

STEEL END SECTION SPECIFICATION

1.0 General:

- 1.1 This specification covers steel end sections used on the inlet and outlet ends of corrugated steel pipe, concrete pipe, and HDPE pipe.
- 1.2 The galvanized material used in the fabrication of the end sections shall conform to the applicable material requirements of AASHTO M 218 and ASTM A 929, or other pre-approved AASHTO or ASTM material specifications. All fabrication of the product shall occur within the United States of America.
- 1.3 The end sections shall be manufactured to show careful finished workmanship.
 - 1.3.1 There shall be no loosely formed seams.
 - 1.3.2 There shall be no ragged shear edges.
 - 1.3.3. The markings on the sheets as received from the steel supplier shall be legible.
 - 1.3.4 The metallic coating on the end section shall not be bruised, broken or otherwise damaged. If there is damage to the coating it shall be repaired in accordance with ASTM A 780.

2.0 Design:

- 2.1 Sizes shall be as shown on the plans.
- 2.2 Gages shall be as shown in the manufacturer's brochure unless shown differently on the plans.
- 2.3 The end sections shall attach to the pipe by means of a strap or rod unless shown otherwise on the plans.
- 2.4 The end sections shall have the standard toe plate. If shown on plans the end sections shall have the optional toe plate extension.

3.0 Installation:

- 3.1 The end sections shall be installed in a careful workmanship like manner.
- 3.2 The strap or rod shall be securely tightened around the pipe.
- 3.3 The toe wall shall be placed in narrow trench. The invert of the end section shall be supported evenly by the bedding.
- 3.4 The alignment of the end section shall match that of the pipe.
- 3.5 The installation shall be completed by proper compaction of the backfill around the end section.



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