Section I: Castings and Aluminum Covers	Effective Date: 01-01-2025
I 1 Valve Boxes	
I 2 Service Clean-out Box and Lid	
13 Manhole Casting/ Standard Ring and Cover	
I 4 Access Covers/ Aluminum	



I 1 - VALVE BOXES:

Effective Date: 01-01-2025

SPECIFICATION/ MATERIAL:

Valve boxes shall meet or exceed the performance specifications of:

- Valve boxes shall be screw type.
- Lid shall be marked "WATER" or "SANITARY SEWER" (to match service type application).
- Produced for gray cast iron.
- ASTM Standards A48, Class 30-35.
- Shall be designed, constructed and capable of withstanding a minimum H-20 type loading.
- Shall be cleaned according to good foundry practice, chipped and ground as needed to remove fins and rough places on castings.
- Shall have a paint or seal-coated finish.
- The lid shall fit flush in the top of the box without forcing and shall not rock.
- Shall have a non-tip lid with a minimum skirt of one and one-half (1-1/2"), for a total lid height of three and one-half (3-1/2") inches.
- Shall have a five and one quarter (5 1/4") inch shaft.

REQUIREMENTS:

- · ISO 9001 or later certification.
- Affidavit of compliance.
- · All castings shall be true and free of holes.
- All castings shall have manufacturers cast mark and part number clearly visible on each component.
- Fixed riser extensions shall be available for the box top section to be considered for approval.
- Riser sections shall be continuously compatible to achieve any desired height in one (1") and two (2") inch increments plus or minus a half (1/2") inch.
- Locking covers shall be available.





MANUFACTURER:

- STAR PIPE PRODUCTS
- TYLER PIPE/ UNION FOUNDRY CO
- SIP INDUSTRIES SERIES: 6000

RESTRICTIONS:



12 - SERVICE CLEAN-OUT BOX & LID:

Effective Date: 01-01-2025

SPECIFICATION/ MATERIAL:

Service clean-out box and lid shall meet or exceed the performance specifications of:

- Box and lid shall be gray cast iron or ductile iron.
- ASTM Standards A48 Class 30B (gray cast iron).
- ASTM Standards A536 Grade 65-45-12 (ductile).
- Shall be designed, constructed and capable of withstanding a minimum H-20 type loading.
- Shall be cleaned according to good foundry practice chipped and ground as needed to remove fins and rough places on castings.
- Bearing surfaces shall be machined to ensure a proper fit and prevent rattling and fit flush without forcing.
- Lid shall be labeled with "CO" for clean-out.
- A nominal 6" diameter by 12" minimum cast iron box and cover.

REQUIREMENTS:

- ISO 9001 or later certification.
- Affidavit of compliance.
- All castings shall be true and free of holes.
- All castings shall have manufacturers cast mark and part number clearly visible on each component.



MANUFACTURER:

- U.S. FOUNDRY & MFG. CORP.
- STAR PIPE PRODUCTS
- CAPITOL FOUNDRY OF VIRGINIA
- GENERAL FOUNDRIES, INC.
- SIP INDUSTRUSTRIES

RESTRICTIONS:



13 - MANHOLE CASTINGS/ STANDARD RING & COVER:

Effective Date: 01-01-2025

SPECIFICATION/ MATERIAL:

Manhole castings, standard ring and cover, shall meet or exceed the performance specifications of:

- Ring and covers shall be gray cast iron or ductile iron
- ASTM Standards A48 Class 35B (gray cast iron).
- ASTM Standards A536 Grade 65-45-12 (ductile).
- Shall be designed, constructed and capable of withstanding a minimum H-20 type loading.
- Shall be cleaned according to good foundry practice, chipped and ground as needed to remove fins and rough places on castings.
- Bearing surfaces shall be machined to ensure a proper fit and prevent rattling and fit flush without forcing.
- Cover shall be labeled with "SANITARY SEWER".



- Clear opening 24" for standard & water tight covers
- Frame height 7-1/2" located in pavement

INCLUDE:

- Ring and covers shall be palletized and banded.
- All covers shall have lifting bars in lieu of pick holes.
- Side sealing gaskets for watertight frame & cover locations.

REQUIREMENTS:

- · ISO 9001 or later certification.
- · Affidavit of compliance.
- · All castings shall be true and free of holes.
- All castings shall have manufacturers cast mark and part number clearly visible on each component.
- · Watertight and bolted covers shall be available.



MANUFACTURER:

- CAPITOL FOUNDRY OF VIRGINIA
- GENERAL FOUNDRIES, INC.
- U.S. FOUNDRY & MFG. CORP.
- STAR PIPE PRODUCTS
- SIGMA CORPORATION
- SIP INDUSTRIES

RESTRICTIONS:

 Frame and covers on manholes permanently located in non-traffic areas and elevated 2' or more above finished grade may be considered for non-H20 type loading requirements.



I 4 - ACCESS COVERS (ALUMINUM):

Effective Date: 01-01-2025

SPECIFICATION/ MATERIAL:

Aluminum access covers shall meet or exceed the performance specifications of:

- Shall be designed, constructed and capable of withstanding a minimum 300-pound per square foot live load.
- If subject to traffic, shall be designed and capable of withstanding a minimum AASHTO HS-20 load.
- Shall have checkered or diamond pattern finish on cover surface.
- Shall have vandal-proof recessed stainless steel hinges.
- Hasp will be fabricated round bar stock mounted vertically and drilled to accept a padlock.
- A fall prevention system shall be incorporated into the access frame.
- Doors over 50 lbs. in pull-weight shall be torsion bar loaded.
- All covers shall have a locking safety handle to hold them in the open position.
- Shall be cast into top slab of wet well or valve vault.
- Shall be sized to provide a clear opening to allow for service and removal of equipment (including pumps).
- For federally funded or DOT projects, access covers must have ISO 9001 or later certification, or manufactured in a factory located in the U.S.A.
- Affidavit of compliance to this specification shall be available upon request.

FALL PREVENTION SYSTEM:

Grate:

- Shall be FRP or aluminum with 316 stainless steel components.
- Shall withstand a 300 pound per square foot load.
- Shall lock in place and rotate open 90 degrees.
- Shall be removable.



MANUFACTURER:

- THE BILCO COMPANY
- HALLIDAY PRODUCTS
- U.S.F. FABRICATION INC.
- OPEN

RESTRICTIONS:

