

## GENERAL SPECIFICATIONS FOR THE FABRICATION OF MANHOLE, SEWER AND VALVE BOX STEEL RISER RING

### 1- MATERIAL

- A. Riser Ring:**  
Hot rolled mild steel  
Specifications ASTM A36 or G-40.21-44W  
Minimum thickness: 1/2"
- B. Impact absorbing strips:**  
**Stainless Steel**  
Serial 300; Finish 2B  
40% of extension before breaking  
Thickness: 13GA  
Width: 3/4"  
Welded at 45° degrees to insure absorbing.
- C. Socket set screws:**  
Cone point  
Diameter: 3/8"  
Length: 1" : Manhole and Sewer  
3/4" : Valve box
- D. Glue: Brand LOCTITE**  
Permanent Thread locker 262 or equivalent

N.B. The mill test of each material is available or request.

### 2- STANDARD RULES & CODES

Canadian association of guidelines (ACNOR)  
W59 and AWS standard are applied

### 3- FORMING

All rings and anti-rotation notches are cold formed.

### 4- TOLERANCE

All dimensions without exception must have a maximum tolerance of ± 0.50 mm.

### 5- ASSEMBLY

Upper and bottom rings are jointed by impact absorbing stainless steel strips welded at 45° that allow the rings to adjust to the height of frame and cover usury and machining variations.

### 6- SECURITY

Bottom ring will be drilled and taped in at least three equidistant locations to allow set screws insertion.

### 7- PAINTING

one shop coat of industrial black primer is to be applied on all carbon steel surfaces.

### 8- MACHINING

Riser ring surfaces, making contact with cover and frame machined parts, are to be machined with a 250 finishing.

### 9- IDENTIFICATION

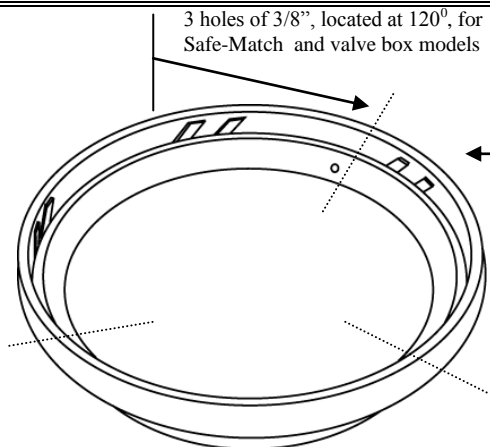
Riser ring upper part must bear a stamping or name plate of the manufacturer and/or the registered trade mark.

### 10- INSTALLATION

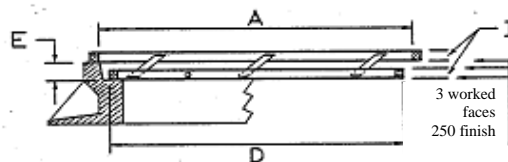
Frame and cover surfaces making contact with the riser ring have to be free of any particle or aggregate to ensure proper seating. The frame must be drilled in at least three equidistant locations of 3/16" depth to allow set screws insertion. To complete the installation, the ring has to be bolted into the frame.. ( See installation Procedure)

### 11- EQUIVALENCE

" The Ring O Pave" riser rings meet all these specifications by any other steel riser ring, bearing the same characteristics, can be installed if previously approved by the undersigned.



3 to 12 strips, depending on diameter and models

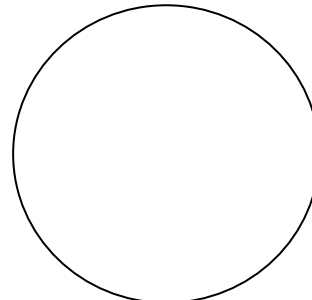


- A :** Cover exterior diameter +1/4" (+6.7mm)  
**D :** Frame interior diameter -1/4" (-6.7mm)  
**E :** Depth of the surface of the frame where cover is sitting  
**I :** Height to be heightened

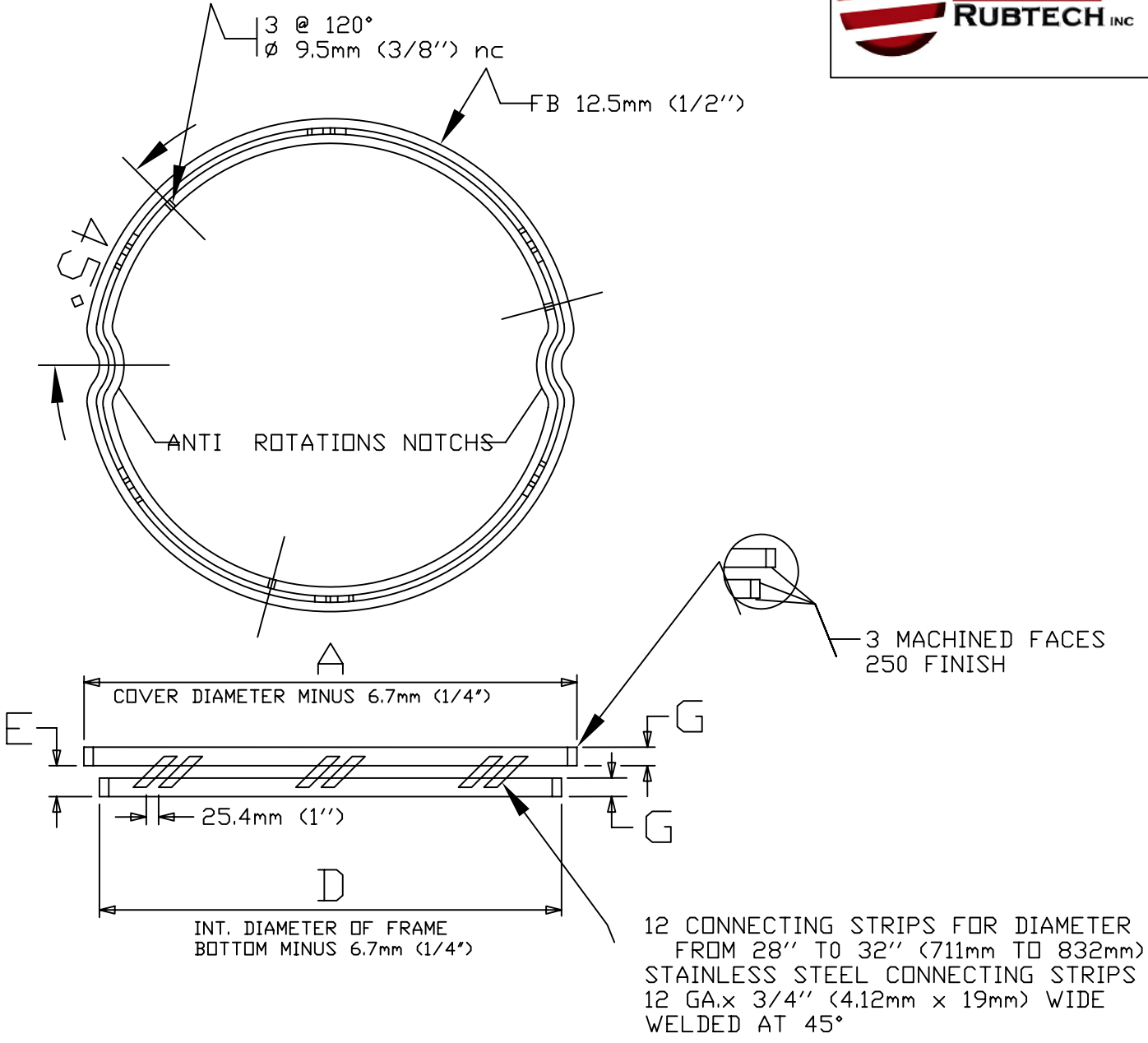
**Note:** All the dimensions must be supplied by the city

Town : \_\_\_\_\_

Date : \_\_\_\_\_ Signature : \_\_\_\_\_

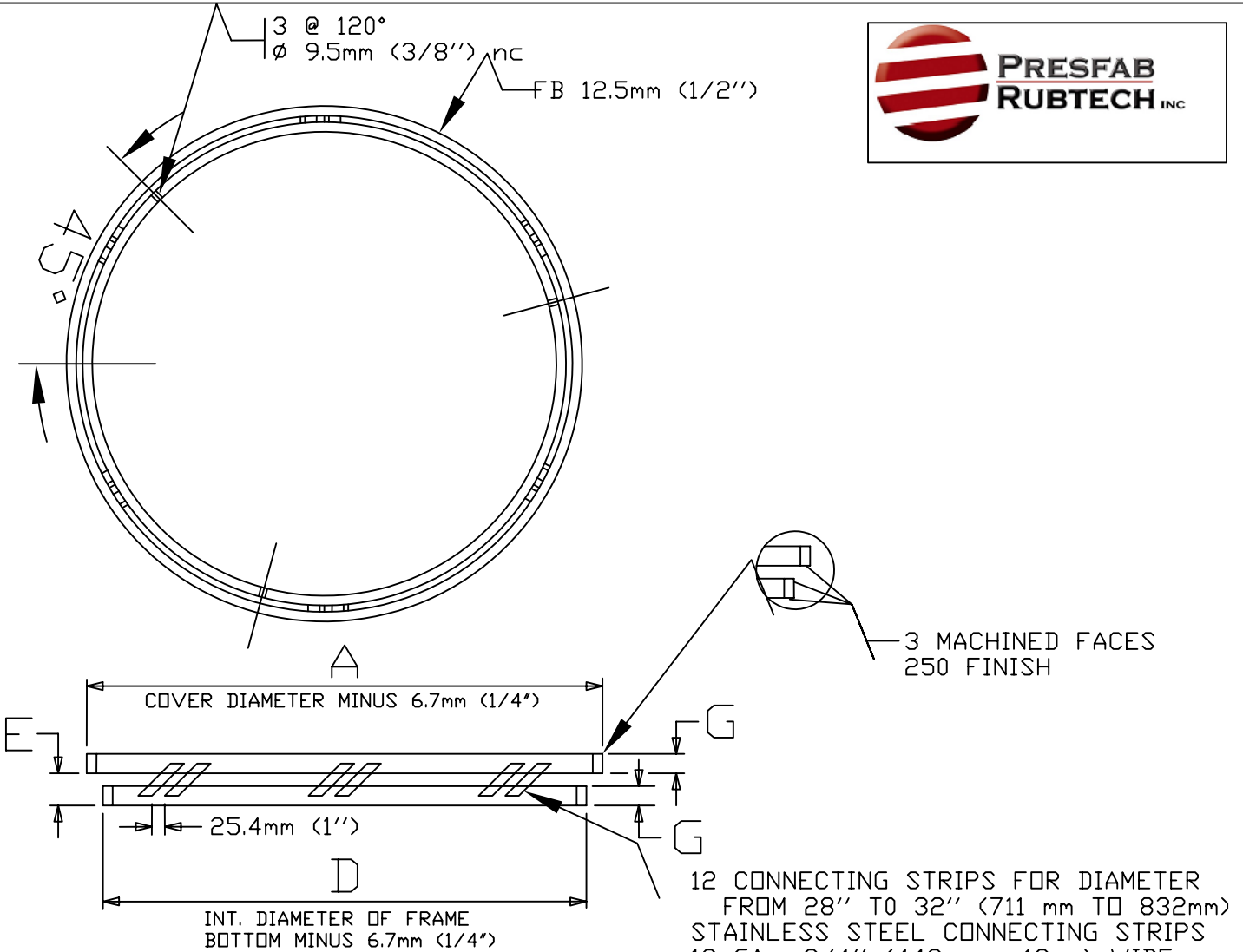


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NOTE: DIMENSIONS TO BE GIVEN BY CUSTOMER  
 E: INTERIOR DEPTH OF FRAME  
 I : HEIGHT TO RISE

<h1 style="margin: 0;">RING-O-PAVE™</h1> <p style="margin: 0;">STEEL RISING RING FOR CATCH BASIN</p>		
<p style="margin: 0;">MODEL: <u>SAFE MATCH</u></p>		
<p>Date: 15 April 93</p>	<p>Drawing No: 1170-2</p>	<p>Ref: CQ34REV2</p>



NOTE: DIMENSIONS TO BE GIVEN BY CUSTOMER  
 E: INTERIOR DEPTH OF FRAME  
 I : HEIGHT TO RISE

NUMBER OF CONNECTING STRIPS		
CONNECTING STRIPS	DIAMETER IMPERIAL (INCHES)	DIAMETER METRIC (mm)
3	4" TO 9" 3/4	101.5 TO 247.7
4	10" TO 19" 3/4	254.0 TO 510.7
6	20" TO 23" 3/4	508.0 TO 603.3
8	24" TO 27" 3/4	609.6 TO 704.9
12	28" TO 32" 3/4	711.2 TO 831.9
16	33" TO 38"	838.2 TO 965.2

**RING-O-PAVE™**  
 STEEL RISING RING FOR MANHOLE AND VALVE BOX

MODEL: SAFE MATCH

Date 15 April 93	Drawing No: 1175-2	Ref: CQ32REV2
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