

**PRECAST PRESTRESSED CONCRETE CONSTRUCTION - FLORIDA SLAB BEAM
SUPERSTRUCTURE SYSTEM.
(REV 1-28-16)**

SUBARTICLE 450-6.1 is deleted and the following substituted:

450-6.1 General: Use metal side and bottom forms, unless otherwise specified in the Contract Documents. For members with special shapes such as corner sheet piles, wood forms are permitted. Slab beams, slab units and sheet piles may be cast on concrete surfaces meeting the profile dimensional tolerances of 450-6.3. Apply release agents in accordance with the manufacturer's recommendations. Liquid membrane curing compounds may be used to prevent bonding of slab products and sheet piles to the existing concrete surface, when applied in two or more coating. Ensure the last application of liquid membrane is applied immediately before placement of the slab or sheet pile.

For all beam members, use side forms designed to be removed without damaging the top flange of the beam. Remove the forms horizontally away from the beam by a method that prevents any contact of the form with the top flange after release of the form. Do not subject the top flange to any vertical force at any time. Include the form details and method of removal in the Producer QC Plan.

For all Florida-I Beams, use forms that do not have more than two horizontal joints.

Use void forms of a type for which service adequacy has been demonstrated, having sufficient strength to provide stability during handling and placing and to withstand hydrostatic pressures and other forces imposed upon them during concrete placement. Use form material that is neutral with respect to the generation of products harmful to the physical and structural properties of the concrete. Ensure that the presence of the form materials does not cause any detrimental effect to the concrete or other materials within the member. Positively vent all voids to the outside of the member. For end headers (except end headers used with CFRP strands) and inside forms, other materials capable of resisting the pressure from concrete are permitted. End headers used with CFRP strands must be either timber headers or steel headers with rubber grommets to protect the CFRP strands from damage.

Use end headers so designed that they can be placed and maintained in correct position between the side forms. Hold the headers in place with devices capable of being removed or loosened after the concrete has attained its initial set allowing free form expansion during curing methods that involve heat. Use end headers with openings conforming to the prestressing strand pattern to permit passage of the prestressing strand. Locate the openings accurately within 1/8 inch of planned location of prestressing strand elements.

Construct circular openings for strands a maximum of 1/4 inch larger than the nominal strand diameter. Construct square or rectangular openings a maximum of 1/4 inch larger, horizontally and vertically, than the nominal strand diameter. Ensure that all headers are mortar tight.

SUBARTICLE 450-10.3.2.1 is deleted and the following substituted:

450-10.3.2.1 AASHTO Type II, Florida-I Beam 36 and Double-T Beams, Piling, Slab Beams, and Precast Slab Units (Except Voided Piling and Slabs): Place concrete in one or more layers or lifts. If more than one layer is used for Double-T Beams, end the first layer such that the top of the concrete is slightly below the bottom of the flange.

SUBARTICLE 450-10.5.4 is deleted and the following substituted:

450-10.5.4 Slabs and Double-T Beams: When the Plans show the top surface of prestressed slab units, slab beams, or Double-T Beams to be the riding surface, apply a Class 4 floor finish in accordance with Section 400. When the Plans show the surface to be overlaid with asphalt or concrete, rough float the top surface and then scrub it transversely with a coarse brush to remove all laitance and to produce a roughened surface for bonding. For the other external surfaces of slabs and double-T beams, unless otherwise specified, apply a General Surface Finish in accordance with 400-15.1.

SUBARTICLE 450-12.5.3.6 is deleted and the following substituted:

450-12.5.3.6 Simple Span Prestressed Slab Beams and Slab Units:

End Zones (within a distance of twice the depth of the product from the end): One horizontal crack at either or both ends in the top half of the product, which is not in the plane of nor intersecting any row of prestressing strands, and extending from the end of the product for a length not to exceed half the product's depth.

Any Location (after detensioning): Vertical cracks in the top half of the product's depth.

SUBARTICLES 450-16.2 and 450-16.3 are deleted and the following substituted:

450-16.2 Storage: Store precast prestressed beams, Double-T Beams and slab units on only two points of support located within 18 inches of the end of the product or as calculated. Support skewed beams, Double-T Beams or slab units within 18 inches of the end of the full product section or as calculated. Do not support slab beams on the outer 6 inches of the product width. Support other products on an adequate number of supports so as to keep stresses in the products within the allowable stresses at release listed in the Department's Structures Design Guidelines. Locate multiple supports (more than two) within 1/2 inch of a horizontal plane through the top surface of the supports. Adequately brace beams as necessary to maintain stability.

All supports must be level and on adequate foundation material that will prevent shifting or differential settlement which may cause twisting or rotation of products. Immediately pick up products in storage that have rotated or twisted and adjust the supports to provide level and uniform support for the product.

Support prestressed products that are stacked by dunnage placed across the full width of each bearing point and aligned vertically over lower supports. Do not use stored products as a storage area for either shorter or longer products or heavy equipment.

Where feasible, base the selection of storage sites, storage conditions and orientation upon consideration of minimizing the thermal and time-dependent creep and shrinkage effects on the camber and/or sweep of the precast pretensioned products.

Continuous application of water during the initial 72 hour moist curing period may be interrupted for a maximum of one hour to allow relocation of precast prestressed concrete elements within the manufacturing facility. Keep the moist burlap in place during relocation of the element.

Measure and record the sweep and camber of beams monthly. Keep the measurement records on file for review at any time by the Engineer, and upon request, submit these measurements to the Engineer. If the camber exceeds by 1 inch the design camber shown in the Plans, take appropriate actions in accordance with 400-7.13.1 to accommodate the product in the structure.

If the sweep exceeds the tolerance specified, take immediate measures to bring the sweep of the product back to within tolerance.

Notify the Engineer immediately when the sweep or camber exceeds the specified tolerances. Special storage conditions for the purpose of removing excessive sweep will not be restricted by requirements of this Subarticle nor contained in 450-2.1. If the sweep of the product exceeds the tolerance specified and cannot be removed, the disposition of the product will be in accordance with 450-12.1 and 450-14.

450-16.3 Shipping: Do not ship precast prestressed concrete products to the project site prior to the completion of the 72 hour curing period and attainment of the required 28-day strength. The contractor is permitted to verify the shipping strength test, before 28 days, by testing compressive strength cylinders that are cured under the conditions similar to the product or by testing temperature match cured cylinders. The use of maturity method, ASTM C1074, pulse velocity method in accordance with ASTM C597, or any other nondestructive test method acceptable to Engineer, is permitted to estimate the strength before its verification by test cylinders. The shipping strength test is the average compressive strength of two test cylinders. Do not ship products until accepted and stamped by the QC Manager or the inspectors under the direct observation of the QC Manager. At the beginning of each project, provide a notarized statement to the Engineer from a responsible company representative certifying that the plant will manufacture the products in accordance with the requirements set forth in the Contract Documents and Producer QC Plan. The QC Manager's stamp on each product indicates certification that the product was fabricated in conformance with the Producer QC Plan, the Contract, and this Section. Ensure that each shipment of prestressed concrete products to the project site is accompanied with a signed or stamped delivery ticket providing the description and the list of the products.

Evaluate the temporary stresses and stability of all products during shipping and locate supports, generally within 18 inches from the beam end, in such a manner as to maintain stresses within acceptable levels. Include impact loadings in the evaluation. Do not support slab beams on the outer 6 inches of the product width.

SUBARTICLE 450-18 is deleted and the following substituted:

450-18 Basis of Payment.

Price and payment will be full compensation for all work and materials specified in this Section, including reinforcement, pretensioning strand, embedded ducts, hardware, inserts and

other materials as required, to fabricate, transport and place the product into its permanent position in the structure.

Payment for the items will be made under the following:

- Item No. 450- 1- Prestressed Beams - per foot.
- Item No. 450- 2 Prestressed Beams: Florida-I Beams – per foot.
- Item No. 450- 3- Prestressed Slab Units - per foot.
- Item No. 450- 4- Prestressed Beam U-beams - per foot.
- Item No. 450- 8- Prestressed Beams: Florida Slab Beam – per foot.
- Item No. 450- 88- Prestressed Slab Units Transversely Post-Tensioned - square foot.

Do Not Use Without
CO Specs Authorization