

SECTION 1013 BEARING PADS:

1013-1 Preformed Fabric Pads:

Preformed fabric pads shall be composed of multiple layers of 8-ounce cotton duck impregnated and bound with high quality natural rubber or of equivalent and equally suitable materials compressed into resilient pads of uniform thickness. The number of plies shall be such as to produce the specified thickness, after compression and vulcanizing. The finished pads shall withstand compression loads perpendicular to the plane of the laminations of not less than 10,000 pounds per square inch without detrimental reduction in thickness or extrusion.

Preformed fabric pad samples will be tested by the Department.

The manufacturer certification and sampling shall conform to the requirements of Subsection 1013-3 of the specifications.

1013-2 Elastomeric Bearing Pads:

1013-2.01 General:

The work shall consist of furnishing and installing elastomeric bearing pads. Bearings shall be constructed in accordance with the details shown on the plans and as specified in these specifications.

Prior to shipment from the point of manufacture, bearings shall be packaged in such manner to ensure that during shipment and storage the bearings will be protected against damage from handling, weather, or any normal hazard. All bearings shall be stored at the work site in an area that provides protection from environmental and physical damage. When installed, bearings shall be clean and free of all foreign substances.

Bearings shall be installed to the positions and orientations shown on the plans. Bearings shall be set level, in exact positions, and must have full and even bearing on all bearing planes. Bearings surfaces located at improper elevations or set not level and true to plane shall be corrected prior to placement of bearings. Elastomeric bearing pads shall be set directly on properly prepared concrete surfaces without bedding material.

Elastomeric bearing pads shall include unreinforced pads (consisting of elastomer only) and reinforced bearings with steel or fabric laminates.

Bearings shall be furnished with the dimensions, material properties and elastomer grade required by the plans. Unless otherwise specified on the plans, bearings which have thicknesses greater than 1/2 inch shall be reinforced with steel or fabric laminates. The design method (A or B) and the design load shall also be shown on the plans, and testing shall be performed accordingly. In the absence of more specific

information, bearings shall be Grade 3, shall be an elastomer with 130 pounds per square inch shear modulus (55 durometer hardness), and shall be subjected to the load testing requirements corresponding to Method A design.

1013-2.02 Material Properties:

The sole polymer in the elastomeric compound shall be neoprene and shall be not less than 60 percent, by volume, of the total compound. The elastomer compound shall be classified as being of low temperature Grade 0, 2, or 3. The grades are defined by the testing requirements in Table 1013-1. A higher grade of elastomer, signified by a larger grade number, may be substituted for a lower one.

The elastomer compound shall meet the minimum requirements of Table 1013-1, except as otherwise specified by the Engineer. Test requirements may be interpolated for intermediate hardness. The material will be specified by its shear modulus whose measured value shall lie within 15 percent of the specified value. A consistent value of hardness shall also be supplied for the purpose of defining limits for the tests in Table 1013-1. Laminated bearings shall have a shear modulus not greater than 200 pounds per square inch. When test specimens are cut from the finished product, the physical properties shall be permitted to vary by 10 percent from those specified in Table 1013-1. All material tests shall be carried out at 73 ± 4 degrees F, unless otherwise noted. Shear modulus tests shall be carried out using the apparatus and procedures described in Annex A1 of ASTM D4014.

Table 1013-1 ELASTOMERIC COMPOUND REQUIREMENTS				
Note that ASTM D1043 refers to "modulus of rigidity" while ASTM D4014 refers to "shear modulus." The word "stiffness" is used here to cover both terms.				
Physical Properties				
D2240	Hardness: Shore A Durometer	45 to 75		
		50±5	60±5	70±5
D412	Ultimate Elongation: min. %	400	350	300
	Tensile Strength: min. psi	2250		
Heat Resistance				
D573: 70 hrs at 212 °F	Change in Durometer Hardness: maximum points	15		
	Change in Tensile Strength: maximum %	-15		
	Change in Ultimate Elongation: maximum %	-40		
Compression Set				
D395, Method B	22 hr at 212°F: maximum %	35		

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Table 1013-1 ELASTOMERIC COMPOUND REQUIREMENTS		
Ozone		
D1149	100 pphm ozone in air by vol., 20 % strain, 100 ± 2°F, 100 hr, mounting IAW ASTM D518 (Procedure A)	No Cracks
Low Temperature Brittleness		
D746 Procedure B	Grade 0: No Test Required Grade 2: No Test Required Grade 3: Brittleness at -40°F	- - No Failure
Instantaneous Low Temperature Thermal Stiffening		
D1043	Grade 0: Tested at -25°F Grade 2: Tested at -25°F Grade 3: Tested at -40°F	(1) (1) (1)
Low Temperature Crystallization		
Quad Shear Test As Described	Grade 0: No Test Required Grade 2: 7 Days at 0°F Grade 3: 14 Days at -15°F	(2) (2) (2)
Notes:		
<p>(1) Stiffness at test temperature shall not exceed four times the stiffness measured at 73 °F.</p> <p>(2) Stiffness at test time and temperature shall not exceed four times the stiffness measured at 73°F with no time delay. The stiffness shall be measured with a quad shear test rig in an enclosed freezer unit. The test specimens shall be taken from a randomly selected bearing. A ± 25 % strain cycle shall be used, and a complete cycle of strain shall be applied with a period of 100 seconds. The first 3/4 cycle of strain shall be discarded, and the stiffness shall be determined by the slope of the force deflection curve for the next 1/2 cycle of loading.</p>		

Certification, sampling and testing shall conform to the requirements of Subsection 1013-3 of the specifications.

1013-2.03 Plain and Fabric-Reinforced Elastomeric Bearing Pads:

Pads less than or equal to 1/2 inch in thickness shall be all elastomer. Pads greater than 1/2 inch thick shall be laminated. The stacking of individual laminated pads to attain thicknesses over 1/2 inch will not be permitted; however, cold bonding of individual laminated pads will be permitted providing the bond between the pads has a minimum peel strength of 20 pounds per inch of width.

Laminated pads shall consist of alternate layers of elastomer and fabric reinforcement bonded together. The top and bottom layers of reinforcement shall be uniformly covered with a layer of elastomer. The thickness of elastomer cover shall not vary.

Laminated pads shall have reinforcement every 1/2 inch through the entire thickness. Fabric reinforcement shall be single-ply at top and bottom surfaces of the pad and double-ply within the pad. Fabric shall be free of folds and ripples and shall be parallel to the top and bottom surfaces. Variations in the location of the reinforcement from its theoretical location in excess of the specified Fabrication Tolerances will be cause for rejection.

Pads of all-elastomer or with fabric reinforcement may be cut from large sheets. Cutting shall be performed in such a manner as to avoid heating of the material, to produce a smooth edge with no tears or other jagged areas, and to cause as little damage to the material as possible. The cutting method shall not cause any separation of the fabric from the elastomer for laminated bearings.

Flash tolerance, finish, and appearance shall meet the requirements of the latest edition of the Rubber Handbook published by the Rubber Manufacturers Association, Inc., RMA F3 and T.063 for molded bearings and RMA F2 for extruded bearings.

The bond between elastomer and fabric shall be such that when a sample is tested for separation, it shall have a minimum peel strength of 30 pounds per inch of width.

Fabric reinforcement shall be woven from 100 percent glass fibers of E-type yarn with continuous fibers. The minimum thread count in either direction shall be 25 threads per inch. The fabric shall have either a crowfoot or an 8 Harness Satin weave. Each ply of fabric shall have a breaking strength of not less than 800 pounds per inch of width in each thread direction when 3 inch by 36 inch samples are tested on split drum grips. The bond between double plies shall have a minimum peel strength of 20 pounds per inch of width. Holes in the fabric will not be permitted.

1013-2.04 Steel Reinforced Elastomeric Bearing Pads:

At the contractor's option, steel-reinforced elastomeric bearing pads may be furnished in lieu of fabric-reinforced elastomeric bearing pads that are 1/2 inch and over in thickness.

Steel-reinforced elastomeric bearing pads shall conform to the requirements for steel-laminated elastomeric bearings as specified in ASTM D4014 and the following:

- (A) The thickness of each bearing pad shall be as shown on the project plans. The bearings shall consist of (N-1) internal elastomer laminates and N steel laminates, where N is equal to the bearing pad thickness in inches shown on the project plans divided by 1/2 inch. The steel laminates shall be 14 gage and shall be spaced every 1/2 inch, center-to-center. The top and bottom steel laminates shall have

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1/4 inch of elastomer cover as measured from the center of the steel laminate to the pad surface;

- (B) The elastomer clear cover thickness from the surface to the steel laminates at the sides of the bearings shall be 1/8 inch. If guide pins or other devices are used to control the side cover over the steel laminates, any exposed portions of the steel laminates shall be sealed by vulcanized patching;
- (C) Steel laminates used for reinforcement shall be made from rolled mild steel conforming to ASTM A36, ASTM A1011, or ASTM A1008, Grade 40. Holes in plates for manufacturing purposes will not be permitted unless they have been accounted for in the design, as shown on the plans;
- (D) Bearings with steel laminates shall be cast as a unit in a mold and shall be bonded and vulcanized under heat and pressure. The mold finish shall conform to standard shop practice. The internal steel laminates shall be sandblasted and cleaned of all surface coatings, rust, mill scale, and dirt before bonding, and shall be free of sharp edges and burrs. External load plates (sole plates) shall be protected from rusting by the manufacturer, and, preferably, shall be hot bonded to the bearing during vulcanization. Bearings that are designed to act as a single unit with a given shape factor must be manufactured as a single unit; and
- (E) Steel laminated bearings shall develop a minimum peel strength of 40 pounds per inch of width.

1013-2.05 Fabrication Tolerances:

Plain pads and laminated bearings shall be built to the specified dimension within the tolerances listed in Table 1013-2.

**Table 1013-2
FABRICATION TOLERANCES**

Parameters	Tolerances	
	Minus	Plus
1. Overall Height: Design Thickness 1-1/4 inch or less Design Thickness over 1-1/4 inch	0 0	+1/8 inch +1/4 inch
2. Overall Horizontal Dimensions: 36 inches or Less Over 36 inches	0 0	+1/4 inch +1/2 inch
3. Thickness of Individual Layers of Elastomer at any Point Within the Bearing	± 20 % of Design Value but no more than ± 1/8 inch	
4. Parallelism with Opposite Face: Top and Bottom Sides	0.005 Radians 0.02 Radians	
5. Position of Exposed Connection Members, Holes, Slots, or Inserts	± 1/8 inch	
6. Edge Cover: Embedded Laminates or Connection Members	0	+1/8 inch
7. Thickness: Top and Bottom Cover Layer (if required)	0	+1/8 inch
8. Size: Holes, Slots, or Inserts	± 1/8 inch	

1013-3 Certification and Testing:

1013-3.01 General Requirements:

(A) General:

A lot shall consist of a single type of bearing of the same design, material and thickness, delivered to the project site at the same time. Unless otherwise specified on the plans, certification and testing shall be as described in Subsections 1013-3.01(B) and (C) of the specifications.

(B) Testing by Manufacturer:

The contractor shall furnish the Engineer with Certificates of Analysis, conforming to the requirements of Subsection 106.05 of the specifications, from the manufacturer certifying that the bearings to be furnished conform to all specified requirements.

Each reinforced bearing shall be marked in indelible ink or flexible paint. The marking shall consist of the order number, lot number, bearing identification number, and elastomer type and grade number. The marking shall be on the face that is visible after erection of the bridge.

The ambient temperature tests on the elastomer described in Subsection 1013-3.02(A) of the specifications shall be conducted for the

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materials used in each lot of bearings. In lieu of performing a shear modulus test for each batch of material, the manufacturer may elect to provide certificates from tests performed within the preceding year on identical formulations. Certificates of Analysis from the manufacturer shall be provided for each lot of reinforcement.

All three low temperature tests described in Subsection 1013-3.02(C) of the specifications shall be conducted on Grade 3 material used in each lot of bearings, with the following exception. In lieu of the low temperature crystallization tests on each lot of bearings to be used, the manufacturer may choose to provide Certificates of Analysis from low-temperature crystallization tests performed within the preceding year on identical Grade 3 material.

Instantaneous thermal stiffening tests shall be conducted on material of Grades 0 and 2. Low temperature brittleness and crystallization tests are not required for Grade 0 or 2 materials.

Every finished bearing shall be visually inspected in accordance with Subsection 1013-3.02(D) of the specifications.

Every steel reinforced bearing shall be subjected to the short-term load test described in Subsection 1013-3.02(E) of the specifications.

From each lot of bearings designed by Method B of AASHTO Bridge Specifications Division I, Article 14.4, a random sample shall be subjected to the long-term load test described in Subsection 1013-3.02(F) of the specifications. The sample shall consist of at least one bearing chosen randomly from each size and material batch and shall comprise at least 10 percent of the lot. If one bearing of the sample fails, all the bearings of that lot shall be rejected, unless the manufacturer elects to test each bearing of the lot at no additional cost to the Department. In lieu of this random sampling procedure, the Engineer may require every bearing of the lot to be tested.

(C) Testing by Contractor:

A minimum of two sample pads from every 100 pads furnished, or portion thereof, will be selected at random by the Engineer at the project site for testing. A minimum of one sample pad will be selected from each lot. Bearing pads marked or otherwise presented to the Department as being test pads shall not be tested. Samples shall consist of complete pads as detailed on the project plans and as specified herein. The contractor shall furnish additional complete pads to replace those taken for testing. Pads shall be available for testing at least three weeks in advance of intended use.

The contractor shall, at no additional cost to the Department, have the sample elastomeric bearing pads tested by a testing laboratory. The testing laboratory shall be approved by the Engineer, shall be not affiliated with the bearing pad manufacturer, and shall be under the

supervision of a registered professional engineer. The contractor shall furnish the Engineer with Certificates of Analysis, conforming to the requirements of Subsection 106.05 of the specifications, from the approved testing laboratory certifying that the bearings tested conform to the specified requirements for dimensional tolerances and material properties. The following tests shall be performed as appropriate and be supported with Certificates of Analysis:

- (1) Ambient temperature test;
- (2) Heat resistance test;
- (3) Low temperature test;
- (4) Visual inspection;
- (5) Shear modulus test; and
- (6) Bond and peel strength tests

The heat resistance tests shall be performed in accordance with Subsection 1013-3.02(B) of the specifications.

Shear stiffness tests shall be performed on material from a random sample of the finished bearings in accordance with Subsection 1013-3.02(G) of the specifications.

Cold bonding of individual laminated pads and peel strength tests shall be performed in accordance with Subsection 1013-3.02(H) of the specifications.

1013-3.02 Testing Requirements:

(A) Ambient Temperature Tests on the Elastomer:

The elastomer used shall satisfy the limits prescribed in Table 1013-1 for durometer hardness, tensile strength, and ultimate elongation. The bond to the reinforcement, if any, shall also satisfy the bond requirements in Subsection 1013-2.03 or 1013-2.04 of the specifications and shall be tested in accordance with ASTM D429, Method B. The shear modulus of the material shall be tested at 73 degrees F using the apparatus and procedure described in Annex A1 of ASTM D4014. It shall fall within 15 percent of the specified value.

(B) Heat Resistance Tests on the Elastomer:

The elastomer shall satisfy the limits prescribed in Table 1013-1 for the change in durometer hardness, change in tensile strength, and change in ultimate elongation, as well as for compression set and ozone.

(C) Low Temperature Tests on the Elastomer:

Grade 3 elastomer shall be subjected to low temperature brittleness tests (ASTM D746), instantaneous low temperature stiffness tests (ASTM D1043), and low temperature crystallization tests (ASTM D4014). Grades 0 and 2 elastomers shall be subjected to instantaneous low

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temperature stiffness tests (ASTM D1043). The tests shall be performed in accordance with the requirements of Table 1013-1, and the compound shall satisfy all limits for its grade.

(D) Visual Inspection of the Finished Bearing:

Every finished bearing shall be inspected for compliance with dimensional tolerances and for overall quality of manufacture. In steel reinforced bearings, the edges of the steel shall be protected everywhere from corrosion.

(E) Short-Duration Compression Tests on Bearings:

The bearing shall be loaded in compression to 1.5 times its maximum design load. That load shall be held constant for five minutes, removed, and reapplied for another five minutes. The bearing shall be examined visually while under the second loading. If the bulging pattern suggests layer thickness or parallelism outside the specified tolerances or a poor laminate bond, the bearing shall be rejected. If there are three or more separate surface cracks greater than 0.08 inches wide and 0.08 inches deep, the bearing shall be rejected.

(F) Long-Duration Compression Tests on Bearings:

The bearing shall be loaded in compression to 1.5 times its maximum design load for a minimum period of 15 hours. If, during the test, the load falls below 1.3 times the maximum design load, the test duration shall be increased by the period of time for which the load is below this limit. The bearing shall be examined visually at the end of the test while it is still under load. If the bulging pattern suggests layer thickness or parallelism outside the specified tolerances or a poor laminate bond, the bearing shall be rejected. If there are three or more separate surface cracks greater than 0.08 inches wide and 0.08 inches deep, the bearing shall be rejected.

(G) Shear Modulus Tests on Material From Bearings:

The shear modulus of the material in the finished bearing shall be evaluated by testing a specimen cut from it using the apparatus and procedures described in Annex A1 of ASTM D4014, or, if directed by the Engineer, a comparable nondestructive stiffness test may be conducted on a pair of finished bearings. The shear modulus shall fall within 15 percent of the specified value. If the test is conducted on finished bearings, the material shear modulus shall be computed from the measured shear stiffness of the bearings, taking account of the influence on shear stiffness of bearing geometry and compressive load.

(H) Bond and Peel Strength Tests:

Cold bonding between individual laminated pads, if used, shall be tested in accordance with the requirements of California Test 663.

The peel strength test shall be performed in accordance with ASTM D429, Method B, for both fabric and steel reinforced pads.

1013-4 Installation:

Bearings shall be placed on surfaces that are plane to within 1/16 inch and horizontal to within 0.01 radians. Exterior plates of the bearing shall not be welded unless at least 1-1/2 inches of steel exists between the weld and the elastomer. In no case shall the elastomer or the bond be subjected to temperatures higher than 400 degrees F.