

Appendix II

Calibration of Magnetic Particle Equipment every 6 months (1 point)			
Shop Laydown per AWS, 863, and AASHTO: Check Point 13			
check hole patterns, size, spacing, gage, accuracy, 863.20 (2 point)			
Check hole deburring, 863.20 (1 point)			
Check blocking horizontal & vertical dimensions @ bearings, after all welding is complete. (document) 1/8" + or - 863.12 (document separately) (5 point)			
Check blocking camber dimensions @ points specified, after all welding is complete 863.12 (document separately) (5 point)			
Check sweep or horizontal curvature, after all welding is complete 1/8"/10'-0" AWS 3.5 (document separately) (2 point)			
Check fitup at bolted splice, 1/4" max gap 863.17 (2 point)			
Check center to center of bearings matches plan dimensions (1 point)			
Check flatness at bearing seats, after all welding is complete AWS 3.5.1.9 (2 point)			
Cleaning per 863, SSPC and ASTM: Check Point 14			
Shop solvent cleaning per SSPC-SP1 (5 point)			
Shop grinding edges 1/16", material thicker than 1 1/2" shall be checked for removal of the heat hardened zone. (1 point)			
Shop blast cleaned SSPC-SP10, <u>Automated process</u> : Five(5) each recorded readings at random locations for each beam and One(1) recorded reading for 10% of all secondary material with replica tape ASTM D4417 method C, 1.5 to 3.5 mil profile (10 point)			
Shop blast cleaned SSPC-SP10, <u>Manual process</u> : Twenty(20) each recorded readings at random locations for each beam and Ten(10) recorded reading for 10% of all secondary material with replica tape ASTM D4417 method C, 1.5 to 3.5 mil profile (10 point)			
Steel Ambient (Dry bulb) and Wet bulb Temperatures, Humidity and Dew Point recorded prior to blasting and at the start of each shift (5 degree F above dew point). (2 point)			
Document abrasive mix (shot % & grit %) and sizes (1 point)			
Check abrasive mix for oil contamination start of each shift (1 point)			
Removal of abrasives & residue by vacuum or double blowing (5 point)			

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Test blow air for oil or other contaminants. Blotter test for 30 seconds at the start of each shift. Not required with vacuum (1 point)			
Conditioning all fins slivers and burred or sharp edges ASTM A6 then reblast to 1.5 to 3.5 mil profile. (1 point)			
Painting per 863, SSPC and ASTM: Hold or Check Point 15			
Record time and dates between blasting and painting (1 point)			
Record ambient temperature & humidity (minimum 50 deg.F and 5 deg F above dew point) (1 point)			
Record temperature of paint storage location (max/ min) (1 point)			
Record Paint TE-24, manufactures name and lot numbers (1 point)			
Mix paint (high shear mixer) and strain (5 point)			
Check operation of automated agitation system every 30 min. (5 point)			
Check prime inside of bolt holes, behind stiffener clips (5 point)			
Record prime thickness 3 to 5 mils: 3 gage readings for each spot measurement with 5 spot measurements in each 100 square foot (see additional instructions with paint system notes) (10 point)			
Check of workman like finish; mudcracking, holidays, pores, runs or sags. (5 point)			
Check prime has dried sufficiently prior to handling (1 point)			
Final Shop, Shipping or Storage, QA Inspection: Hold Point 16			

Y = Yes, N = No, NA = Not Applicable, No partial points are available for a Y, N or NA answer

Sum of {Y/(Y + N) x Section %}

Check Point 1	_____ (Y) / _____ (Y + N)*	X 7 = _____
Check Point 2	_____ (Y) / _____ (Y + N)	X 2 = _____
Check Point 3	_____ (Y) / _____ (Y + N)	X 5 = _____
Check Point 4	_____ (Y) / _____ (Y + N)	X 2 = _____
Check Point 5	_____ (Y) / _____ (Y + N)*	X 7 = _____
Check Point 6	_____ (Y) / _____ (Y + N)*	X 7 = _____
Check Point 7	_____ (Y) / _____ (Y + N)*	X 7 = _____
Check Point 8	_____ (Y) / _____ (Y + N)	X 2 = _____
Check Point 9	_____ (Y) / _____ (Y + N)*	X 2 = _____
Check Point 10	_____ (Y) / _____ (Y + N)*	X 15 = _____
Check Point 11	_____ (Y) / _____ (Y + N)*	X 15 = _____
Check Point 12	_____ (Y) / _____ (Y + N)	X 15 = _____