

State of Illinois  
Illinois Department of Transportation

Addendum  
MANUAL FOR FABRICATION OF PRECAST PRESTRESSED CONCRETE PRODUCTS

Effective: June 15<sup>th</sup>, 2015

Section 4.2.1

Replace the 1<sup>st</sup> sentence of the 3<sup>rd</sup> paragraph with the following:

“The Producer shall furnish to the Inspector, as directed, one test sample of two 4 ft. (1.5 m) lengths cut from each coil or reel with a torch in a manner that will weld or fuse together the ends of the individual wires of the strand **cut-off wheel, chop saw, grinder, or equivalent. A torch shall not be used to cut samples.**”

---

Effective: August 17<sup>th</sup>, 2015

Section 3.2.3 Vibration of Concrete

Replace the 2<sup>nd</sup> sentence with the following:

“The Producer shall note the special requirements for hand vibrators in Article 1103.17(a) of the Standard Specifications when epoxy coated reinforcement is used in beams; **however, a vibrator with a non-metallic head may be coated by someone other than the manufacturer, if approved by the Inspector.**”

Section 3.4.1(2) Deck Beams

Replace the 2<sup>nd</sup> paragraph with the following:

“The top surface of deck beams detailed with no wearing surface or a bituminous wearing surface without a waterproofing membrane system shall be textured with a broom finish **or roughened in the transverse direction to an amplitude of approximately ¼ in. (6mm) with a 1/8 in. (3 mm) flat wire texture broom with maximum 1 in. (25 mm) wire spacing. Roughening the surface of fresh self-consolidating concrete may require trial and error to determine a method that produces suitable results. The thixotropic characteristics of self-consolidating concrete (see Section 3.2.3.2) may require care be taken to avoid causing the concrete to revert to its liquid state during and after roughening. Furthermore, temperature and other climatic conditions may also influence how easy or difficult it is to roughen the surface as specified. The method for roughening the surface of self-consolidating concrete shall be approved by the Inspector. Sandblasting is also an option, particularly if corrective action is needed to provide a roughened surface meeting the requirements.**”

---

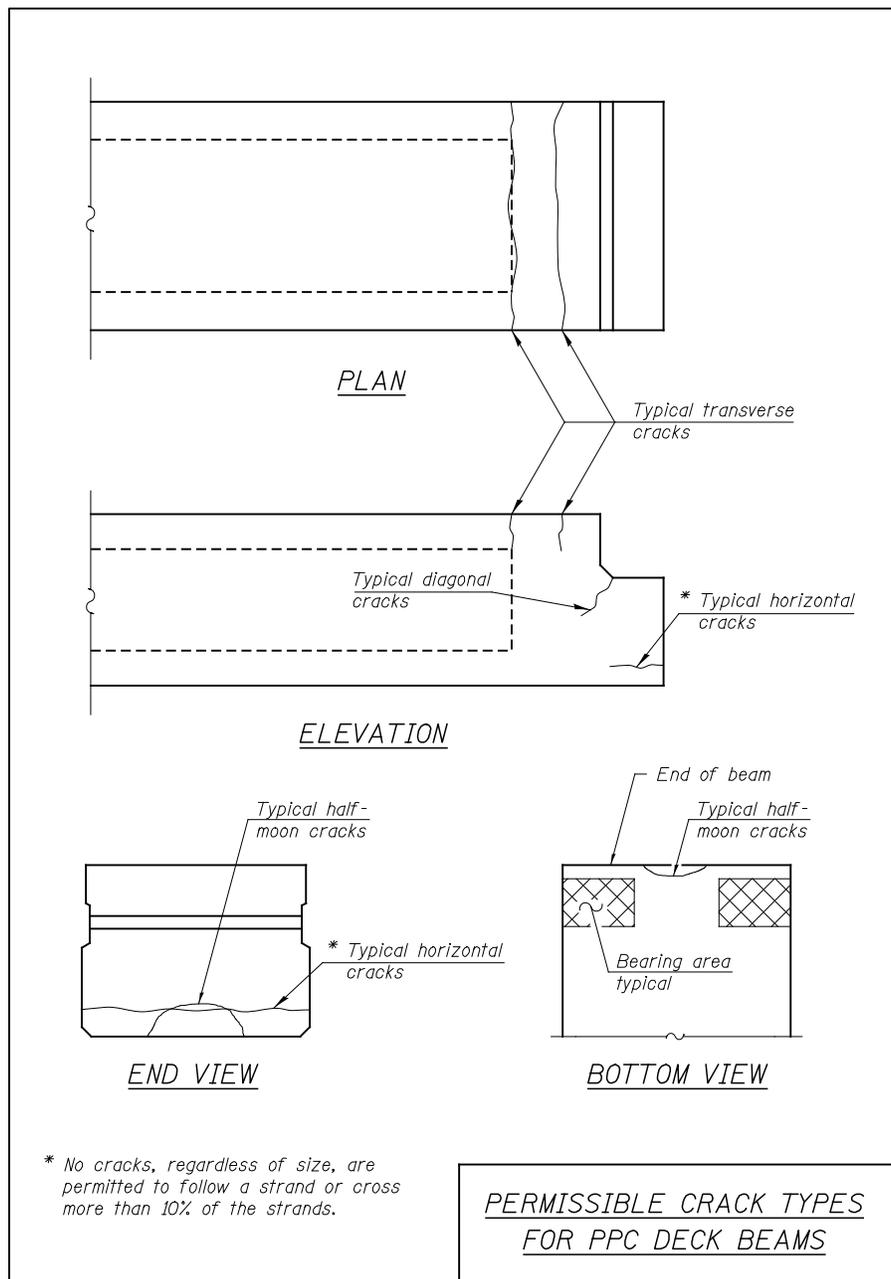
Effective: February 1, 2016

Section 3.5.4, 1. Splitting Cracks at Beam Ends

Under Permissible Crack Guidelines for Deck Beams, add item #4 as follows:

4. "Half-moon" cracks as shown in Appendix A may occur in prestressed beams when most of the permissible strand locations are utilized in the center. The maximum crack width for this type of crack is 0.007 in. (0.18 mm). In some cases, especially if the crack wraps around the underside of the beam, the concrete inside the crack may be unsound, and if that is the case, the rules in Section 3.5.3 shall be followed.

Replace figure on page A-53 with the following:



Effective: July 22, 2016

Section 3.4.2 Sealing

Replace the last sentence of the 2<sup>nd</sup> paragraph with the following:

“In addition, protective coat shall be applied to fascia I-beams, Bulb T-beams, **and IL-beams** on all the surfaces of the side exposed to view for the entire length of the beam including the adjacent side underneath (bottom surface of the bottom flange).”