

ENGINEERING SPECIFICATION
PULTRUDED DYNAFORM[®] FIBERGLASS STRUCTURAL SHAPES

October 25, 2004

Revision 1

SECTION 06610

FIBERGLASS REINFORCED PLASTICS (FRP) FABRICATIONS

PULTRUDED FIBERGLASS STRUCTURAL SHAPES

PART 1 - GENERAL

1.0 GENERAL

1.1 REFERENCES:

The publications listed below (latest revision applicable) form a part of this specification to the extent referenced herein. The publications are referred to within the text by the designation only.

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM) Test Methods:

ASTM D-638-Tensile Properties of Plastics

ASTM D-790-Flexural Properties of Unreinforced and Reinforced Plastics

ASTM D-2344-Apparent Interlaminar Shear Strength of Parallel Fiber Composites by Short Beam Method

ASTM D-696-Coefficient of Linear Thermal Expansion for Plastics

ASTM E-84-Surface Burning Characteristics of Building Materials

1.2 CONTRACTOR SUBMITTALS:

- A. The CONTRACTOR shall furnish shop drawings of all fabricated structural systems and accessories in accordance with the provisions of this Section.
- B. The CONTRACTOR shall furnish manufacturer's shop drawings clearly showing material sizes, types, styles, part or catalog numbers, complete details for the fabrication of and erection of components including, but not limited to, location, lengths, type and sizes of fasteners, clip angles, member sizes, and connection details.
- C. The CONTRACTOR shall submit the manufacturer's published literature including structural design data, structural properties data, corrosion resistance tables, certificates of compliance, test reports as applicable, and design calculations for systems not sized or designed in the contract documents, sealed by a Professional Engineer.

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- D. The CONTRACTOR may be requested to submit sample pieces of each item specified herein for acceptance by the ENGINEER as to quality and color. Sample pieces shall be manufactured by the method to be used in the WORK.

1.3 QUALITY ASSURANCE:

- A. All items to be provided under this Section shall be furnished only by manufacturers having a minimum of ten (10) years experience in the design and manufacture of similar products and systems. Additionally, if requested, a record of at least five (5) previous, separate, similar successful installations in the last five (5) years shall be provided.
- B. Manufacturer shall offer a 3 year limited warranty on all FRP products against defects in materials and workmanship.
- C. Manufacturer shall be certified to the ISO 9001-2000 standard.
- D. Manufacturer shall provide proof of certification from at least two other quality assurance programs for its facilities or products (UL, DNV, ABS, USCG, AARR).

1.4 PRODUCT DELIVERY AND STORAGE

- A. Delivery of Materials: Manufactured materials shall be delivered in original, unbroken pallets, packages, containers, or bundles bearing the label of the manufacturer. Adhesives, resins and their catalysts and hardeners shall be crated or boxed separately and noted as such to facilitate their movement to a dry indoor storage facility.
- B. Storage of Products: All materials shall be carefully handled to prevent them from abrasion, cracking, chipping, twisting, and other types of damage. Store adhesives, resins and their catalysts and hardeners in dry indoor storage facilities between 70 and 85 degrees Fahrenheit (21 to 29 degrees Celsius) until they are required.

PART 2 - MATERIALS

2.1 MANUFACTURER:

- A. Structural shapes shall be Dynaform[®] as manufactured by

Fibergate Composite Structures Inc.

5151 Belt Line Road, Suite 700

Dallas, Texas 75254-7028 USA

(800) 527-4043 (972) 250-1530 Fax

2.2 GENERAL:

- A. All structural shapes are to be manufactured by the pultrusion process with a glass content minimum of 45%, maximum of 55% by weight. The structural shapes shall be composed of fiberglass reinforcement and resin in qualities, quantities, properties, arrangements and dimensions as necessary to meet the design requirements and dimensions as specified in the Contract Documents.
- B. Fiberglass reinforcement shall be a combination of continuous roving, continuous strand mat, and surfacing veil in sufficient quantities as needed by the application and/or physical properties required.
- C. Resins shall be {DYNAFORM[®] ISO, non-fire retardant isophthalic polyester; ISOFR, fire retardant isophthalic polyester or VEFR, fire retardant vinyl ester, (*choose one*)} with chemical formulation necessary to provide the corrosion resistance, strength and other physical properties as required.
- D. All finished surfaces of FRP items and fabrications shall be smooth, resin-rich, free of voids and without dry spots, cracks, crazes or unreinforced areas. All glass fibers shall be well covered with resin to protect against their exposure due to wear or weathering.
- E. All pultruded structural shapes shall be further protected from ultraviolet (UV) attack with 1) integral UV inhibitors in the resin and 2) a synthetic surfacing veil to produce a resin rich surface.
- F. All FRP products shall have a tested flame spread rating of 25 or less per ASTM E-84 Tunnel Test.

- 2.3 Pultruded structural shapes are to have the minimum longitudinal mechanical properties listed below:

Property	ASTM Method	Value	Units
Tensile Strength	D-638	30,000 (206)	psi (MPa)
Tensile Modulus	D-638	2.5 x 10 ⁶ (17.2)	psi (GPa)
Flexural Strength	D-790	30,000 (206)	psi (MPa)
Flexural Modulus	D-790	1.8 x 10 ⁶ (12.4)	psi (GPa)
Flexural Modulus (Full Section)	N/A	2.8 x 10 ⁶ (19.3)	psi (GPa)
Short Beam Shear (Transverse)	D-2344	4,500 (31)	psi (MPa)
Shear Modulus (Transverse)	N/A	4.5 x 10 ⁵ (3.1)	psi (GPa)
Coefficient of Thermal Expansion	D-696	4.4 x 10 ⁻⁶ (8.0 x 10 ⁻⁶)	in/in/°F (cm/cm/°C)
Flame Spread	E-84	25 or less	N/A

PART 3 - EXECUTION

3.0 FABRICATION

- A. Measurements: Structural Shapes supplied shall meet the minimum dimensional requirements as shown or specified. The Contractor shall provide and/or verify measurements in field for work fabricated to fit field conditions as required by manufacturer to complete the work. Determine correct size and locations of required holes or coping from field dimensions before structural shape fabrication.
- B. Sealing: All shop fabricated cuts or drilling shall be coated with vinyl ester resin to provide maximum corrosion resistance. All field fabricated cuts or drilling shall be coated similarly by the contractor in accordance with the manufacturer's instructions.
- C. Hardware: Type 316 stainless steel bolts shall be provided.

3.1 INSPECTION

- A. Shop inspection is authorized as required by the Owner and shall be at Owner's expense. The fabricator shall give ample notice to Contractor prior to the beginning of any fabrication work so that inspection may be provided. The structural shapes shall be as free, as commercially possible, from visual defects such as foreign inclusions, delamination, blisters, resin burns, air bubbles and pits.