

**4C15 INSTALLATION PROCEDURE:**

- 1) LAYOUT EACH TENDON ANCHORAGE AND DUCT LOCATION ACCORDING TO THE SPACING SHOWN ON THE TENDON LAYOUT PLANS.
- 2) BOLT THE ANCHORAGE TRUMPLATE SECURELY AND PERPENDICULAR TO THE BLOCK-OUT FORM.
- 3) INDIVIDUAL DUCT LENGTHS SHALL BE COUPLED TOGETHER TO OBTAIN THE CORRECT LENGTH FROM ANCHORAGE TO ANCHORAGE. INSTALL VENTED COUPLERS AS SHOWN ON THESE DRAWINGS AND THE APPLICABLE CONTRACT PLANS.
- 4) USE HEAT SHRINK TO SEAL DUCT TO DUCT AND DUCT TO TRUMPLATE CONNECTIONS FOLLOWING THE MANUFACTURER'S RECOMMENDED PROCEDURE. CARE MUST BE OBSERVED TO AVOID BURNS ON THE DUCT.
- 5) PLACE ALL REINFORCEMENTS AS SHOWN ON THESE DRAWINGS AND THE APPLICABLE CONTRACT PLANS.
- 6) PROCEED WITH CONCRETING, TAKING CARE TO NOT DAMAGE OR DISPLACE THE DUCT.
- 7) PLACE THE CORRECT QUANTITY OF STRAND IN EACH DUCT LEAVING MINIMUM STRESSING TAILS AT EACH END. THIS CAN BE ACCOMPLISHED BY PUSHING OR PULLING THE STRAND THROUGH THE DUCT.
- 8) INSTALL THE ANCHOR BLOCK AT EACH END OF THE TRUMPLATE. INSERT THE WEDGES INTO THE ANCHOR BLOCK.
- 9) STRESSING MAY PROCEED ONCE THE CONCRETE HAS ATTAINED THE REQUIRED COMPRESSIVE STRENGTH AS INDICATED IN THE PLANS AND AS CONFIRMED BY TESTS.
- 10) ALL TENDONS SHALL BE STRESSED BY JACKING FROM ONE OR TWO ENDS IN THE APPROVED SEQUENCE. ONCE APPROVED, CUT TAILS TO 1.5" MAXIMUM LENGTH.
- 11) INSTALL GROUT CAPS, INLET AND OUTLET ACCESSORIES.
- 12) PERFORM DUCT PRESSURE FIELD TEST AS REQUIRED BY APPLICABLE SPECIFICATIONS.
- 13) GROUTING SHALL BE PERFORMED IN ACCORDANCE WITH THE LATEST EDITION OF THE PTI GUIDE SPECIFICATIONS FOR GROUTING OF POST TENSIONING STRUCTURES OR APPLICABLE SPECIFICATION.

4C15 ASSEMBLY				
ITEM	DESCRIPTION	MATERIAL	PART # / LABEL	DWG REF.
	4C15 INTERNAL TENDON W/COUPLER OVERALL ASSEMBLY			FINC-4C15-001
	4C15 ANCHORAGE ASSEMBLY			FINC-4C15-002
01	4C15 ANCHORAGE (TRUMPLATE)	ASTM A48, 35B GALV. ASTM A123	FREYSSINET 4C15	FINC-4C15-003
02	4C15 ANCHOR BLOCK (WEDGE PLATE)	AISI C1045/C1050	4C15	FINC-4C15-004
03	4C15 GROUT CAP	NYLON ASTM D5989	FREYSSINET 4C15	FINC-4C15-005
04	4C15 48mm GTI DUCT	POLYPROPYLENE ASTM D4101	220150	FINC-4C15-006
05	4C15 48mm GTI COUPLERS W/ OR W/O VENT	POLYPROPYLENE ASTM D4101	220155	FINC-4C15-007
06	4C15 SPIRAL REINFORCEMENT	STEEL GR. 60ksi; ASTM A615	N/A	FINC-4C15-008
07	4C15 HEAT SHRINK SLEEVE	POLYOLEFIN BACKING W/ ADHESIVE	PLA 63	FINC-4C15-009
08	WEDGE	12L14 ASTM A240	N/A	FINC-001
09	0.6" DIA. STRAND	STEEL ASTM A416	N/A	FINC-002
10	1/2" BALL VALVE	PVC SCH. 80 PRESSURE RATING ≥ 150 psi	N/A	FINC-003
11	3/4" BALL VALVE	PVC SCH. 80 PRESSURE RATING ≥ 150 psi	N/A	FINC-004
14	1/2" NIPPLE	PVC SCH. 80 PRESSURE RATING ≥ 150 psi	N/A	FINC-007
19	3/8" BOLT	316 STAINLESS STEEL ASTM F593	F593	FINC-012
21	3/4" CRESLINE PIPE	HIGH-DENSITY POLYETHYLENE	CRESLINE HD160	FINC-014
23	1/2" PLUG	NYLON ASTM D5989	FREYSSI 1/2"	FINC-016
30	21mm GROUT PORT, HEAT WELDED	POLYPROPYLENE ASTM D4101	220064	FINC-025
31	21mm NPT GROUT VALVE	PC-ABS / NYLON (TEMP. FITTING)	220087	FINC-023
32	21mm GROUT TUBE	POLYPROPYLENE ASTM D4101	220044	FINC-024

**NOTES:**

1. ALL PVC SCH. 80 MATERIALS TO BE TEMPORARY FITTING.
2. 21mm GROUT VENT TUBE (ITEM #32) AND ASSEMBLY ARE USED AS AN ALTERNATIVE TO THE RIGID PE VENT TUBE (ITEM #21).

**VENDOR-SPECIFIC INSTALLATION PROCEDURE FOR WELDING PORT (ITEM #30) TO DUCT:**

MARK GTI DUCT & DRILL 3/8" (22mm) HOLE IN THE GTI DUCT AND CLEAN HOLE AND GTI WELDED GROUT PORT. WELDED GROUT PORT HOLE REQUIRED TO BE BETWEEN RIBS OF DUCT.

FOLLOW MANUFACTURER'S REQUIREMENTS FOR PREPARATION OF THE PORT WELDER.

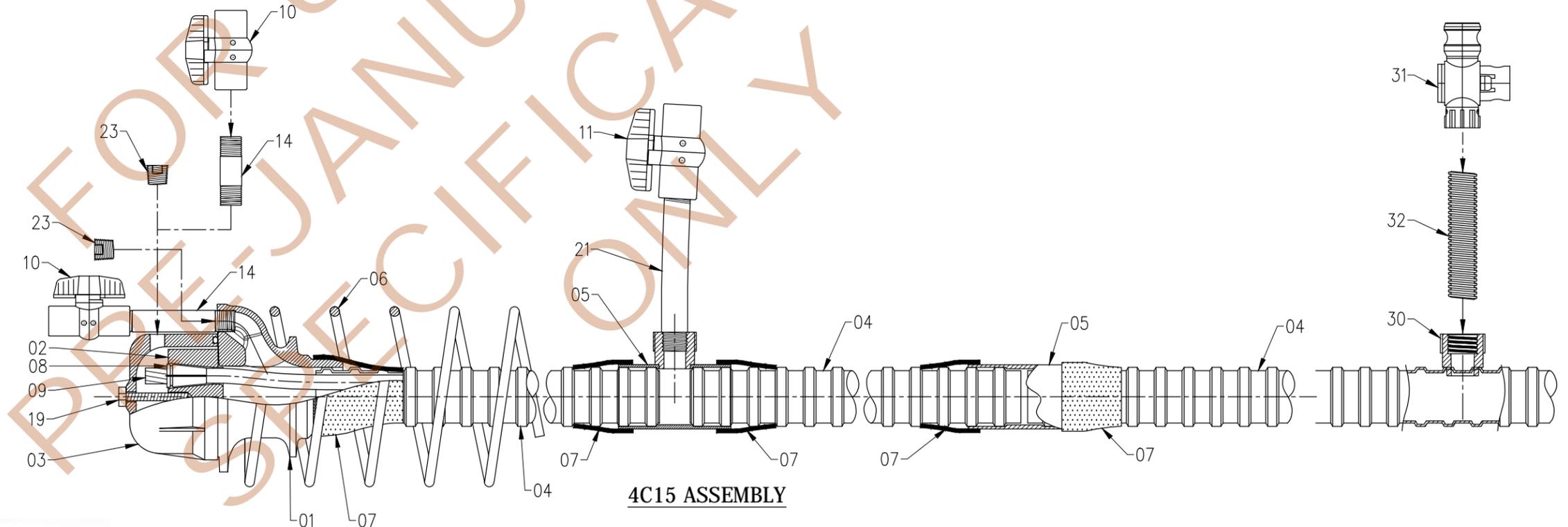
SIMULTANEOUSLY, INSERT MALE ADAPTER OF GTI GROUT PORT WELDER INTO DRILLED HOLE AND PLACE GTI WELDED GROUT PORT INTO FEMALE ADAPTER. APPLY LIGHT PRESSURE FOR 20-25 SECONDS BY PUSHING THE GTI WELDED GROUT PORT WITH THE PALM OF HAND.

REMOVE THE PORT WELDER FROM THE DRILLED HOLE AND WITHIN 5 SECONDS, INSERT THE WELDED GROUT PORT UNTIL SHOULDER IS REACHED.

ALLOW THE GTI DUCT AND GTI WELDED GROUT PORT TO COOL FOR A MINIMUM OF 4 MINUTES.

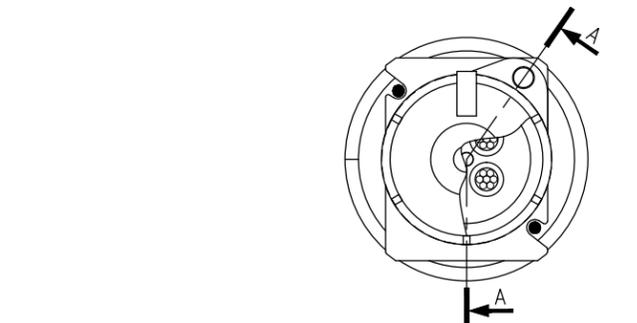
AFTER THE COOLING TIME HAS FINISHED, THE ASSEMBLY CAN BE USED AS REQUIRED.

- THE ABOVE IS A GENERIC INSTALLATION PROCEDURE - JOB SPECIFIC PROCEDURES SHALL ACCOMPANY EACH PROJECT.

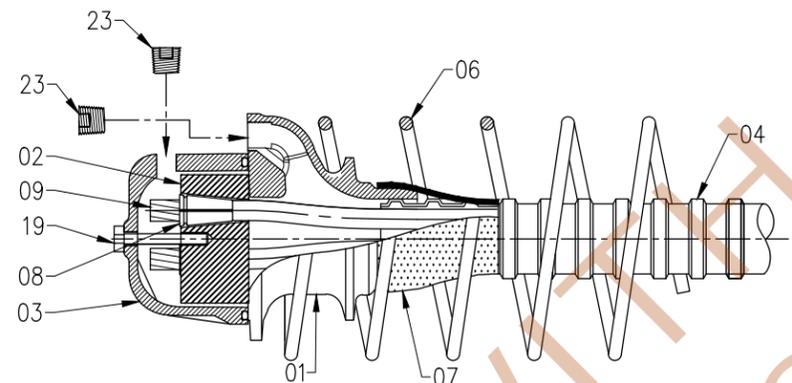


**4C15 ASSEMBLY**

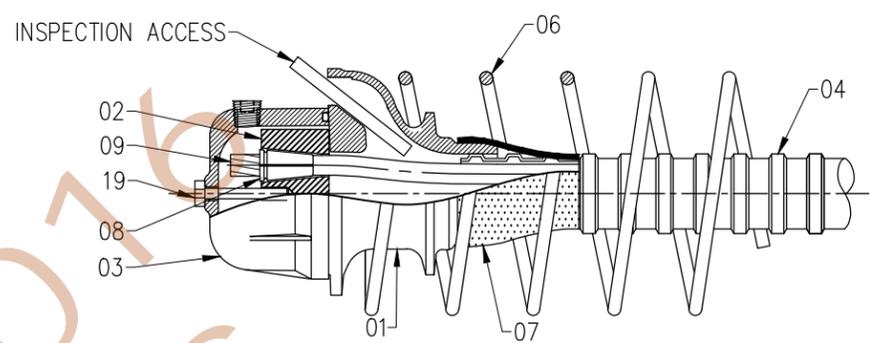
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REV.	DATE	DRAWN	CHECKED	APPROVED	REVISIONS																																																	
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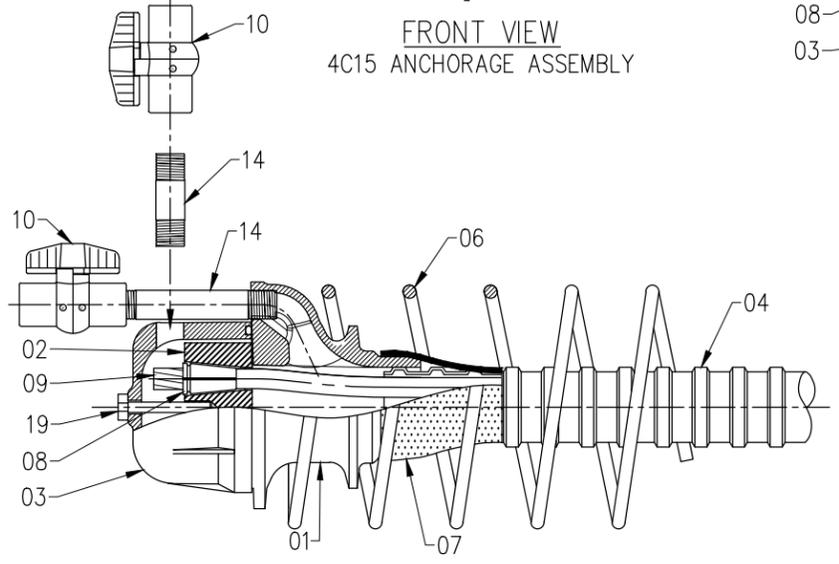
FRONT VIEW  
4C15 ANCHORAGE ASSEMBLY



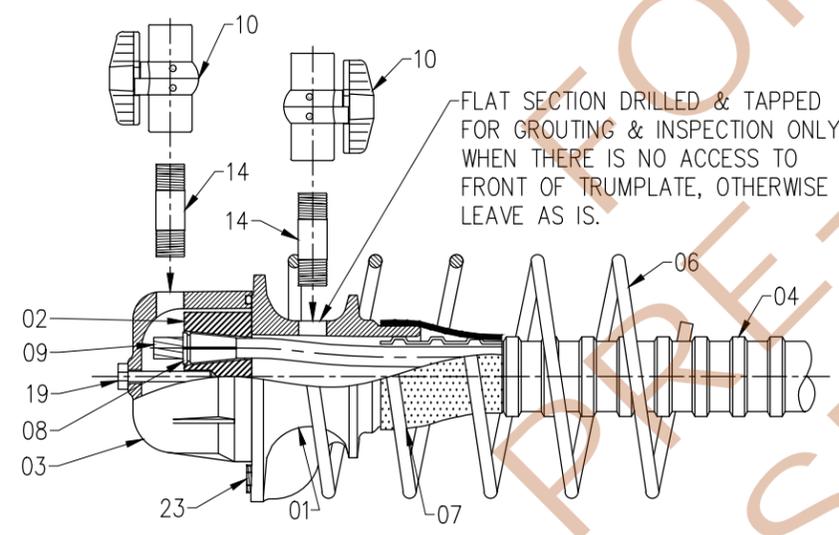
PARTIAL SECTION A-A  
AFTER GROUTING



PARTIAL SECTION A-A  
GROUT INSPECTION



PARTIAL SECTION A-A  
GROUT INLET / OUTLET



PARTIAL SECTION A-A  
GROUT AND INSPECT FROM TOP

FLAT SECTION DRILLED & TAPPED FOR GROUTING & INSPECTION ONLY WHEN THERE IS NO ACCESS TO FRONT OF TRUMPLATE, OTHERWISE LEAVE AS IS.

4C15 ASSEMBLY				
ITEM	DESCRIPTION	MATERIAL	PART # / LABEL	DWG REF.
	4C15 INTERNAL TENDON W/COUPLER OVERALL ASSEMBLY			FINC-4C15-001
	4C15 ANCHORAGE ASSEMBLY			FINC-4C15-002
01	4C15 ANCHORAGE (TRUMPLATE)	ASTM A48, 35B GALV. ASTM A123	FREYSSINET 4C15	FINC-4C15-003
02	4C15 ANCHOR BLOCK (WEDGE PLATE)	AISI C1045/C1050	4C15	FINC-4C15-004
03	4C15 GROUT CAP	NYLON ASTM D5989	FREYSSINET 4C15	FINC-4C15-005
04	4C15 48mm GTI DUCT	POLYPROPYLENE ASTM D4101	220150	FINC-4C15-006
06	4C15 SPIRAL REINFORCEMENT	STEEL GR. 60ksi; ASTM A615	N/A	FINC-4C15-008
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14	1/2" NIPPLE	PVC SCH. 80 PRESSURE RATING ≥ 150 psi	N/A	FINC-007
19	3/8" BOLT	316 STAINLESS STEEL ASTM F593	F593	FINC-012
23	1/2" PLUG	NYLON ASTM D5989	FREYSSI 1/2"	FINC-016

NOTE: ALL PVC SCH. 80 MATERIALS TO BE TEMPORARY FITTING

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4	01-15-16	JM	TG/JN	AM	FOURTH REVISION
3	07-19-13	JF	TG/BG	AM	THIRD REVISION
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DRAWING TITLE:  
**4C15 INTERNAL TENDON W/COUPLER OVERALL ASSEMBLY**

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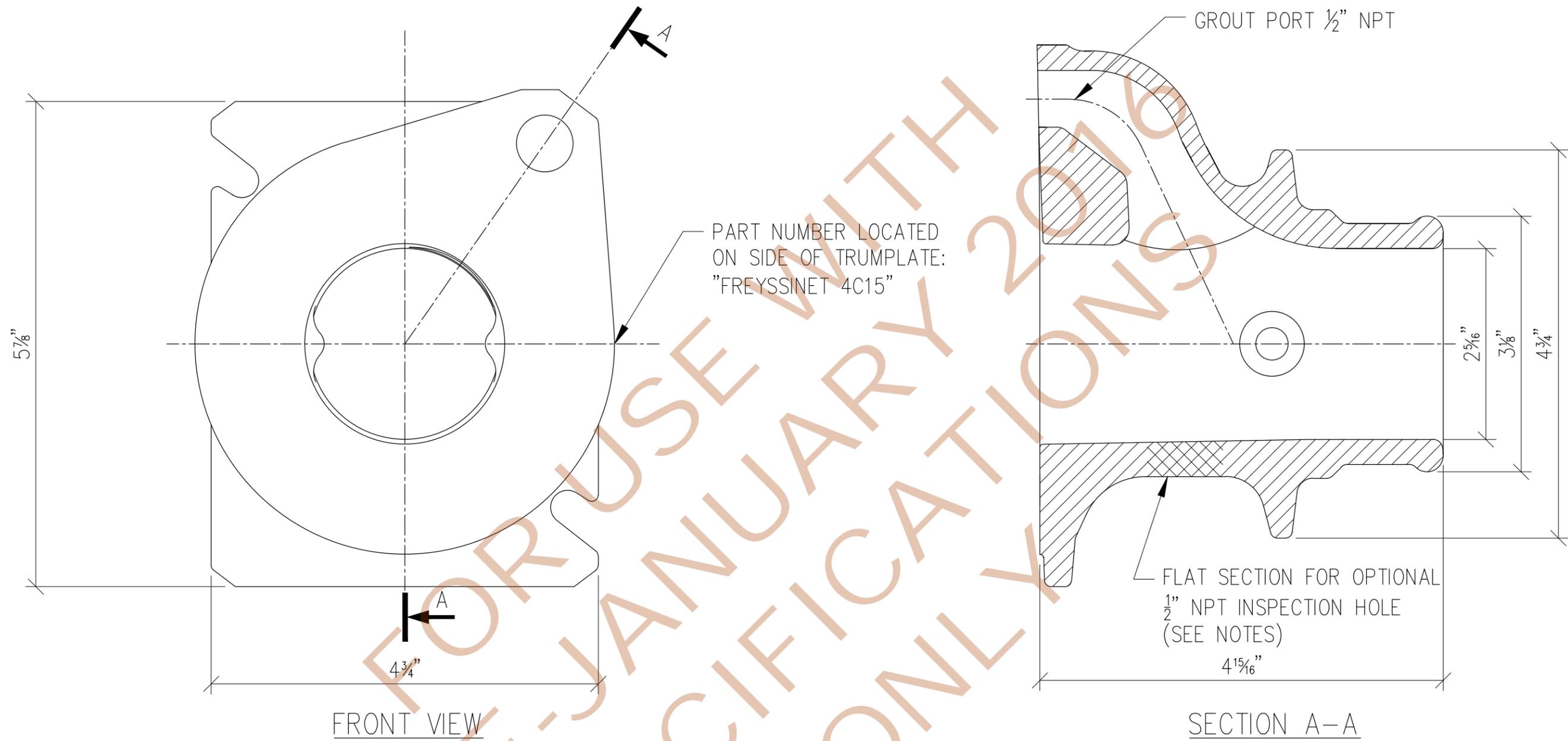
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SHEET NO.:  
**FINC-4C15-002**

REV:  
**4**



NOTES:

- MATERIAL: ASTM A48, 35B GALV. ASTM A123
- FLAT SECTION DRILLED & TAPPED FOR GROUTING & INSPECTION ONLY WHEN THERE IS NO ACCESS TO FRONT OF TRUMPLATE. OTHERWISE LEAVE AS IS.

REV.	DATE	DRAWN	CHECKED	APPROVED	REVISIONS
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DRAWING TITLE:  
**4C15 ANCHORAGE (TRUMPLATE)**

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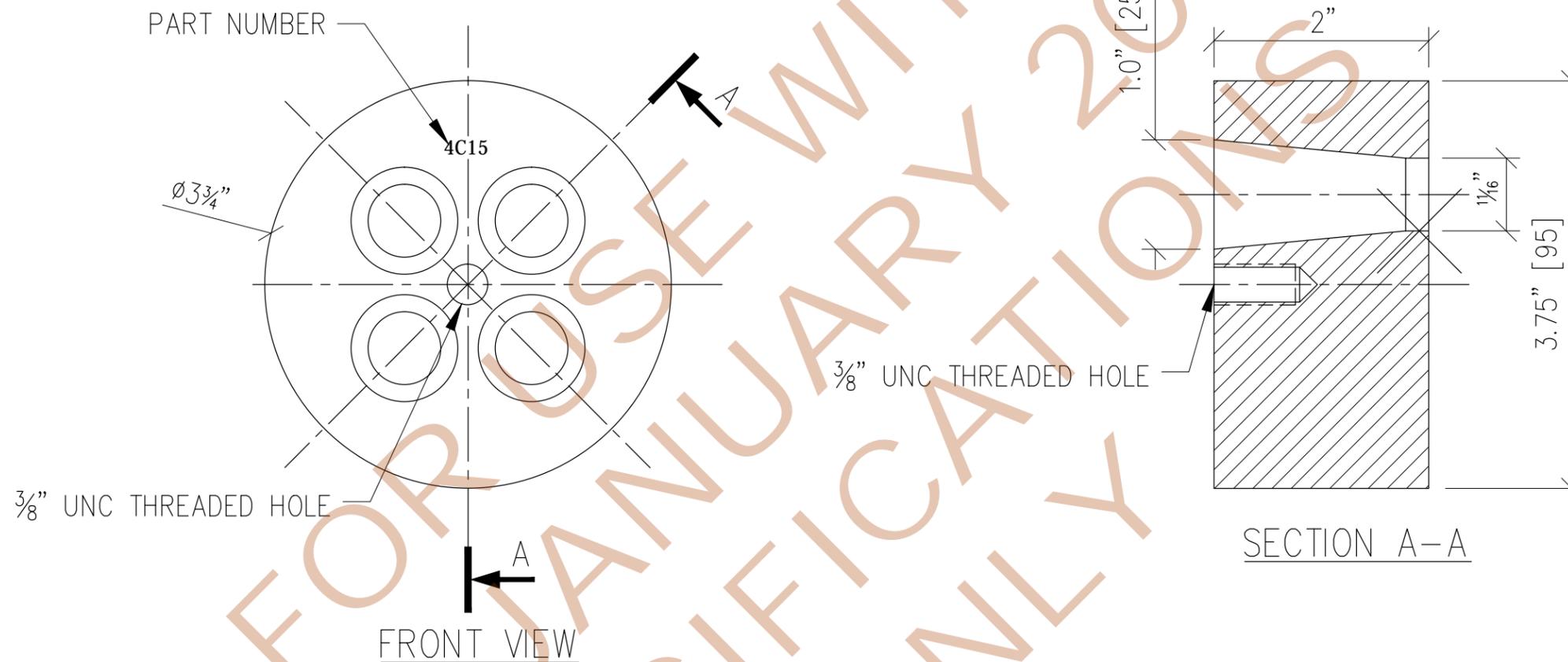
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NOTE:

- MATERIAL: AISI C1045 / C1050

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4	01-15-16	JM	TG/JN	AM	FOURTH REVISION
3	07-19-13	JF	TG/BG	AM	THIRD REVISION
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1	07-26-12	TG	BG	AM	FIRST REVISION
0	02-11-11	SA	BG	AM	ORIGINAL

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PROJECT NAME AND LOCATION:  
**FDOT STANDARD DRAWINGS**

DRAWING TITLE:  
**4C15 ANCHOR BLOCK (WEDGE PLATE)**

SCALE:  
**N.T.S.**

FREYSSINET PROJECT NO.:

FILENAME:

4C15\_071913\_APPROVED\_DWGS.dwg

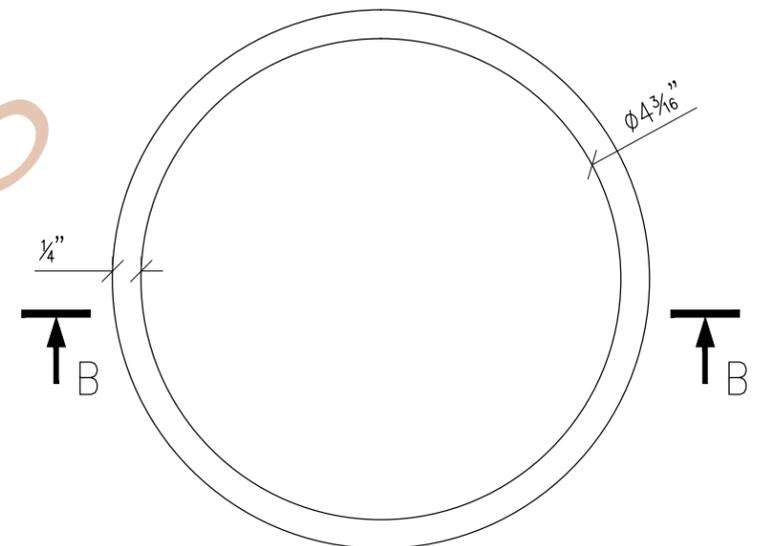
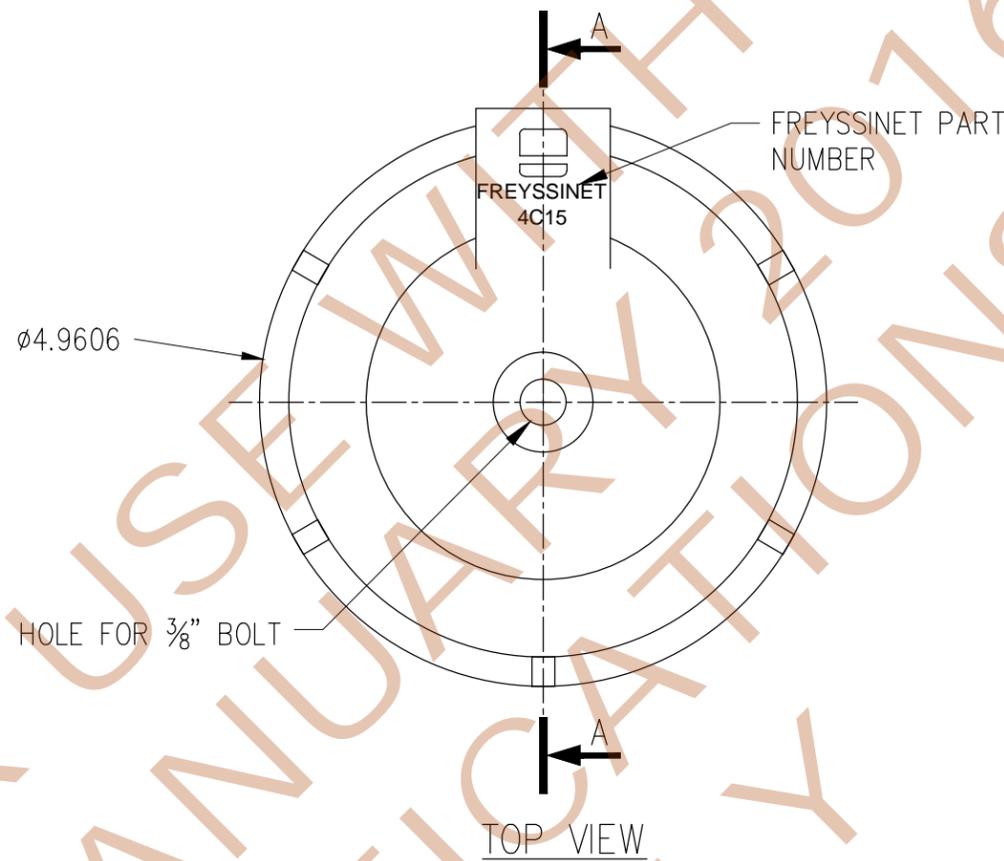
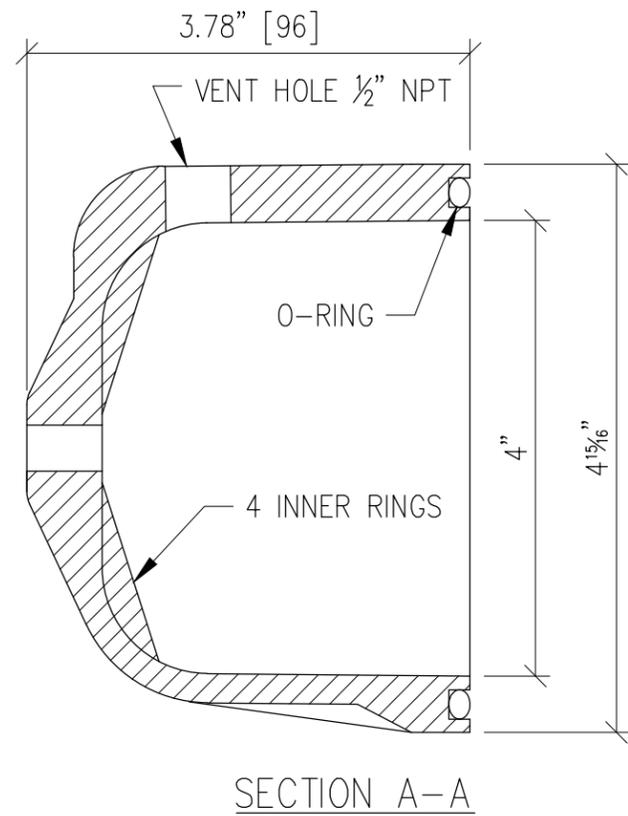
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NOTE:

- MATERIAL: NYLON ASTM D5989
- USE O-RING IN GROOVE FOR SEALING AGAINST TRUMPLATE (DWG. FINC-4C15-002)
- USE 3/8" S.S. BOLT ASTM F593
- PRESSURE RATING = 150 psi
- GROUT CAP MEETS OR EXCEEDS FDOT REQUIREMENTS OF SECTION 960-2.2.2.1 AND 960-2.4.1

NOTE:

- O-RING MATERIAL: 65-75 DUROMETER BLACK NITRILE WITH A SHORE A DUROMETER = 72 AS PER ASTM D2240
- MEETS OR EXCEEDS FDOT REQUIREMENTS OF SECTION 960-2.2.1.7

REV.	DATE	DRAWN	CHECKED	APPROVED	REVISIONS
4	01-15-16	JM	TG/JN	AM	FOURTH REVISION
3	07-19-13	JF	TG/BG	AM	THIRD REVISION
2	10-01-12	JF	TG/BG	AM	SECOND REVISION
1	07-26-12	TG	BG	AM	FIRST REVISION
0	02-11-11	SA	BG	AM	ORIGINAL

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**FDOT STANDARD DRAWINGS**

DRAWING TITLE:  
**4C15 GROUT CAP**

SCALE:  
**N.T.S.**

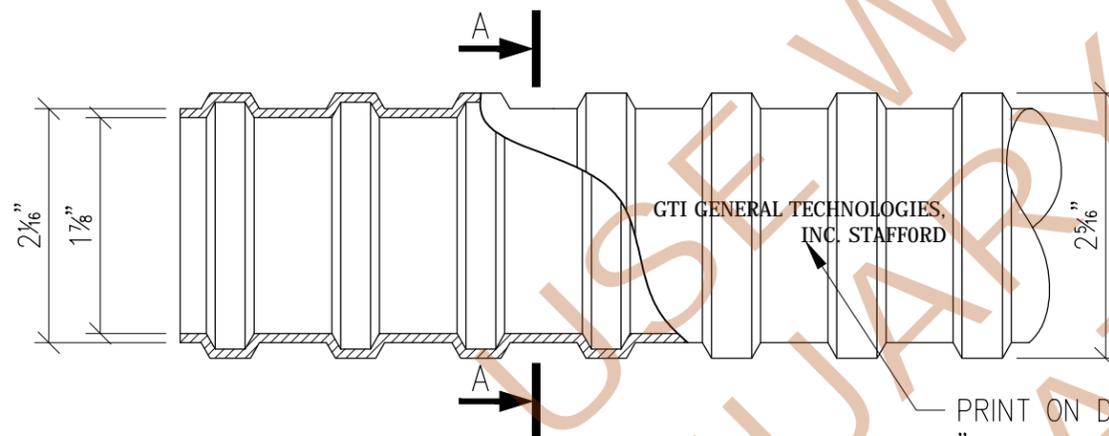
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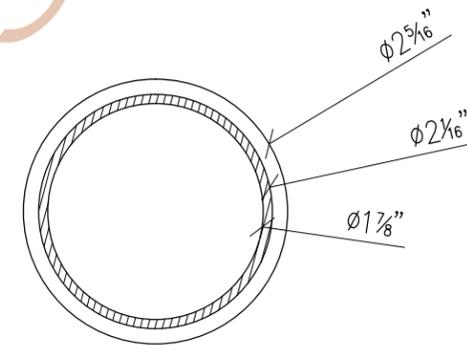
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 STAFFORD, TEXAS X3F E16 U.S. &  
 FOREIGN PATENT PENDING P.N.  
 220150 48mm"



SECTION A-A

ELEVATION

NOTE:

- MATERIAL: POLYPROPYLENE (ASTM D4101)
  - STANDARD FIT FOR 4C15
  - DUCT IS DELIVERED IN STRAIGHT SECTIONS AND IS NOT INTENDED TO BE COILED.
- DUCT MEETS OR EXCEEDS FDOT REQUIREMENTS OF SECTION 960-2.2.1.1 AND 960-2.4.4

REV.	DATE	DRAWN	CHECKED	APPROVED	REVISIONS
4	01-15-16	JM	TG/JN	AM	FOURTH REVISION
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1	07-26-12	TG	BG	AM	FIRST REVISION
0	02-11-11	SA	BG	AM	ORIGINAL

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PROJECT NAME AND LOCATION:  
**FDOT STANDARD DRAWINGS**

DRAWING TITLE:  
**4C15 48mm GTI DUCT**

SCALE:  
**N.T.S.**

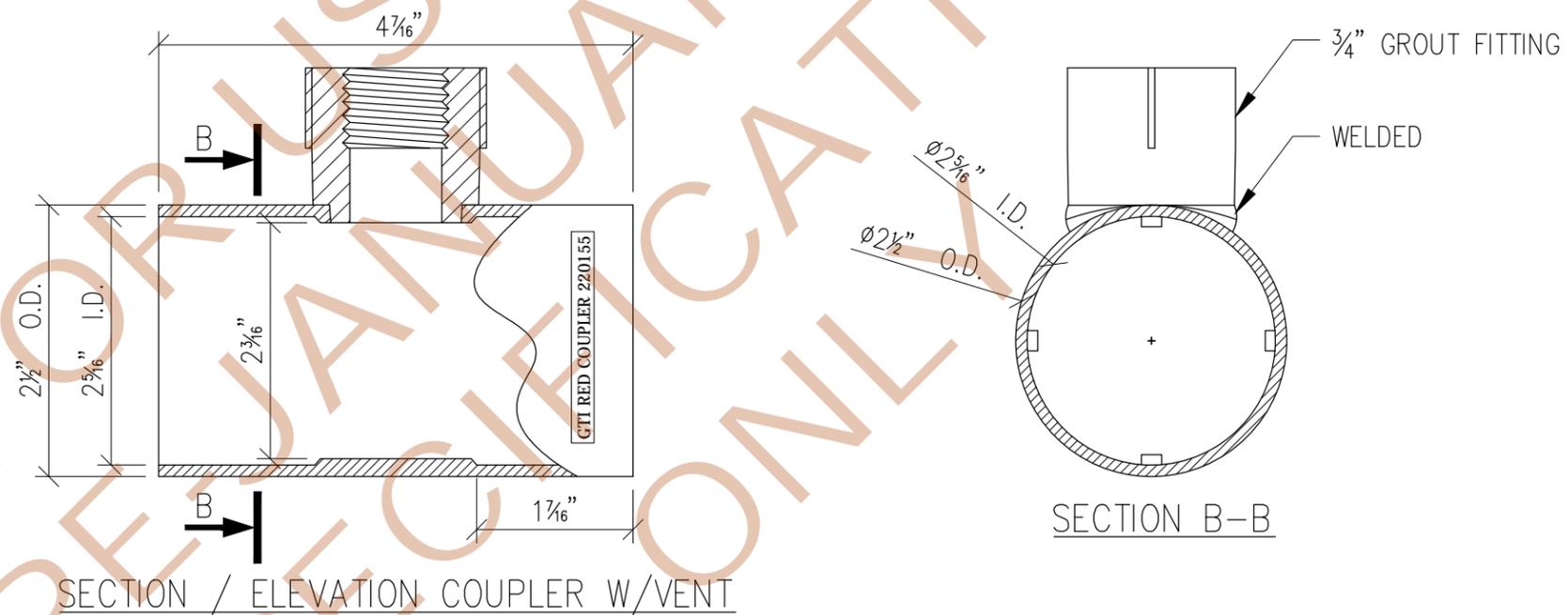
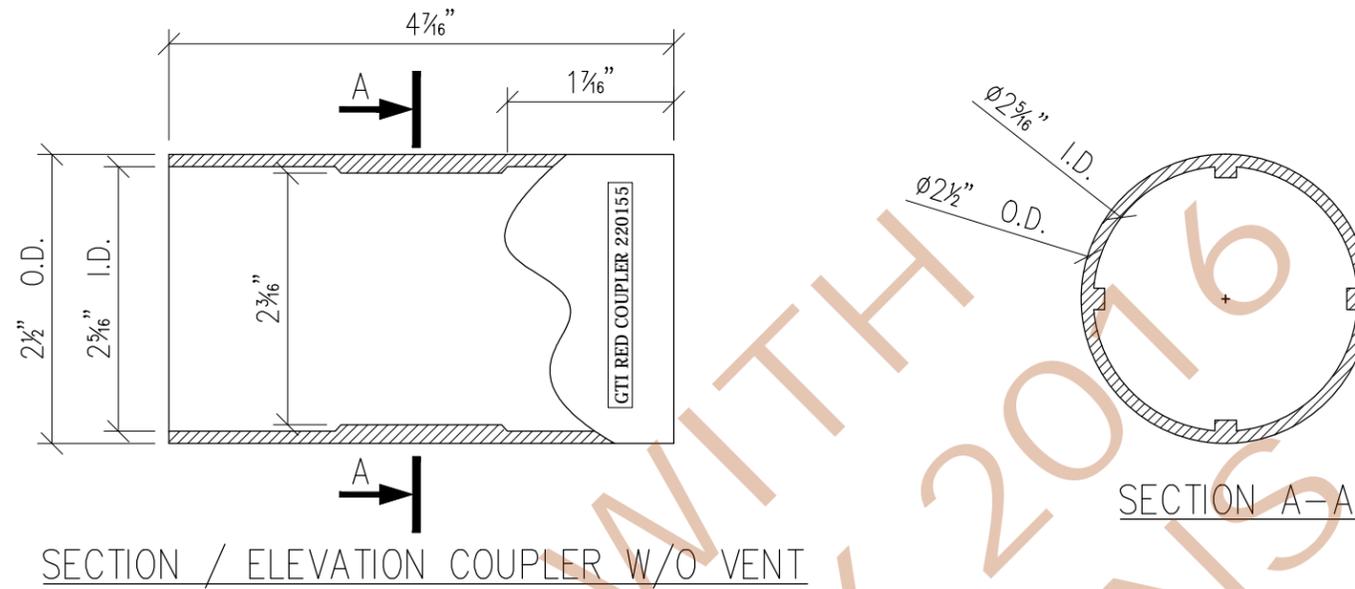
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SHEET NO.:  
**FINC-4C15-006**

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NOTE:

- MATERIAL: POLYPROPYLENE (ASTM D4101)
- STANDARD FIT FOR 48mm DUCT
- COUPLER MEETS OR EXCEEDS FDOT REQUIREMENTS OF SECTION 960-2.2.1.5 AND 960-2.4.4

REV.	DATE	DRAWN	CHECKED	APPROVED	REVISIONS
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PROJECT NAME AND LOCATION:  
**FDOT STANDARD DRAWINGS**

DRAWING TITLE:  
**4C15 48mm GTI SLIP-ON COUPLER W/ OR WO/ VENT**

SCALE:  
**N.T.S.**

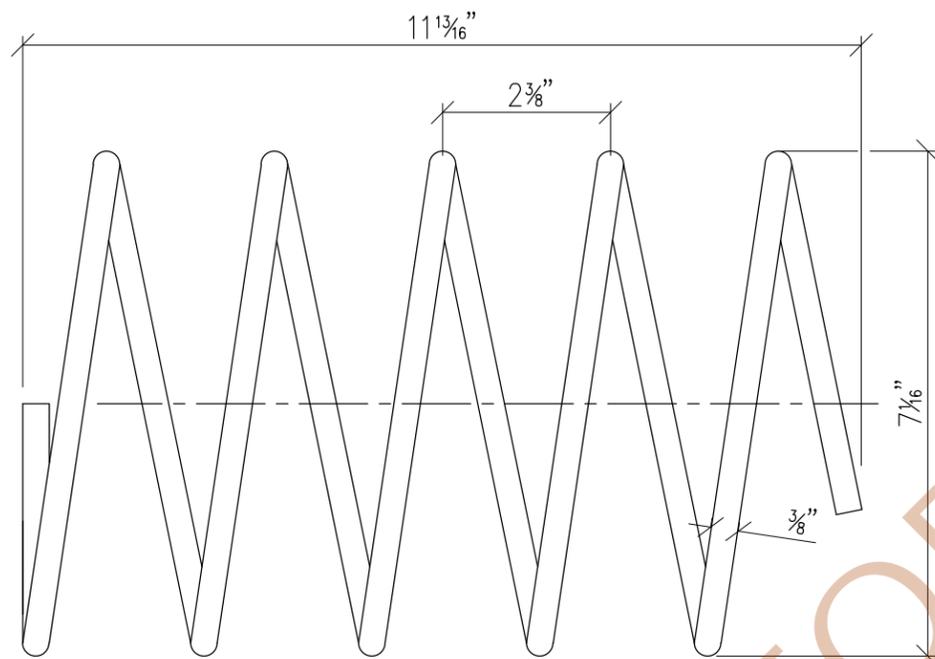
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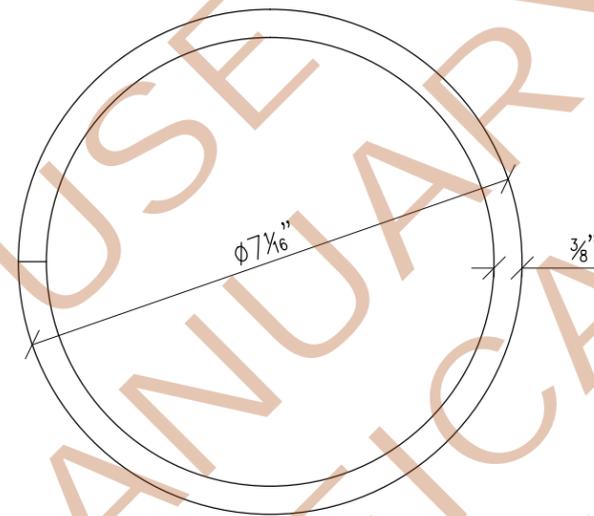
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**FINC-4C15-007**

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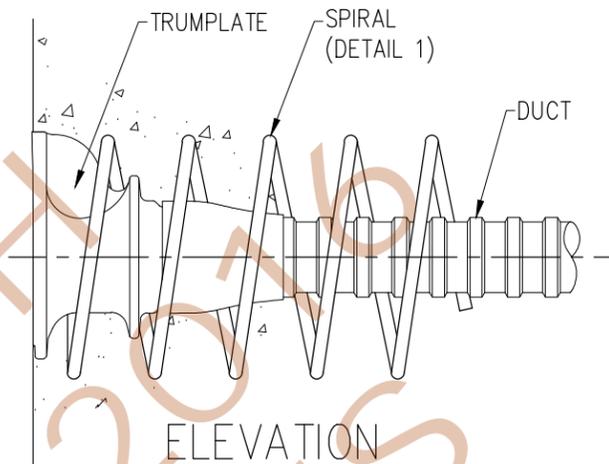
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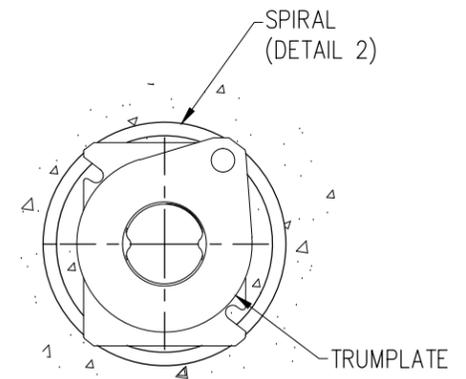
DETAIL 1  
ELEVATION



DETAIL 2  
FRONT VIEW



ELEVATION  
NOT TO SCALE



FRONT VIEW  
NOT TO SCALE

SPIRAL REINFORCEMENT

NOTE:

- MATERIAL: STEEL GR. 60ksj; ASTM A615
- #3 REBAR
- 5 TURNS IN TOTAL
- 2.36" PITCH
- $\phi$  7.09"

REV.	DATE	DRAWN	CHECKED	APPROVED	REVISIONS
4	01-15-16	JM	TG/JN	AM	FOURTH REVISION
3	07-19-13	JF	TG/BG	AM	THIRD REVISION
2	10-01-12	JF	TG/BG	AM	SECOND REVISION
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PROJECT NAME AND LOCATION:  
**FDOT STANDARD DRAWINGS**

DRAWING TITLE:  
**4C15 SPIRAL REINFORCEMENT**

SCALE:  
N.T.S.

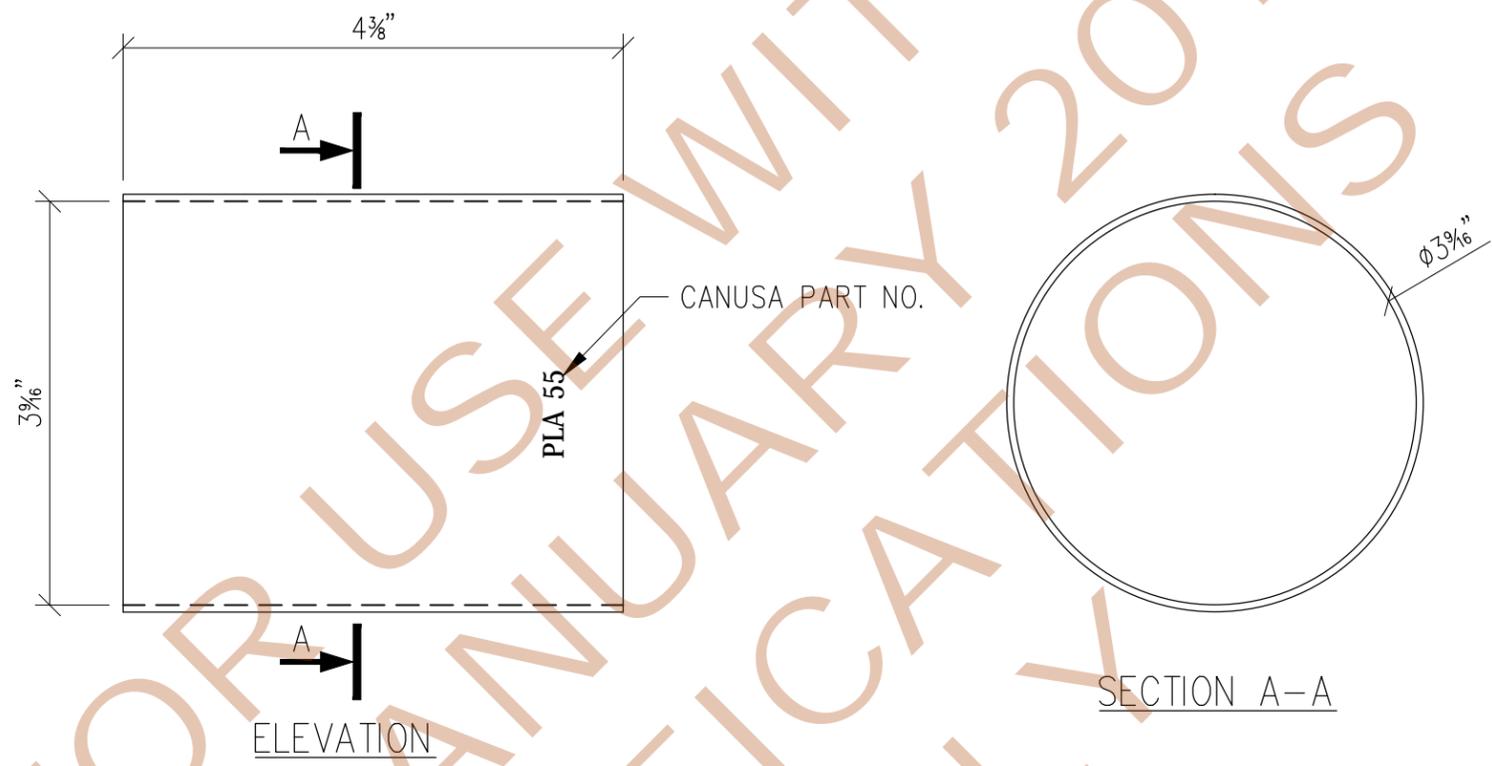
FREYSSINET PROJECT NO.:

FILENAME:  
4C15\_071913\_APPROVED\_DWGS.dwg

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SHEET NO.:  
**FINC-4C15-008**

REV:  
**4**



- NOTE:
- MATERIAL: POLYOLEFIN W/ ADHESIVE
  - TUBULAR SLEEVE DIAMETER: 3.5" [90mm] AS SUPPLIED  
2.3" [55mm] FULLY RECOVERED
  - HEAT SHRINK SLEEVE MEETS OR EXCEEDS FDOT REQUIREMENTS OF SECTION 960-2.2.1.8

REVISIONS:					 <b>FREYSSINET, INC</b> PHONE: 703-378-2500 WWW.FREYSSINETUSA.COM COPYRIGHT & MODIFICATION RESERVED	MEMBERS OF:  	STAMP:	CLIENT: <b>FDOT</b>	DRAWING TITLE: <b>4C15 HEAT SHRINK SLEEVE</b>			These drawings contain proprietary information restricted solely to this project and may not be reproduced in whole or part without the written expressed permission of FREYSSINET, INC				
4	01-15-16	JM	TG/JN	AM				FOURTH REVISION	PROJECT NAME AND LOCATION: <b>FDOT STANDARD DRAWINGS</b>	SCALE: N.T.S.			FILENAME: 4C15_071913_APPROVED_DWGS.dwg	SHEET NO.:	REV:	
3	07-19-13	JF	TG/BG	AM				THIRD REVISION		<b>FINC-4C15-009</b>				<b>4</b>		
2	10-01-12	JF	TG/BG	AM				SECOND REVISION								
1	07-26-12	TG	BG	AM				FIRST REVISION								
0	02-11-11	SA	BG	AM	ORIGINAL											
REV.	DATE	DRAWN	CHECKED	APPROVED	REVISIONS											