

State of Illinois  
Illinois Department of Transportation

Addendum  
MANUAL FOR FABRICATION OF PRECAST PRESTRESSED CONCRETE PRODUCTS

Effective: April 13<sup>th</sup>, 2018

Section 3.6.3

Replace the 1<sup>st</sup> paragraph and numbered list with the following:

“When a prestressed product has attained the specified strength, the earliest the product may be loaded, shipped, and used shall be as follows:

1. Precast prestressed concrete deck beams – the 5<sup>th</sup> calendar day.
2. Precast prestressed concrete I-beams, Bulb T-beams, and IL-beams used for single-span bridges less than or equal to 100 feet long – the 5<sup>th</sup> calendar day.
3. Precast prestressed concrete I-beams, Bulb T-beams, and IL-beams used for single-span bridges greater than 100 feet long – the 46<sup>th</sup> calendar day.
4. Precast prestressed concrete I-beams, Bulb T-beams, and IL-beams used for multi-span bridges – the 46<sup>th</sup> calendar day.”

Revisions to Appendix A:

Revise page A-1 of the table of contents as follows:

Alternate Straight Top Strand Placement for IL-Beams with G2(E) Bars (English) ...	A – 28
New: Alternate Top Flange Reinforcement for 36 in. Thru 72 in. IL-Beams (English) .....	A – 29
Alternate Bottom Flange WWR for IL-Beams (English) .....	<del>A – 34</del> 30
WWR Placement Tolerances for 27 in. IL-Beams (English) .....	A – <del>29</del> 31
WWR Placement Tolerances for 36 in. Thru 72 in. IL-Beams (English).....	A – <del>30</del> 32

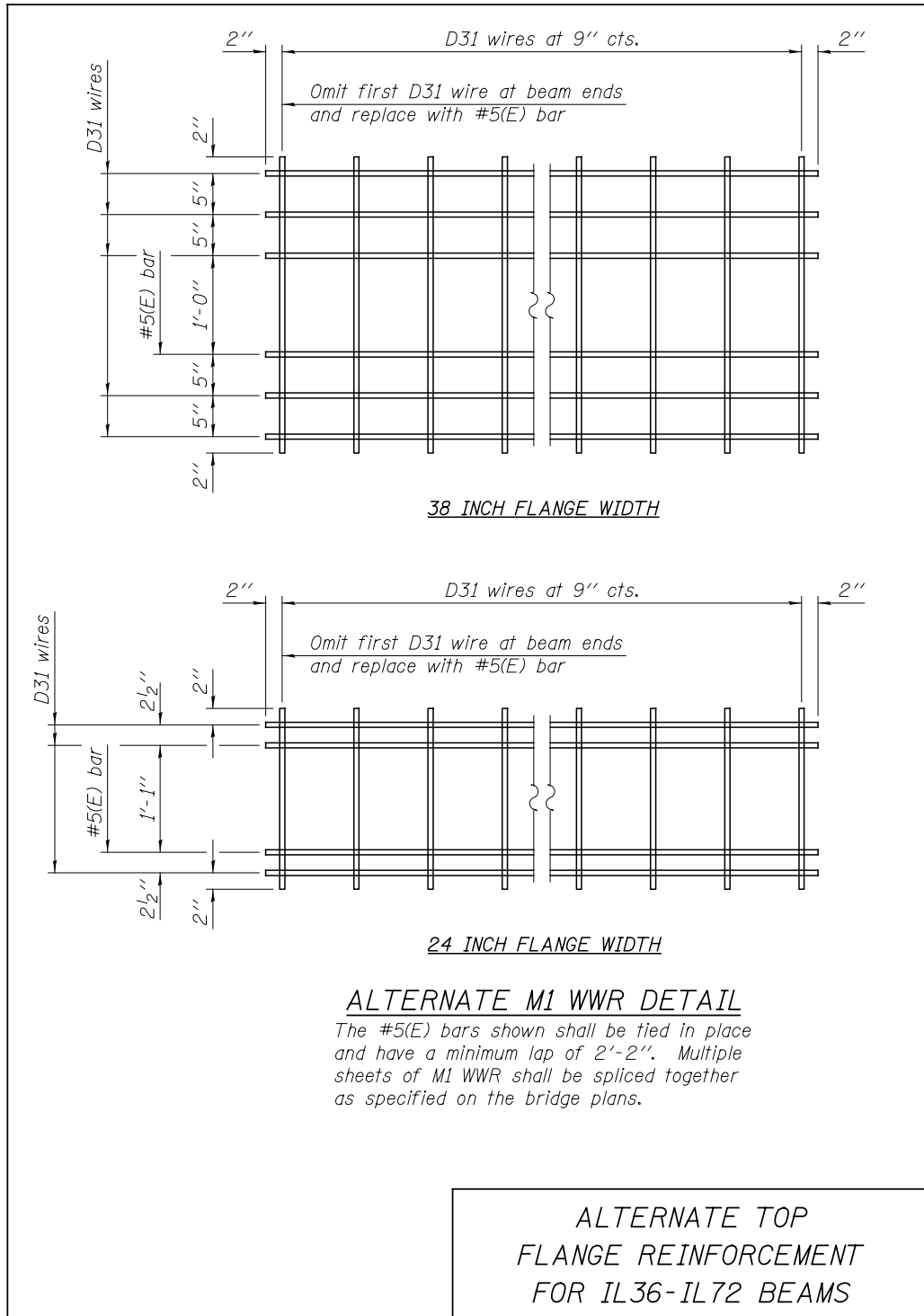
Revise Procedure to Remedy an Unacceptable Precast or Precast Prestressed Product at the Plant to add the following sentence to Step 8:

“The District will forward the remedy resolution to the District Bridge Maintenance Engineer—or, if a Local Agency structure, the Owner will retain a copy—to keep with the bridge file for this structure to ensure the condition rating inspector has access to this information.”

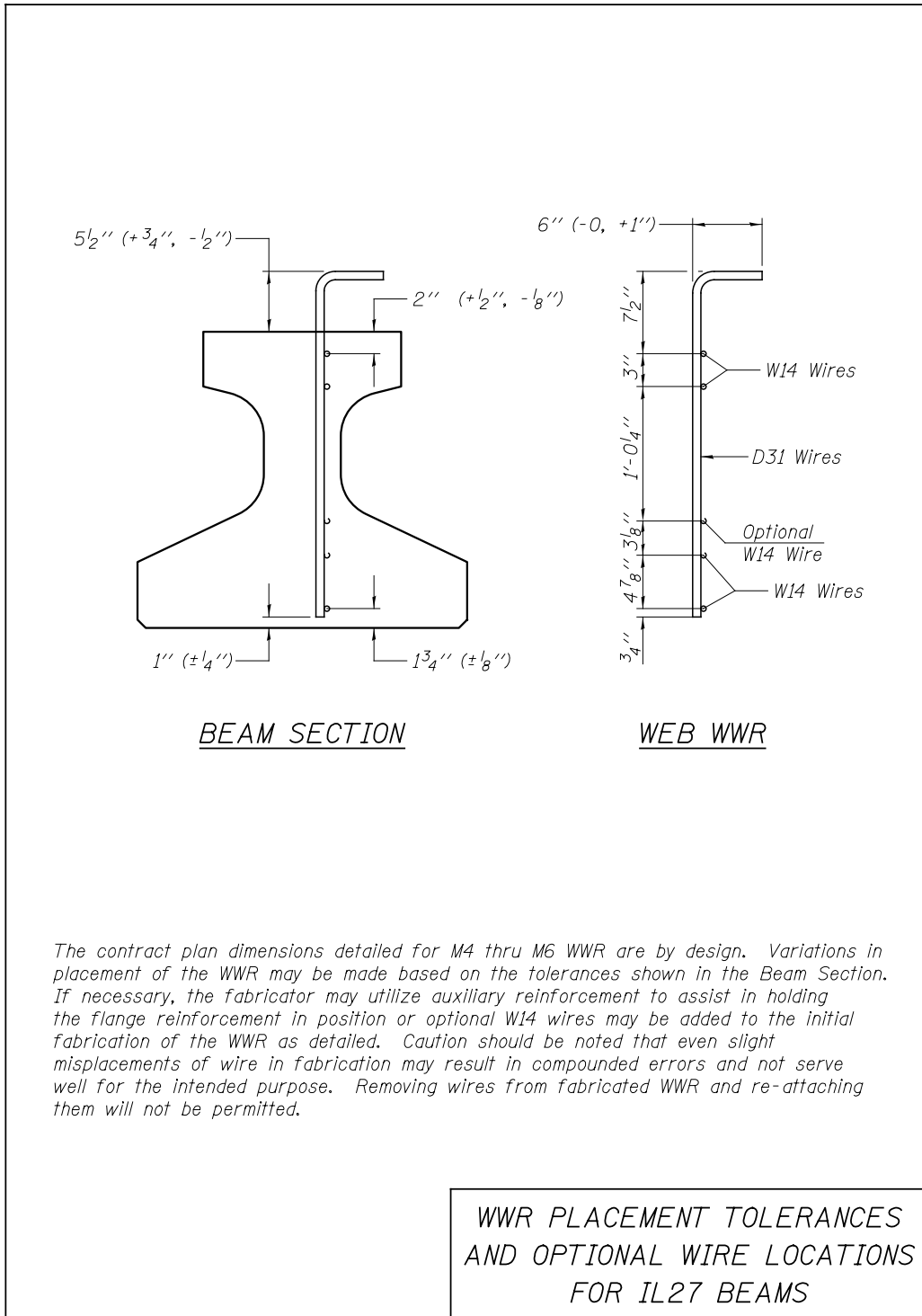
Revise Procedure to Remedy an Unacceptable Precast or Precast Prestressed Product at the Jobsite to add the following sentence to Step 8:

“The District Office or Local Agency will record the remedy solution in the bridge file for this structure to ensure the condition rating inspector has access to this information.”

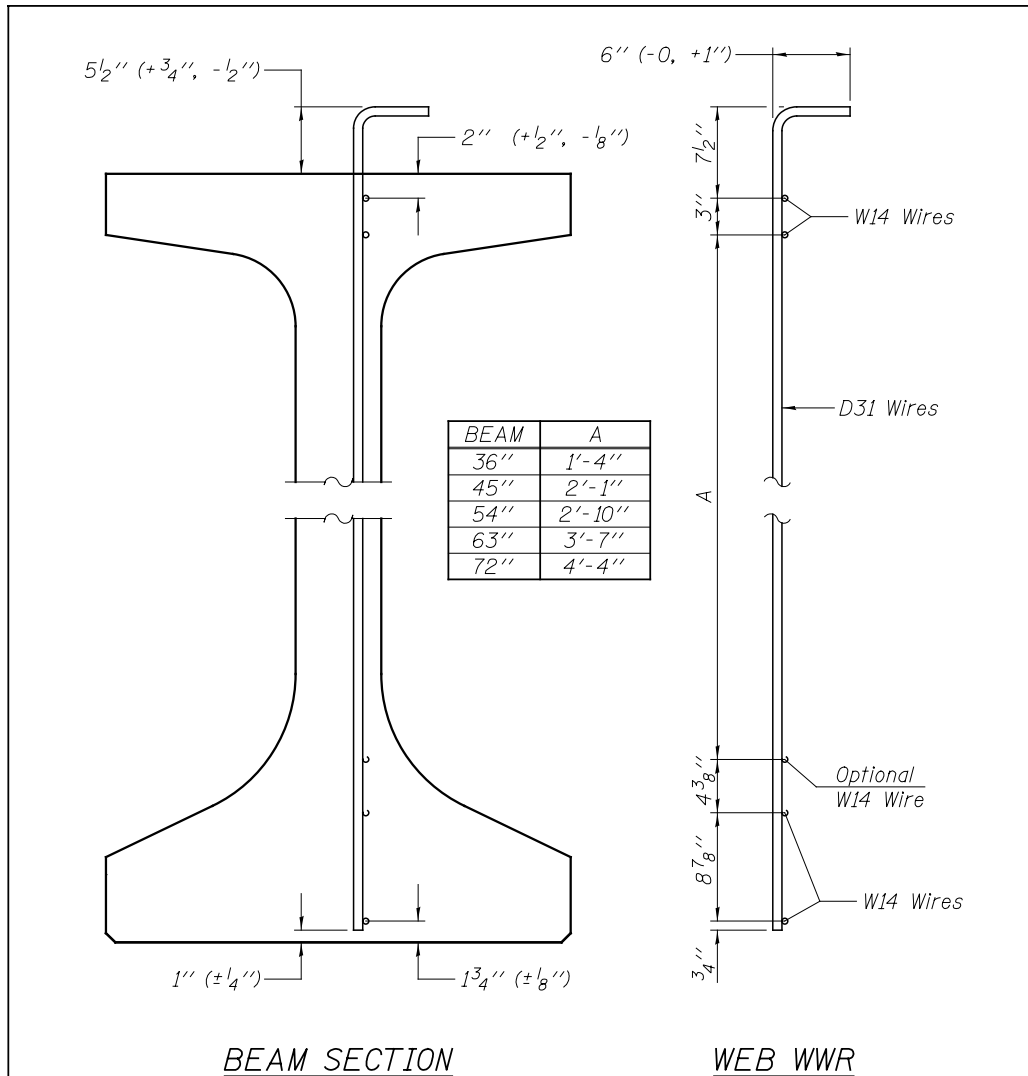
Add new figure, "Alternate Top Flange Reinforcement for 36 in. Thru 72 in. IL-Beams (English)":



Replace figure, "WWR Placement Tolerances for 27 in. IL-Beams (English)," with the following:



Replace figure, "WWR Placement Tolerances for 36 in. Thru 72 in. IL-Beams (English)," with the following:



The contract plan dimensions detailed for M5 thru M8 WWR are by design. Variations in placement of the WWR may be made based on the tolerances shown in the Beam Section. If necessary, the fabricator may utilize auxiliary reinforcement to assist in holding the flange reinforcement in position or optional W14 wires may be added to the initial fabrication of the WWR as detailed. Caution should be noted that even slight misplacements of wire in fabrication may result in compounded errors and not serve well for the intended purpose. Removing wires from fabricated WWR and re-attaching them will not be permitted.

WWR PLACEMENT TOLERANCES  
AND OPTIONAL WIRE LOCATIONS  
FOR IL36 THRU 72 BEAMS