



Standard Specification for Underground Precast Concrete Utility Structures¹

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1. Scope

1.1 This specification covers the recommended design criteria and manufacturing practices for monolithic or sectional precast concrete utility structures. Concrete pipe and box culverts are not covered under this specification. Also, precast concrete manholes covered in Specification C 478 are excluded from this specification.

2. Referenced Documents

2.1 ASTM Standards:

- A 82 Specification for Steel Wire, Plain, for Concrete Reinforcement²
- A 184/A184M Specification for Fabricated Deformed Steel Bar Mats for Concrete Reinforcement²
- A 185 Specification for Steel Welded Wire, Fabric, Plain, for Concrete Reinforcement²
- A 496 Specification for Steel Wire, Deformed, for Concrete Reinforcement²
- A 497 Specification for Steel Welded Wire Fabric, Deformed, for Concrete Reinforcement²
- A 615/A615M Specification for Deformed and Plain Billet-Steel Bars for Concrete Reinforcement²
- A 616/A616M Specification for Rail-Steel Deformed and Plain Bars for Concrete Reinforcement²
- A 617/A617M Specification for Axle-Steel Deformed and Plain Bars for Concrete Reinforcement²
- A 706/A706M Specification for Low-Alloy Steel Deformed Bars for Concrete Reinforcement²
- C 31 Practice for Making and Curing Concrete Test Specimens in the Field³
- C 33 Specification for Concrete Aggregates³
- C 39 Test Method for Compressive Strength of Cylindrical Concrete Specimens³
- C 42 Test Method for Obtaining and Testing Drilled Cores and Sawed Beams of Concrete³
- C 94 Specification for Ready-Mixed Concrete³
- C 150 Specification for Portland Cement⁴

- C 192 Practice for Making and Curing Concrete Test Specimens in the Laboratory³
- C 231 Test Method for Air Content of Freshly Mixed Concrete by the Pressure Method³
- C 260 Specification for Air-Entraining Admixtures for Concrete³
- C 330 Specification for Lightweight Aggregates for Structural Concrete³
- C 478 Specification for Precast Reinforced Concrete Manhole Sections⁵
- C 494 Specification for Chemical Admixtures for Concrete³
- C 595M Specification for Blended Hydraulic Cements⁴
- C 618 Specification for Fly Ash and Raw or Calcined Natural Pozzolan for Use as a Mineral Admixture in Portland Cement Concrete³
- C 857 Practice for Minimum Structural Design Loading for Underground Precast Concrete Utility Structures⁵
- 2.2 *American Concrete Institute Standard:*
ACI 318 Building Code Requirements for Reinforced Concrete⁶
- 2.3 *American Welding Society Standard:*
AWS-D1.4 Structural Welding Code Reinforcing Steel⁷

3. Terminology

- 3.1 Definition of Term Specific to this Standard:
 - 3.1.1 *utility structure*—a structure that is used by electric, gas, communication, or similar industries.

4. Ordering Information

4.1 Unless otherwise stipulated by the purchaser in his order, a structure produced in accordance with this specification and constructed in accordance with the design drawings approved by the purchaser shall be acceptable.

5. Materials

5.1 *Cement*—Portland cement shall conform to the requirements of Specification C 150 or shall be portland blast-furnace slag cement or portland pozzolan cement conforming to the requirements of Specification C 595M.

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² *Annual Book of ASTM Standards*, Vol 01.04.

³ *Annual Book of ASTM Standards*, Vol 04.02.

⁴ *Annual Book of ASTM Standards*, Vol 04.01.

⁵ *Annual Book of ASTM Standards*, Vol 04.05.

⁶ Available from the American Concrete Institute, P.O. Box 19150, Detroit, Mich., 48219.

⁷ Available from the American Welding Society (AWS), P.O. Box 351040, 550 LeJune Rd., N. W., Miami, FL 33135.

5.2 *Aggregates*—Aggregate shall conform to Specification C 33 and light-weight aggregate shall conform to Specification C 330, except that the requirements for grading shall not apply.

5.3 *Admixtures*—Admixtures may be used provided such admixtures are not injurious to other products used in the concrete.

5.3.1 *Chemical Admixtures*—Chemical admixtures shall conform to Specification C 494.

5.3.2 *Fly Ash and Pozzolanic Admixture*—Fly ash or other pozzolanic admixtures shall conform to Specification C 618.

5.3.3 *Air-Entraining Admixtures*—Air-entraining admixtures conforming to Specification C 260 shall be used when there is a risk that the concrete may be exposed to a freeze-thaw cycle. The concrete mixture shall contain 5.5 ± 1.5 % air by volume as determined by Specification C 231.

5.4 *Water*—Water used for curing, washing aggregate, or mixing concrete shall be clean and free of injurious amounts of oil, acids, alkalis, salts, organic materials, or other substances that may be incompatible with concrete or steel.

5.5 *Steel Reinforcement*:

5.5.1 *Wire Reinforcement*—Wire reinforcement shall conform to Specifications A 82 or A 496.

5.5.2 *Wire Fabric Reinforcement*—Wire fabric reinforcement shall conform to Specifications A 185 or A 497.

5.5.3 *Bar Reinforcement*—Bar reinforcement shall conform to Specifications A 184/A 184M, A615/A 615M, A616/A 616M, A617/A 617M, or A706/A 706M.

6. Manufacture

6.1 *Forms*—Forms shall be accurately constructed and strong enough to maintain the structure's dimensions within the tolerances given in Section 8. Forms should be constructed in such a manner as to minimize the seepage of water. All casting surfaces shall be smooth nonporous material.

6.1.1 *Cleaning and Oiling*—Forms shall be cleaned before each use. New forms shall be free of paint or other protective coatings that might cling to the surface of the structure. Releasing agents applied to the form to aid in breaking the bond between the form and the concrete shall not be injurious to the concrete.

6.2 *Reinforcement*—Steel reinforcement shall conform to the requirements of this specification and shall be securely positioned in the form to maintain design concrete cover given in Section 7 during concrete placement. All chairs, bolsters, braces, and spacers in contact with form and reinforcing rod shall be of material that will not deteriorate.

6.3 *Mixture*—The aggregates shall be sized, graded, proportioned, and thoroughly mixed in a batch mixer with proportions of cement and water as will produce a homogeneous concrete having the required specified compressive strength. If Ready-Mix concrete is used, it shall be in accordance with Specification C 94.

6.4 *Concrete Placement*—Concrete shall be deposited as nearly as practicable in its final position. Concrete shall be placed in the form at a rate such that the concrete is plastic at all times and flows readily into all parts of the form and around all reinforcement steel and embedded fixtures without segregation of materials. Concrete that has partially hardened or has

been contaminated by foreign material shall not be deposited in the form.

6.5 *Curing*—Structures shall be cured by an accepted industry method that will develop the required 28-day compressive strength without affecting the long-term durability of the concrete.

7. Design Requirements

7.1 The elastic method of structural design or the ultimate strength method of reinforced concrete design as outlined in ACI 318, shall be used to design the concrete sections, including the reinforcement required, when the structure is subjected to the loading conditions covered in Practice C 857.

7.2 *Access Openings*—The structural design shall take into consideration the number, placement, and size of access openings.

7.3 *Floors*—The minimum floor thickness resulting from slope shall be considered as the nominal floor thickness in the design of the structure.

7.4 *Terminators, Knockouts, and Sumps*—Duct terminators, knockouts, and sumps shall be designed to carry the loads imposed upon them. The basic structure shall be designed to carry all imposed loads with knockouts removed.

7.5 *Placement of Reinforcement*—The design concrete cover for reinforcing bars, mats, or fabric shall be not less than $\frac{3}{4}$ in. (19 mm) subject to the requirements of Section 8.

7.6 *Concrete Strength*—The minimum specified compressive strength for design shall be 3000 psi (21 MPa) at 28 days of age. Compressive-strength tests should be made in accordance with Practices C 31 and C 192 and Test Methods C 39 and C 42.

7.7 *Joints*—Joints in sectional precast concrete structure shall be designed so as to be self-aligning when assembling sections of the structure.

7.7.1 The manufacturer shall provide a single joint design on all units of the same size and type to ensure interchangeability.

7.8 *Lifting Devices*—Design of lifting devices shall conform to requirements as specified in the Lifting Devices Section of Practice C 857.

8. Permissible Variations

8.1 *Dimensional Tolerances*—The length, width, height, or diameter measurements of the structure when measured on the inside surfaces shall not deviate from design dimensions by more than the following:

Dimensions	Tolerance
0 to 5 ft (0 to 1.52 m)	$\pm \frac{1}{4}$ in. (± 6 mm)
5 to 10 ft (1.52 to 3.05 m)	$\pm \frac{3}{8}$ in. (± 10 mm)
10 to 20 ft (3.058 to 6.10 m)	$\pm \frac{1}{2}$ in. (± 13 mm)
20 ft (6.10 m) and over	as agreed upon between the supplier and purchaser

8.2 *Squareness Tolerance*—The inside of the precast concrete component shall be square as determined by diagonal measurements. The difference between such measurements shall not exceed the following:

Measured Length	Allowable Difference
0 to 10 ft (0 to 3.05 m)	$\frac{1}{2}$ in. (13 mm)
10 to 20 ft (3.05 to 6.10 m)	$\frac{3}{4}$ in. (19 mm)

20 ft (6.10 m) and over

as agreed upon between the
supplier and purchaser

the finished structure shall be subject to inspection at anytime
by the purchaser or his representative.

8.3 Joint Surfaces—The inside joint seam gap between two sections placed together without a joint sealant shall not exceed $\frac{3}{8}$ in. (9.5 mm).

8.4 Insert Location—Insert locations for attachments in each component shall not deviate individually or cumulatively more than $\pm \frac{1}{8}$ in. (3.18 mm) from dimensions on specification drawings.

8.5 Reinforcement Location—With reference to thickness dimension of wall or slab, reinforcement shall be within $\pm \frac{1}{4}$ in. (6.3 mm) of the design location but in no case shall the cover be less than $\frac{3}{4}$ in. (19 mm). The reinforcement spacing shall not vary more than one tenth of the designed bar spacing nor exceed $1\frac{1}{2}$ in. (38 mm) in variation, except for welded wire mesh which shall conform to Specifications A 185 or A 497.

8.6 Slab and Wall Thickness—The slab and wall thickness shall not be less than that shown in the design by more than 5 % or $\frac{3}{16}$ in. (4.8 mm), whichever is greater. A thickness greater than that required in the design shall not be a cause for rejection.

9. Repairs

9.1 Precast concrete structures may be repaired. Repairs shall be performed by the manufacturer, in such a manner as to ensure that the repaired structure conforms to the requirements of this specification.

10. Inspection

10.1 The quality of materials, process of manufacture, and

11. Rejection

11.1 Precast concrete structures or sections of structures shall be subject to rejection upon failure to conform to any of the specified requirements contained herein, or if any of the following imperfections occur:

11.1.1 Defects that indicate any imperfect concrete mixing and molding, or

11.1.2 Surface defects indicated by honeycombed or open-texture and damaged areas where such defects would affect the structural adequacy.

12. Certification

12.1 At the request of the purchaser, the manufacturer shall, prior to the actual delivery of a structure, furnish a statement giving the source and type of cement, the source and specific gravities of the aggregates, the concrete mix proportions, strength, type, amount, and name of admixtures and mill certificates for the reinforcement steel used in manufacture.

13. Product Marking

13.1 The weight shall be marked on the outside of each component section.

13.2 The purchaser may in his order request additional information to be marked on the component section.

13.3 The method of marking shall be agreed upon between the purchaser and the supplier prior to ordering.

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