

SEE FABRICATION NOTES ON SHEET 3



WOOD BENCH FABRICATION - STEEL BRACE

REVIEWED BY THE PARK STANDARDS COMMITTEE, AND APPROVED BY THE CHIEF OF DESIGN & CONSTRUCTION

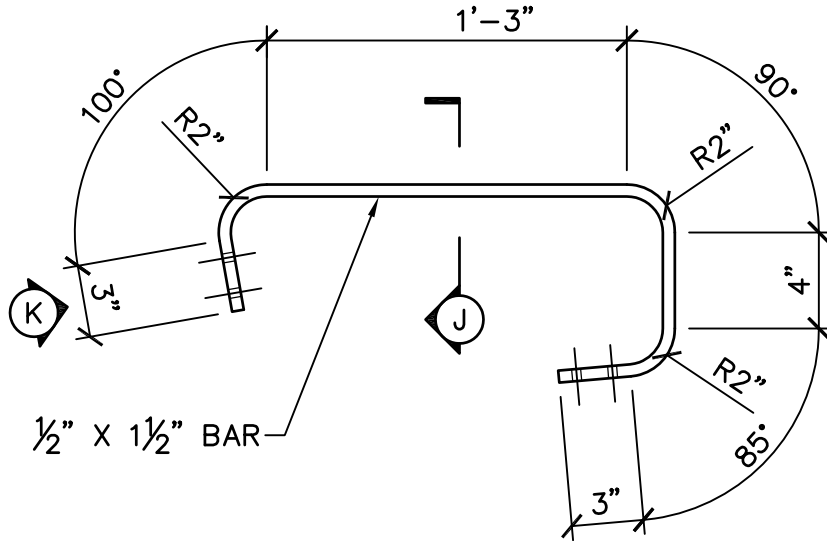
L. Gajjar

9/15/2020

EAST BAY REGIONAL PARK DISTRICT - STANDARD PLANS

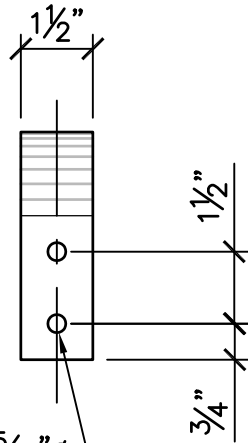
STD PLAN
503F
SHEET 1 OF 3
NOT TO SCALE

SEE FABRICATION
NOTES ON SHEET 3



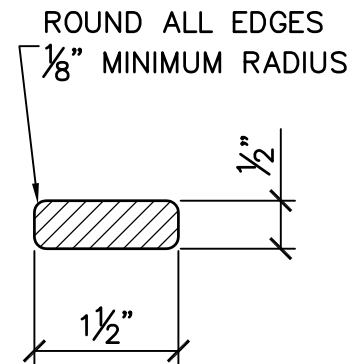
$\frac{1}{2}$ " x $1\frac{1}{2}$ " BAR

(L) SIDE VIEW



DRILL FOR $\frac{5}{16}$ " ϕ
FASTENERS - 2 HOLES
EA END OF ARMREST

(K) END VIEW (TYPICAL)



(J) SECTION



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MATERIALS

1. STEEL BAR AND ANGLE: ASTM A36.
2. HSS (HOLLOW STRUCTURAL SECTION) STEEL: ASTM A500 GRADE B.
3. WELDING ELECTRODES:
 - 3.1. E70XX
 - 3.2. COMPATIBLE WITH THE MATERIALS BEING WELDED.

WORKMANSHIP

4. DRILL OVERSIZED FASTENER HOLES PRIOR TO GALVANIZING/COATING AS NOTED BELOW:

FASTENER DIAMETER	DRILLED HOLE DIAMETER	FINISHED HOLE DIAMETER
3/8"	$3/8" + 3/32" = 15/32"$	13/32" TO 7/16"
5/16"	$5/16" + 3/32" = 13/32"$	1 1/32" TO 3/8"

VERIFY FINISHED HOLE DIAMETER AFTER GALVANIZING/COATING AND ADJUST FABRICATION TO CONFORM AS REQUIRED.

5. WELDING TO BE PERFORMED BY AWS CERTIFIED WELDERS PREQUALIFIED FOR THE WELDING TO BE PERFORMED.
6. WELDS TO BE REASONABLY SMOOTH AND UNIFORM WITH SPATTER REMOVED.
7. PRIOR TO GALVANIZING, RADIUS ALL SHARP CORNERS AND REMOVE ALL BURRS FROM DRILLED AND CUT PIECES.
8. HOT-DIP GALVANIZE (HDG) ALL METAL AFTER FABRICATION IN ACCORDANCE WITH ASTM A123. WATER QUENCHING OR CHROMATE CONVERSION COATING SHOULD BE AVOIDED AS THESE PROCESSES INTERFERE WITH PAINT ADHESION AND SURFACE PREPARATION. REFER TO ASTM D6386, STANDARD PRACTICE FOR PREPARATION OF ZINC (HOT-DIP GALVANIZED) COATED IRON AND STEEL PRODUCT FOR PAINTING.
9. PROVIDE VENT/DRAIN HOLES AS REQUIRED FOR HOT-DIP GALVANIZING. UNLESS OTHERWISE NOTED, HOLES IN VISIBLE LOCATIONS TO BE FINISHED WITH ZINC PLUGS.
10. EXCEPT WHERE NOTED, PRIME AND PAINT ALL STEEL "EBRPD BROWN METAL" PER DISTRICT STANDARD PLAN 003, PAINTING AND STAINING SPECIFICATION. PRIMER AND PAINT SHALL BE SUPPLIED BY THE FABRICATOR.



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