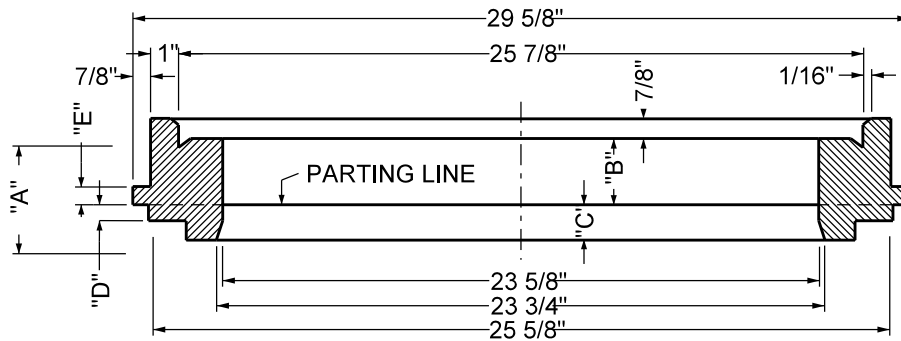


PLAN



SECTION

WELDING BETWEEN STEEL AND CAST IRON SHALL BE DONE PER MNDOT SPEC. 2471.3 USING NI-55 WELDING RODS AND AS APPROVED BY THE ENGINEER.

MAKE 2" LONG WELDS AT 1'-0" SPACES AROUND CIRCUMFERENCE OR PERIMETER.

ALTERNATE TO WELDING TO CASTINGS, A SPECIALLY FORMULATED EPOXY MAY BE USED AROUND THE TOTAL MATING SURFACE WITH THE APPROVAL OF THE CITY ENGINEER.

MATERIAL: GRAY IRON ASTM A-48

AMOUNT EXTENSION	"A"	"B" (FINISHED)	"C" (FINISHED)	"D"	"E"	WEIGHT
1 1/2"	1 1/8"	1/4"	1 1/4"	3/16"	1/2"	60
2"	1 3/8"	1/2"	1 1/2"	7/16"	3/4"	100
2 1/2"	1 7/8"	1"	1 1/2"	7/16"	3/4"	118
3"	2 3/8"	1 1/2"	1 1/2"	7/16"	3/4"	140
3 1/2"	2 7/8"	2"	1 1/2"	7/16"	3/4"	162
4"	3 3/8"	2 1/2"	1 1/2"	7/16"	3/4"	185

MNDOT SPEC. REF. 2506  
MNDOT 4108F  
NOT TO SCALE



DRW: ZTT

DATE: 1/03

APP: HRS

DATE: 12/06

CAST IRON ADJUSTING RING

STANDARD  
PLATE  
NO.  
SEWR-2011