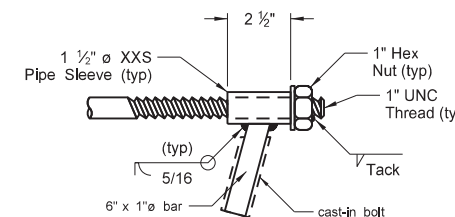
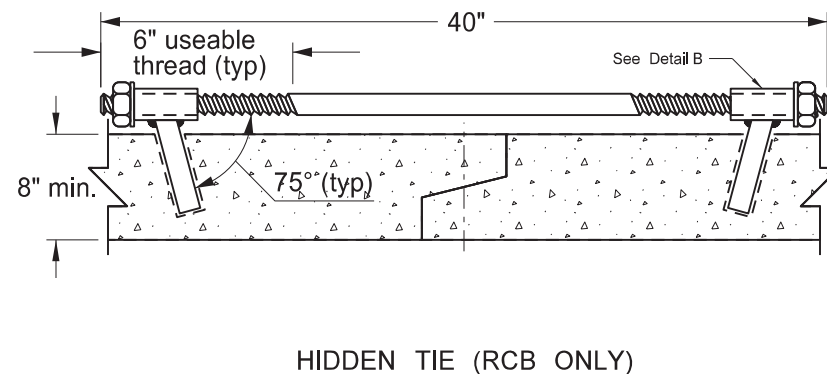
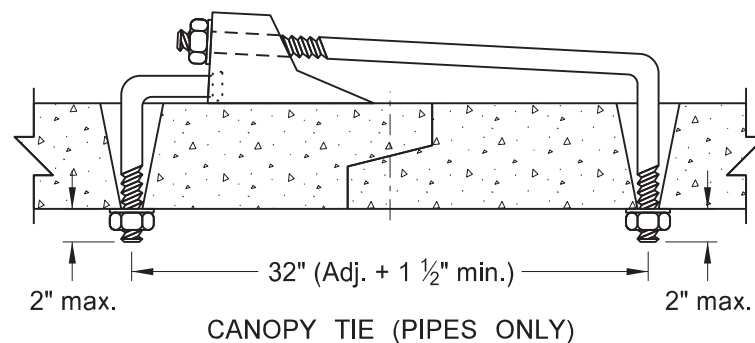
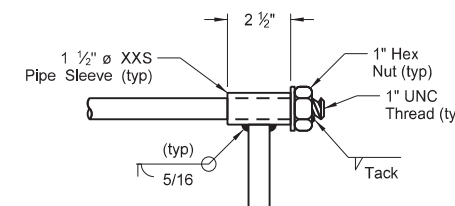
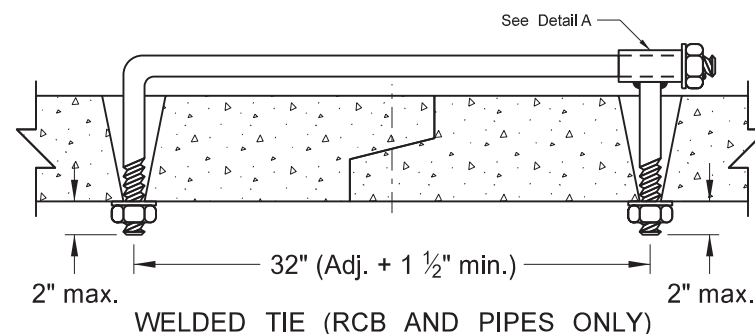
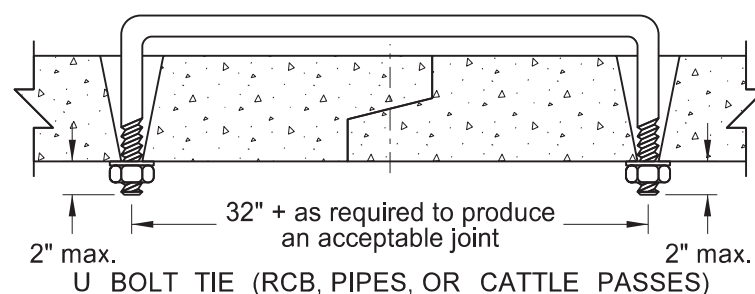
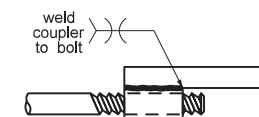
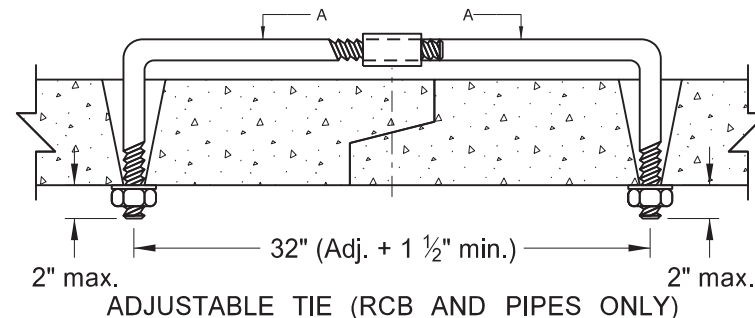
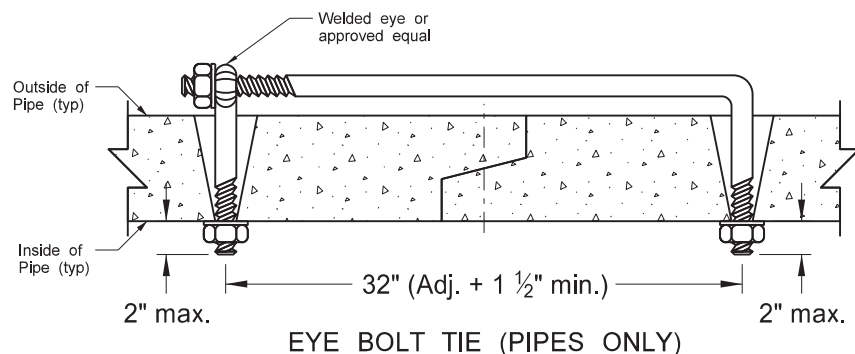
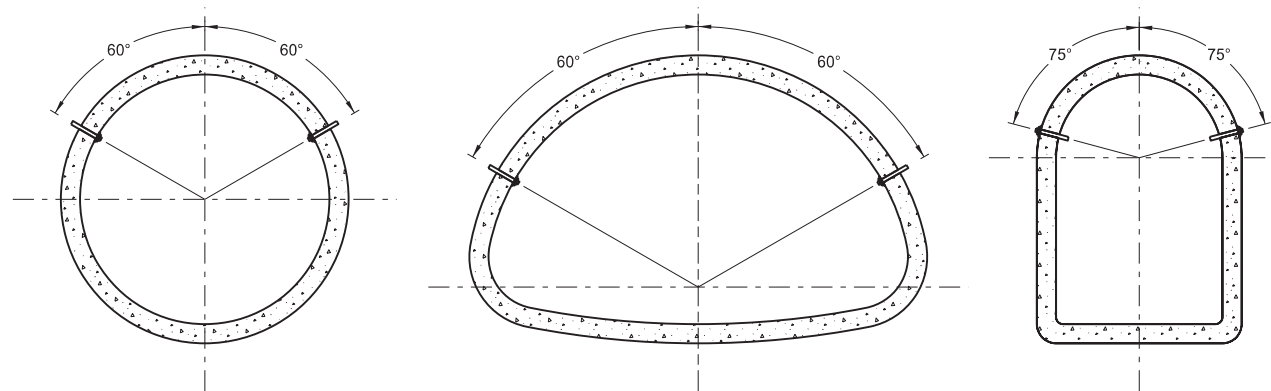
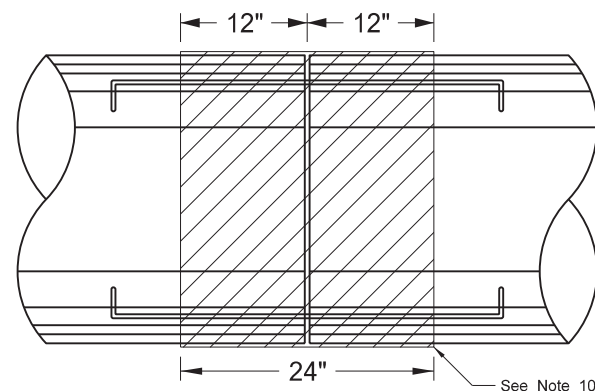


CONCRETE PIPE, CATTLE PASS, OR PRECAST CONCRETE BOX CULVERT TIES

REQUIRED SIZE OF TIE BOLTS		
Pipe Size	Thread ϕ	XXS Pipe Sleeve Inner ϕ
18" - 24"	$\frac{5}{8}$ " See note 3	$\frac{3}{4}$ "
30" - 66"	$\frac{3}{4}$ "	1"
72" - 120"	1"	1 $\frac{1}{4}$ "
RCB/Cattle Pass		



- NOTES:
- The pipe size listed is the inside diameter of round pipe or the equivalent diameter of pipe arch.
 - Insert pipe ties from the inside of the pipes and grout in place for Cattle Pass and Jacked and Bored pipes. Jacked and bored pipes with a diameter of 24" or less do not require pipe ties.
 - Nuts and washers are not required on Jacked and Bored pipes or pipes with a 24" diameter or less. Insert and grout tie bars into place where nuts and washers are not used.
 - Do not use pipe ties to pull the pipe or RCB sections tight. The ties are only for holding sections together.
 - Use only tie bolt assemblies that have been hot dip galvanized in accordance with ASTM A 153.
 - Holes in pipes to accommodate tie bolts can be precast or drilled. Tapered holes are permitted when precast. Use holes that have a diameter $\frac{1}{4}$ " larger than the diameter of the thread. In precast RCB's, use holes that contain cast-in bolt sleeves with an inside diameter of 1 $\frac{1}{4}$ ".
 - Select the type of tie bolt used from those shown.
 - Include the cost of precasting or drilling the required holes and furnishing and installing the tie bolts in the price bid for the appropriate conduit or RCB pay item.
 - Tie all centerline and approach RCP culvert joints. Tie the first three joints including the end section of all free ends of storm drain systems. Free ends are defined as any storm drain end which does not terminate at an inlet or manhole. Outfall culverts with end sections which drain adjacent ditches are examples of free ends.
 - Place joint wrap prior to installing ties. Firmly secure the wrap around the full perimeter. For concrete pipes, overlap the joint by 12" in both directions. For box culverts, use a waterproof membrane that meets ASTM C877 (Type III). Provide a membrane that is a minimum of 12" wide and center it at the joint. Provide a minimum overlap of 2.5" at the seams.
 - Use tie bolts that conform to ASTM A 36. Use heavy hex nuts that conform to ASTM A 563. Use washers that conform to ASTM F 436, Type 1. Use welded pipe sleeves and cast-in bolt sleeves that conform to ASTM A 53, Grade B.
 - Tie RCB's at locations shown on the plans.



NORTH DAKOTA DEPARTMENT OF TRANSPORTATION	
3-18-14	
REVISIONS	
DATE	CHANGE
7-21-15	Note 8
6-5-17	Notes 2-11, Table, Title, Labels
8-11-21	Notes 2-12, Table, Label

