



**114m mockup:**

4. **Addendum to the Dimensional Verification Plan (ADVP):** A partial mockup using at least two 47m long Skin A plates may be fabricated using the proposed ADVP methodology (see attached draft ADVP monitoring sheets). If the fabricated work is acceptable, the Department will permit the skin plates to be included in the work.

The Department will consider increasing the threshold for distorted plates to be corrected without the approval of the Engineer, hence minimizing Heat Straightening Requests (HSR's), if ABF/ZPMC complete the following:

- ZPMC takes measures to minimize welding distortion
- Only one (1) type of each skin plate with stiffeners is fabricated prior to proceeding to the subsequent plates
- Welding sequences and plate geometry are modified to minimize distortion

Based on the results of the first fabricated skin plate with stiffeners and the changes implemented for the second plate, the Department is willing to provide a higher threshold of correcting distortion without the required submittal of a HSR.

5. **Bolt Stress Measurement Procedure:** Submittal ABF-CAL-SUB-000094R02, "Fabrication Procedure - T1 Tower Lift Erection Splice Mock-Up," was returned "Approved as Noted" in State Letter 05.03.01-001278.

Once the PJP partial mockups (described in No. 1) and the initial measurements for the ADVP (described in No. 4) are completed, stiffener to skin plate welding and diaphragm to web welding may begin. Nos. 2, 3, 4 and 5 and the approval of the Dimensional Verification Plan must be completed prior to the completion of the lift 1 stiffener to skin plate welding.

Sincerely,



GARY PURSELL  
Resident Engineer

Attachment: ADVP sheets (4 pages)

cc: Peter Siegenthaler, Rick Morrow, Doug Coe, Kanu Balan, Scott Kennedy, Mark Woods  
file: 05.03.01

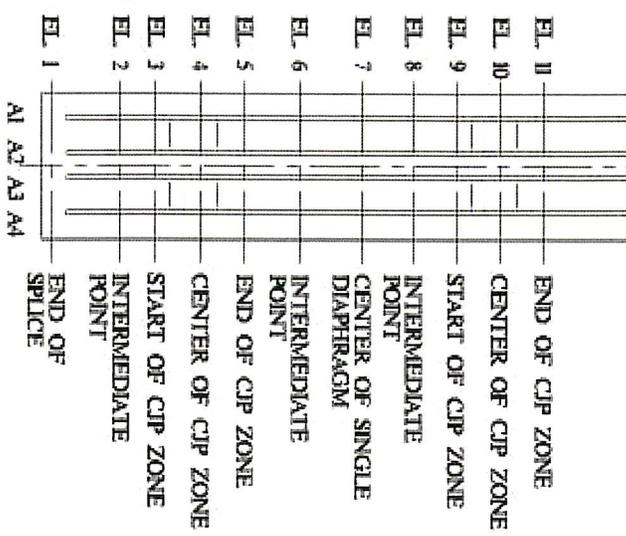


Skin Plate Flatness Checks

Lift =

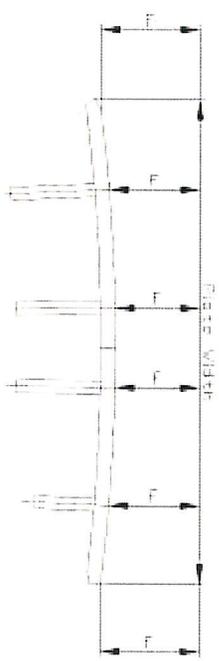
Shaft =

Face =



- Measurements to be taken:
- Prior to fit up
  - After PJP
  - After PJP HSR
  - After CJP
  - After CJP HSR
  - Prior to diaphragm fit up

Longitudinal Edge of Plate	Transverse										
	EL. 1	EL. 2	EL. 3	EL. 4	EL. 5	EL. 6	EL. 7	EL. 8	EL. 9	EL. 10	EL. 11
A1											
A2											
A3											
A4											
EOP											
Max Δ											
Go / No-Go											
Plate Width											





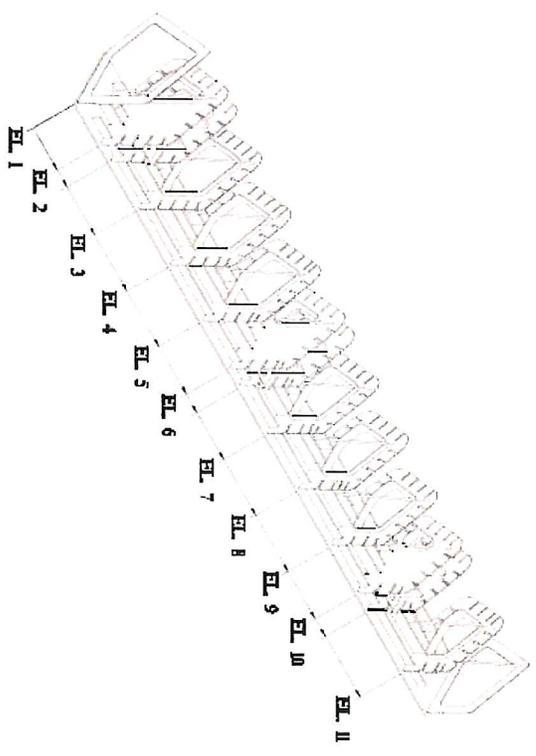
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**FLUOR**  
A JOINT VENTURE

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Longitudinal Diaphragm locations  
Allowable Tolerance

Lift =  
Shaft =



	Longitudinal										
Running	EL. 1	EL. 2	EL. 3	EL. 4	EL. 5	EL. 6	EL. 7	EL. 8	EL. 9	EL. 10	EL. 11



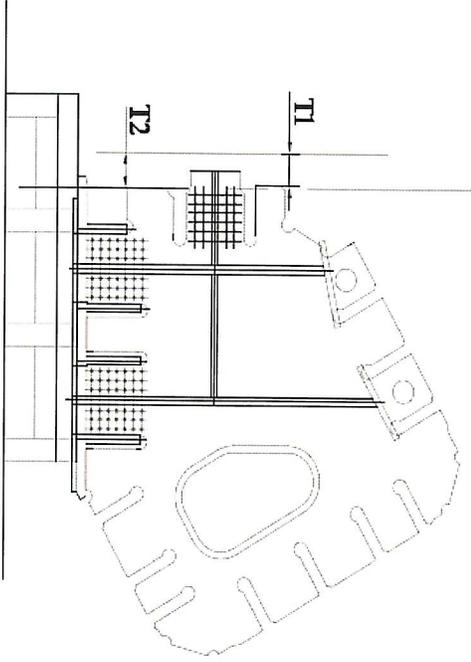
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Transverse Diaphragm Location

Lift =

Shaft =



Diaphragm Elev.	T1	T2
EL. 1		
EL. 2		
EL. 3		
EL. 4		
EL. 5		
EL. 6		
EL. 7		
EL. 8		
EL. 9		
EL. 10		
EL. 11		