ITEM 471
FRAMES, GRATES, RINGS, AND COVERS

471.1. Description. Furnish and install frames, grates, rings and covers for inlets, manholes, and other structures.

471.2. Materials.
A. Welded Steel Grates and Frames. Provide welded steel grates and frames as an assembly conforming to the member size, dimensions, and details shown on the plans. Fabricate these assemblies in accordance with Item 441, “Steel Structures.” Use steel that meets ASTM A 36 or equal.

B. Frame, Grate, Ring, and Cover Castings. Provide clean castings conforming to the shape and dimensions shown on the plans. Ensure that the castings are free from sand and blow holes or other defects and that surfaces of the castings are reasonably smooth. Remove runners, risers, fins, and other cast-on pieces from the castings, and grind these areas smooth. Cast or machine the bearing surfaces between manhole rings and covers and between grates and frames with such precision that uniform bearing is provided throughout the perimeter area of contact. Matchmark pairs of machined castings for proper identification at installation.

Provide steel castings conforming to ASTM A 27. Furnish Grade 70-36 unless otherwise specified. Provide gray iron castings conforming to ASTM A 48, Class 35B. Provide ductile iron castings conforming to ASTM A 536. Use Grade 65-45-12 unless otherwise specified. Frame, grate, ring, and cover castings must meet the proof-load testing requirements of AASHTO M 306. Use commercial type frames, rings, risers or appurtenances only with prior approval of the Engineer.

C. Documentation. Furnish mill test reports or manufacturer’s certification to the Engineer for each lot or shipment of steel and iron materials. For castings, also furnish a manufacturer’s certification stating that the casting meets the proof-load testing requirements of AASHTO M 306.

471.3. Construction. Construct and install frames, grates, rings, and covers in accordance with the details shown on the plans. Weld in accordance with Item 448, “Structural Field Welding.” Tack-weld grates and covers to the frame or ring when directed by the Engineer.

Galvanize steel castings and welded steel grates and frames in accordance with Item 445, “Galvanizing.” Galvanizing is not required for iron castings unless used in conjunction with structural steel shapes or shown on the plans.

Provide galvanized bolts and nuts in accordance with Item 445, “Galvanizing.”

471.4. Measurement. Frames, grates, rings, and covers, when a part of the complete manhole or inlet, will not be measured for payment but will be considered subsidiary to Item 465, “Manholes and Inlets.” Frames, grates, rings, and covers, when not a part of a Manhole (complete) or Inlet (complete), will be measured by the each.

471.5. Payment. When payment is required in accordance with “Measurement,” payment for frames, grates, rings, and covers will be made at the unit price bid for “Grate,” “Frame,” “Grate and Frame,” “Frame and Cover,” or “Ring and Cover.” This price is full compensation for equipment, materials, labor, tools, and incidentals.