INSPECTION

At the option of the Contracting Officer, precast floats shall be inspected by the QC Representative prior to being transported to the job site. The Contractor shall give notice 14 days prior to the time the units will be available for plant inspection. Neither the exercise nor waiver of inspection at the plant will affect the Government's right to enforce contractual provisions after units are transported or erected.

1.8 QUALITY ASSURANCE

1.8.1 Drawing Information

Submit drawings indicating complete information for the fabrication, handling, and erection of the precast floats and gangways. Drawings shall not be reproductions of contract drawings. Design drawings of precast floats and gangways (including connections) shall be prepared and sealed by a registered professional engineer, and submitted for approval prior to fabrication. The drawings shall indicate, as a minimum, the following information:

- a. Floating pier system layout
- b. Marking of floats for assembly
- c. Connections between floats, and connections between floats and other construction
- d. Location and anchorage of mooring fittings
- e. Waler size and splice pattern
- f. Guide pile size, length, location and connection to pier
- g. Reinforcing details

- h. Material properties of all materials used
- i. Lifting and assembly inserts and embedded items
- j. Dimensions and surface finishes of each float
- k. Erection sequence and handling requirements
- l. All loads used in design (such as live, dead, wind, current, berthing, handling, and erection)
- m. Bracing/shoring required
- n. Gangways
- [o. Utility routing and connections for work of other trades
-]

1.8.2 Design Calculations

Submit calculations reflecting design conforming to requirements of paragraph entitled "Precast Concrete Float Design" and "Gangway Design". Design calculations of precast floats and gangways (including connections) shall be prepared and sealed by a registered professional engineer, and submitted for approval prior to fabrication. In addition to member sizing calculations, submit calculations for the pier system which include:

- a. Anchorage attachment points to insure reactions shall be appropriately and rationally distributed throughout the system
- b. Overall system loads under full occupancy, with consideration for shielding factors, and deflection of the system and its effects on anchor loading
- c. Anchorage system capacity for individual and overall load considerations
- d. Guide pile size, length, cross section, and minimum embedment

1.8.3 Concrete Mix Design

Thirty days minimum prior to concrete placement, submit a mix design for each strength and type of concrete. Include a complete list of materials including type; brand; source and amount of cement, pozzolan, and admixtures; and applicable reference specifications.

[1.8.4 Paint Coating System

Submit NEMA C57.12.29 coating system performance requirements test on "test specimens" of the same material used in fabrication of the receptacle stations.

] PART 2 PRODUCTS

2.1 CONTRACTOR-FURNISHED MIX DESIGN

NOTE: Normal precast design is based on concrete having a compressive strength of 35 MPa 5000 psi at 28 days. Some precast manufacturers like to speed

up production by using Type III (high early strength) concrete.

NOTE: Delete air entraining requirements when the project is located in a nonfreezing climate.

ACI 211.2, using weight method. The minimum compressive strength of concrete at 28 days shall be [____] [35] MPa[5000] psi with a unit weight of 1800 kg/m³115 pcf dry .Mix shall contain a corrosion inhibitor[and air-entraining admixtures at the mixer to produce between 5 to 7 percent air by volume]. The use of foaming agents is prohibited.

2.2 PRECAST FLOAT MATERIALS

2.2.1 Cement

NOTE: For normal precasting (not requiring sulfate resistance), use the first bracketed item. If sulfate resistance is required, use the second bracketed item.

ASTM C 150, Type [I][II]; or ASTM C 595 Type IP(MS) or IS(MS) blended cement, except as modified herein. The blended cement shall consist of a mixture of ASTM C 150 cement and one of the following materials: ASTM C 618 pozzolan or fly ash, or ASTM C 989 ground iron blast furnace slag. The pozzolan/fly ash content shall not be less than 20 percent nor exceed 40 percent by total mass of cementitious material. The content of ground granulated blast-furnace slag shall not exceed 50 percent of the mass of cement. The minimum amount of portland cement is 50 percent of the total mass of cementitious material. For exposed concrete, use one manufacturer for each type of cement, ground slag, fly ash, and pozzolan.

2.2.1.1 Fly Ash and Pozzolan

ASTM C 618, Type N, F, or C, except that the maximum allowable loss on ignition shall be 6 percent for Type N and F.

2.2.1.2 Ground Iron Blast-Furnace Slag

ASTM C 989, Grade 100 or 120.

2.2.2 Water

Water shall be fresh, clean, and potable.

2.2.3 Aggregates

2.2.3.1 Aggregates Selection

NOTE: Select gradation(s) based on job requirements and constraints. The maximum aggregate size shall not exceed three-quarters the minimum cover over reinforcing. Aggregate grading sizes with their

general grading ranges are as follows: Size 57 (25 mm one inch to No. 4 sieve), Size 67 (20 mm 3/4 inch to No. 4 sieve), and Size 7 (12 mm 1/2 inch to No. 4 sieve).

ASTM C 330, Size 8 (3/8 inch), except as modified herein. Obtain aggregates for exposed concrete surfaces from one source. Aggregates shall not contain any substance which may be deleteriously reactive with the alkalis in the cement.

2.2.4 Grout

2.2.4.1 Nonshrink Grout

ASTM C 1107.

2.2.4.2 Cementitious Grout

NOTE: Delete air entraining requirements when the project is located in a nonfreezing climate.

Shall be a mixture of portland cement, sand, and water. Proportion one part cement to approximately 2.5 parts sand, with the amount of water based on placement method. [Provide air entrainment for grout exposed to the weather.]

2.2.5 Admixtures

[2.2.5.1 Air-Entraining

NOTE: Delete air entraining requirements when the project is located in a nonfreezing climate.

ASTM C 260.

]2.2.5.2 Accelerating

ASTM C 494/C 494M, Type C or E.

2.2.5.3 Water Reducing

ASTM C 494/C 494M, Type A, E, or F.

2.2.5.4 Corrosion Inhibitor

Calcium nitrite, ASTM G 109. Add at the rate of 22.25 l per cubic meter 4.5 gallons per cubic yard.

2.2.6 Reinforcement

All reinforcement shall be hot-dipped galvanized, ASTM A 123/A 123M or ASTM A 153/A 153M.

2.2.6.1 Reinforcing Bars

NOTE: Specify ASTM A 706/A 706M reinforcing where
welding or bending of reinforcement bars is
important.

ASTM A 615/A 615M [ASTM A 706/A 706M], Grade 420 [40] [60].

2.2.6.2 Welded Wire Fabric

ASTM A 185 or ASTM A 497/A 497M. Provide flat sheets of welded wire fabric, rolled fabric is not acceptable. Maximum fabric grid is 50mm x 50mm (2 in. x 2 in.).

2.2.7 Metal Accessories

Provide ASTM A 123/A 123M or ASTM A 153/A 153M, hot-dipped galvanized.

2.2.7.1 Inserts

ASTM A 47/A 47M, Grade 22010 32510 or 35018, or ASTM A 27/A 27M Grade 415-205 U-60-30.

2.2.7.2 Structural Steel

ASTM A 36/A 36M.

2.2.7.3 Bolts

ASTM A 307 and ASTM A 36/A 36M. Waler rods shall be continuous laterally through the pier, with a minimum diameter of 19 mm^{3/4} inch. All continuous waler rods shall be placed within PVC sleeves cast into the precast float modules.

2.2.7.4 Nuts

ASTM A 563MASTM A 563.

2.2.7.5 Washers

ASTM F 844 washers for ASTM A 307 bolts.

2.2.7.6 Cleats

Provide [___]457 mm18 in. boat cleats spaced at approximately [___]6100 mm 20 ft. .

2.2.8 Foam Core

Closed cell, expanded polystyrene (EPS), ASTM C 578. Foam core laminations shall be glued with a low solvent glue. Core shall not be made from more than four laminated sections. Horizontal laminations in the upper 254mm10 in. are not permitted. Core shall be strapped to prevent de-lamination during transportation and handling. Core shall not contain more than 10 percent reground EPS foam material. Reground foam pieces shall not exceed 10mm^{3/8} in. diameter.

Unit Weight:	70.1 - 155.7 kg/m ³ 0.9 - 2.0 PCF
Water absorption (ASTM C 272):	3 percent (by volume)
Dimensional tolerance:	+/- 3mm 1/8 in.

2.3 FABRICATION

PCI MNL-116 unless specified otherwise.

2.3.1 Precast Floats

Precast floats shall be cast monolithically, cold joints of any type are not acceptable. Modules shall have a minimum deck and wall thickness of 51mm 2 in. . Precast float decks shall be constructed to drain freely and there shall be no floodable enclosed spaces.

2.3.1 Forms

Brace forms to prevent deformation. Forms shall produce a smooth, dense surface. Chamfer exposed edges of floats 13 mm 1/2 inch, unless otherwise indicated. Form tolerance shall not exceed 3mm 1/8 in. dimensions indicated on shop drawings. When measured diagonally, floats more than 13mm 1/2 in. out of square shall be rejected.

2.3.2 Reinforcement Placement

ACI 318/318M for placement and splicing. Reinforcement may be preassembled before placement in forms.

2.3.3 Concrete

2.3.3.1 Concrete Mixing

ASTM C 94/C 94M. Mixing operations shall produce batch-to-batch uniformity of strength, consistency, and appearance.

2.3.3.2 Concrete Placing

ACI 304R, ACI 305R for hot weather concreting , ACI 306.1 for cold weather concreting, and ACI 309R, unless otherwise specified. Concrete shall be vibrated internally and/or externally to assure a smooth, dense finish.

2.3.3.3 Concrete Curing

Commence curing immediately following the initial set and completion of surface finishing. Provide curing procedures to keep the temperature of the concrete between 10 and 90 degrees C 50 and 190 degrees F. When accelerated curing is used, apply heat at controlled rate and uniformly along the casting beds. Monitor temperatures at various points in a product line in different casts. Cure for a minimum of seven days prior to transporting, launching and assembly.

2.3.4 Surface Finish

Precast floats containing hairline cracks which are visible and are less than 0.5 mm 0.02 inches in width, may be accepted, except that cracks larger than 0.1 mm 0.005 inches in width for surfaces exposed to the weather shall be repaired. Precast floats which contain cracks greater than

0.5 mm 0.02 inches in width shall be approved by the Contracting Officer, prior to being repaired. Any precast float that is structurally impaired or contains honeycombed section deep enough to expose reinforcing shall be rejected.

2.3.4.1 Unformed Surfaces

Provide a steel troweled and broomed finish for pier deck surface. Slip resistant broomed deck finish shall be transverse to pier orientation. All deck edges shall have a 10mm3/8 in. tooled radius with a minimum 38mm1 1/2 in. wide, smooth, hard steel finished face.

2.3.4.2 Formed Surfaces

NOTE: PCI MNL-116 different grades of formed surface finishes:

Commercial Grade: Concrete produced in forms that produce a rough finish. Fins are removed and large surface blemishes filled. Sharp edges that will be visible in the finished structure are ground down.

Standard Grade: Same finish as commercial grade, except the forms do not produce a texture on the concrete. Surface can be painted, but will have surface voids.

Finish Grade B: Same as standard grade, except all surface blemishes should be filled or finished to provide a smooth surface or uniform appearance if painted.

Finish Grade A: Same as Finish Grade B, except that the components of the completed structure, where exposed, shall be reasonably color matched. This finish is difficult to obtain.

PCI MNL-116 (Appendix A - Commentary), Chapter 3, for grades of surface finishes. Provide a standard grade surface finish for both exposed and unexposed areas.

2.3.5 Float Identification

All precast floats are to be clearly identified on one side and one end, between the bottom of the waler and the waterline. Identification shall include name of manufacturer, date of manufacture, specific float type, and job number.

2.4 TIMBER AND WOOD PRODUCTS

All walers shall be fabricated from parallel strand lumber (PSL) engineered structural beams. PSL structural beams shall be in accordance with ASTM D 5456 All other structural lumber shall be No. 1 Southern Yellow Pine.

2.4.1 Preservative Treatment

Treat wood to be used in contact with salt water or salt water splash in accordance with AWPAC C2 (Material Subject to Marine Borer Exposure) with waterborne preservative AWPAC P5, (ACA - Ammoniacal Copper Arsenate, ACZA - Ammoniacal Copper Zinc Arsenate, CCA - Chromated Copper Arsenate) to 0.6 pcf retention. For wood continuously immersed, treat in accordance with AWPAC C1 and AWPAC C18 as applicable, to 2.5 pcf retention. For glue laminated engineered structural beams treat in accordance with AWPAC C28 and AWPAC C33 as applicable

2.5 RUBBING SURFACE - ULTRA-HIGH MOLECULAR WEIGHT POLYETHYLENE (UHMWPE)

Materials including additives shall be traceable by original lot number. Materials used shall be FDA approved or otherwise harmless to marine life. Fabricated form shall be from virgin resin.

2.5.1 Resin

ASTM D 4020. Virgin resin shall be homopolymer of ethylene and have an intrinsic viscosity (IV) between 22.0 and 28.0 dl/g. No reprocessed resin shall be used. Resin shall be oil and moisture free (0.2 percent weight maximum).

2.5.2 Composition and Fabricated Form

Resin shall comprise a minimum 95.0 percent by weight concentration in the formulation. The finished form shall maintain ultraviolet stability for a minimum of 25 years and be free of saltwater or petroleum product leachable materials. No unfused areas or light patches greater than 300 micrometers No. 50 sieve shall be in the final fabricated form. Form shall be 38mm 1 1/2 in. thick, depth equal to design depth of waler, and length as required but not less than 3m 10 ft. . Exterior edges shall be rounded to 19mm 3/4 in. radius. Color shall be black. The fabricated form shall have the following properties:

Density (ASTM D 792)	0.92-0.94 g/cc
Tensile Strength (ASTM D 638)	
Ultimate, minimum	31.7 MPa
Ultimate Elongation, minimum	250 percent
Impact Strength (ASTM D 256)	
Test Method A, Izod	Non-break for all five determinations in sample
Hardness (ASTM D 2240), minimum	Shore D 65
Coefficient of Friction (ASTM D 1894)	
Kinetic, maximum	0.13
Static, maximum	0.20
Water Absorption (ASTM D 570)	Nil
Abrasion Index (relative to steel = 100), maximum	10
Density (ASTM D 792)	57.5-58.7 lb/cu.ft
Tensile Strength (ASTM D 638)	
Ultimate, minimum	4600 psi
Ultimate Elongation, minimum	250 percent
Impact Strength (ASTM D 256)	
Test Method A, Izod	Non-break for all five determinations in sample
Hardness (ASTM D 2240), minimum	Shore D 65

Coefficient of Friction (ASTM D 1894)		
Kinetic, maximum		0.13
Static, maximum		0.20
Water Absorption (ASTM D 570)		Nil
Abrasion Index (relative to steel = 100), maximum		10

2.6 GUIDE PILES

Guide piles shall be prestressed concrete piles; fabricated and installed in accordance with section 02456N PRESTRESSED CONCRETE PILES. Pile size, length, cross section and embedment shall be determined by pier manufacturer's design. [Recommended pile butt elevation is [] [5.0] ft. [1.5] m above [extreme] high water.] Pile quantity and location shall be as indicated on the drawings. Relocation of pile layout and additional piles required by the manufacturer's design to resist the indicated design loads, shall be subject to approval by the government.

2.6.1 Guide Pile Caps

Provide heavy UV-resistant, low density polyethylene piling caps with an estimated life in excess of 10 years. Caps shall be cone or pyramid shaped and attached to the piling top with stainless fasteners.

2.7 GANGWAYS

2.7.1 Aluminum

Aluminum alloy shall be 6061-T6. Extruded in accordance with the applicable requirements of SAE AMS-QQ-A-200/8.

2.7.2 Stainless Steel

Type 316 L.

2.7.3 Castings

F-214 Cast aluminum. Castings shall be true to pattern, structurally sound and free from blow holes or other defects.

2.7.4 Insulators

MIL-I-24768/14. Bushings or separation sheets shall be a minimum of 1.5mm 1/16 in. thickness.

2.7.5 Rollers

A-A-55619B, UHMW polyurethane, with UV inhibitors added. Color shall be black.

[2.8 Receptacle Stations

Receptacle stations shall include enclosure, mechanical interlocks, and related wiring and devices as indicated.

2.8.1 Enclosure

Enclosure shall be NEMA ICS 6, type 3R, fabricated of 12 gauge stainless steel. Paint ASTM D 1535 light gray No. 61. Paint coating system shall

comply with NEMA C57.12.29.

2.8.2 Mechanical Interlocks

UL 231, UL 1686, UL 98. Mechanical interlock devices shall incorporate a fused disconnect safety switch and IEC receptacle in a non-metallic, watertight, enclosure. The interlock mechanism shall prevent making and breaking of power under load. Enclosure shall be rated NEMA 4X and also rated IP67 in accordance with EN 60529. Include matching plug for each mechanical interlock provided. Plugs and receptacles shall be classified to EN 60309-1 and EN 60309-2.

2.8.3 Circuit Breakers

UL 489. Individual molded case circuit breakers with voltage and continuous current ratings, number of poles, overload trip setting, and short circuit current interrupting rating as indicated.

2.8.4 Ground-Fault Circuit Interrupter Receptacles

NOTE: For LANTNAVFACENGCOM projects, use GFI terminology in lieu of GFCI. NAVFACENGCOM has established these GFCI/GFI safety standards at a higher level of protection than NFPA 70's minimum requirements as a result of a GAO report and DOD concern about health and safety.

UL 943, duplex type for mounting in standard outlet box. Device shall be capable of detecting current leak of 6 milliamperes or greater and tripping per requirements of UL 943 for Class A GFI devices. Provide screw-type, side-wired wiring terminals or pre-wired (pigtail) leads. Provide in nonmetallic box with gasketed, weatherproof, nonmetallic cover plate and gasketed cap over each receptacle opening. Provide caps with a spring-hinged flap. Receptacle shall be UL listed for use in "wet locations with plug in use."

]PART 3 EXECUTION

3.1 SURFACE REPAIR

Prior to erection, and again after installation, precast floats shall be checked for damage, such as cracking, spalling, and honeycombing. As directed by the Contracting Officer, precast floats that do not meet the surface finish requirements specified in Part 2 in paragraph entitled "Surface Finish" shall be repaired, or removed and replaced with new precast floats.

3.2 LAUNCH AND ASSEMBLY

Precast floats shall be launched after the concrete has attained the specified compressive strength, unless otherwise approved by the precast manufacturer. Assemble in accordance with the approved shop drawings. PCI MNL-116 and PCI MNL-120 (Chapter 8), for tolerances. Brace precast floats, unless design calculations submitted with the shop drawings indicate bracing is not required. Follow the manufacturer's recommendations for maximum construction loads.

3.4 ANCHORAGE

Provide anchorage for fastening work in place. Conceal fasteners where practicable. Make threaded connections up tight and nick threads to prevent loosening.

3.5 WELDING

AWS D1.4 for welding connections and reinforcing splices. Protect the concrete and other reinforcing from heat during welding. Weld continuously along the entire area of contact. Grind smooth visible welds in the finished installation. Welding of epoxy-coated reinforcing is not allowed.

3.6 OPENINGS

Holes or cuts requiring reinforcing to be cut, which are not indicated on the approved shop drawing, shall only be made with the approval of the Contracting Officer and the precast manufacturer. Drill holes less than 300 mm 12 inches in diameter with a diamond tipped core drill.

3.7 GALVANIZING REPAIR

Repair damage to galvanized coatings using ASTM A 780 zinc rich paint for galvanized surfaces damaged by handling, transporting, cutting, welding, bolting, or acid washing. Do not heat surfaces to which repair paint has been applied.

3.8 GROUTING

Clean and fill indicated areas, solidly with nonshrink grout or cementitious grout. Provide reinforcing where indicated. Remove excess grout before hardening.

3.9 SEALANTS

Provide as indicated and as specified in Section 07920 JOINT SEALANTS.

-- End of Section --