### Notes

**Materials and Specifications**

1. Steel plate and extrusion shall conform to AASHTO M270, Grade 36, and shall be galvanized in accordance with AASHTO M123.
2. Strip seals shall conform to ASTM D-5973 and shall be furnished and installed in one continuous piece.
3. Welding shall be done according to current AASHTO specifications.

**Fabrication**

4. Shop drawings shall be submitted to the engineer electronically in PDF format in accordance with Section 504 and shall include complete dimensions and details of fabrication including an erection diagram. Materials being used shall be clearly specified. Before project completion, the contractor shall furnish the engineer electronic as-built shop drawings in PDF format.
5. Due to the length of steel extrusions and the joint profile, partial penetration groove weld shop splices will be permitted. No weld shall be permitted in the internal section of the steel extrusion where the neoprene strip seal is located.
6. The strip seal shall be the location of all splices, the final line and grade of the joint, all necessary welding information, and the method of support during the field work.
7. The line and grade of the joint shall conform to that shown on this sheet. The elevation of the points shown in the joint profile detail may vary no more than 0.02 feet from the values shown.
8. When the joint angles exceed 60° in length, a maximum of two partial penetration groove weld field splices shall be permitted. The field splice shall not be located in the wheel path, and the location shall be shown on the shop drawings.

**Installation**

9. Setting of the joint system shall be as recommended by the manufacturer.
10. Neoprene extrusion shall be bonded to the steel extrusion with an elastic adhesive as recommended by the joint manufacturer. The adhesive shall meet the requirements of ASTM D-4070-B1.
11. The expansion joint shall be adjusted for every 10° F change in temperature from the median temperature of 60° F at the time of installation of the joint.
12. After the joint system is installed, the joint area shall be flooded with water and inspected from below the joint for leakage. If leakage is observed, the joint system shall be repaired at the expense of the manufacturer and approved by the engineer.
13. The completed joint assembly, including all components and subassemblies, shall be fabricated by one manufacturer.

### Table of Elevations

<table>
<thead>
<tr>
<th>Location</th>
<th>Elevation</th>
<th>Angle A</th>
<th>Angle B</th>
</tr>
</thead>
<tbody>
<tr>
<td>HORIZONTAL BEND LEFT SIDE</td>
<td>2'-4&quot; from outside of parapet</td>
<td>1.335&quot; to 1.50&quot;</td>
<td>1.00&quot; to 1.06&quot;</td>
</tr>
<tr>
<td>HORIZONTAL BEND RIGHT SIDE</td>
<td>2'-4&quot; from outside of parapet</td>
<td>1.335&quot; to 1.50&quot;</td>
<td>1.00&quot; to 1.06&quot;</td>
</tr>
</tbody>
</table>

### Recommended Manufacturers of the Shown Joint Assembly

<table>
<thead>
<tr>
<th>Location</th>
<th>Manufacturer</th>
<th>Style</th>
<th>Installation Width Normal to Joint</th>
<th>Extrusion Type</th>
</tr>
</thead>
<tbody>
<tr>
<td>WATER BOWMAN ACME</td>
<td>D.S. BROWN</td>
<td>*</td>
<td>vary by manufacturer</td>
<td>vary by manufacturer</td>
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<tr>
<td>TECHSTAR</td>
<td></td>
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</tbody>
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* or approved equal.