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ALUMINUM BOX CULVERT

CAN BE HANDLED AND ASSEMBLED WITHOUT CRANE

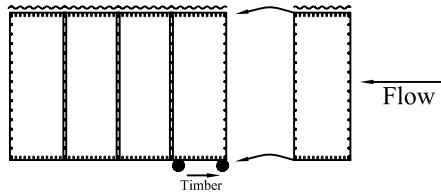
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BOX CULVERT ASSEMBLY STEPS

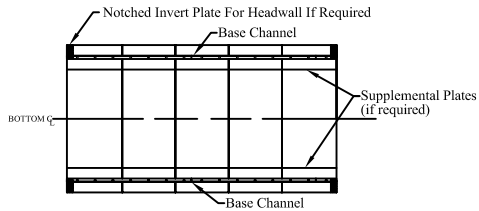
Step 1: Review shop drawings and product details.

Step 2: Assemble invert plates if more than one plate is required for width.

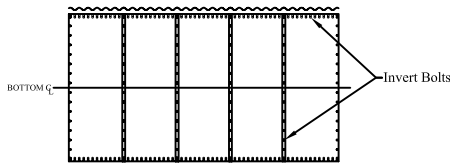
Step 3: Start assembly of invert at the downstream end making sure the plate is oriented as shown on the assembly drawing. (Refer to the shop drawing for this step). Lift upstream end of plate and block with timbers, lapping the next panel over and bolting hand tight.



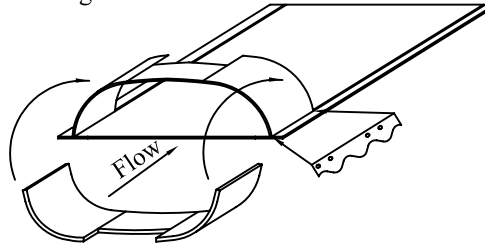
Step 4: Layout supplemental plates (if required), then layout the base angle and hand tighten nuts.



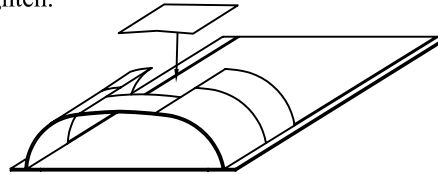
Step 5: After loose assembly of invert, tighten all nuts to proper torque.



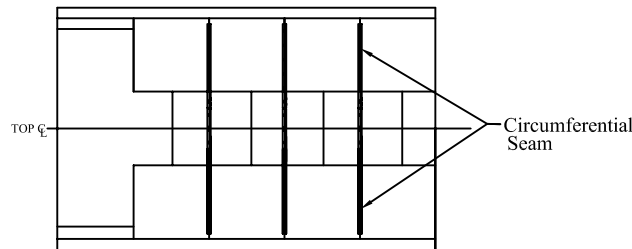
Step 6: Start assembly of shell at upstream end with panels required to establish stagger pattern. Do not put bolts into holes that will be used for reinforcing rib bolts. Hand tighten, then flip first ring into place on to the invert. Place the scallop closure plates on vertical leg of base angle.



Step 7: Place next ring of plates, place bolts and hand tighten the longitudinal plate seams. Place bolts and nuts into arch and vertical angle leg and hand tighten.

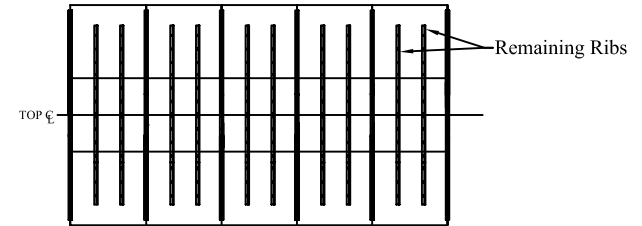


Step 8: Place both haunch ribs and crown ribs at the circumferential plate seam laps.



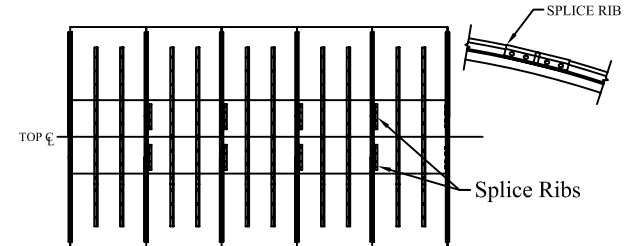
Step 9: Repeat steps 6 and 7 to the end of structure.

Step 10: Place and bolt remaining ribs in between ribs already placed in step 7.



Step 11: Tighten all shell and rib nuts to proper torque.

Step 12: Attach splice ribs and tighten.



Step 13: Attach toe plates.

