



Hamilton Form Company, Ltd

Custom forms. Custom equipment. Practical solutions.

Guidelines for the Installation and Anchoring of Long-Line Forms

LEGAL DISCLAIMERS

THESE GUIDELINES ARE GENERAL AND NOT SPECIFIC TO A PARTICULAR SITUATION.

IF YOU HAVE ANY QUESTION REGARDING A PARTICULAR SITUATION, THEN YOU SHOULD ENGAGE THE PROFESSIONAL SERVICES OF A LICENSED AND QUALIFIED ENGINEER, EITHER THROUGH HAMILTON FORM COMPANY, LTD. OR WITH ANOTHER LICENSED AND QUALIFIED ENGINEER.

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Hamilton Form Company designs and builds custom forms to fit our customer's specifications. Detailed dimensions, load capacities, and installation requirements can change with every form. The specific dimensions, capacities, and requirements for your form will be shown on the final Approval Drawings provided to you prior to the form being released for production. An additional electronic copy of these drawings is available from Hamilton Form Company if needed. **All utility installations should meet local code and be completed by certified personnel.** The following are general guidelines to follow for installation and setup of your new form:

PRIOR TO DELIVERY OF FORMWORK:

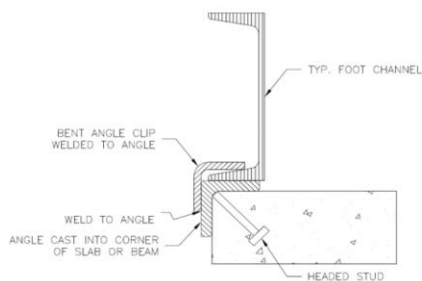
Evaluate the proposed site of the new form for the following:

- Space required for overall footprint of bed installation including safe access for personnel and equipment.
- Verify availability and access to required utilities (power, compressed air, heat curing source, etc.).

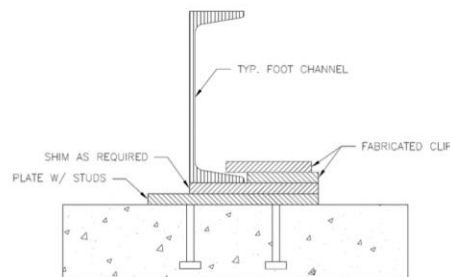
- Verify foundation requirements and capacities for formwork.
- All forms should be laid out using the centerline of the bed in both directions. Do not use the outside edge of a form for placement.
- Prepare the foundation to accept the entire form bed including any form extensions or rollouts for machinery in a single flat plane. Anchor bolts and clips for forms may be installed using the dimensions supplied on the specific form drawings provided for approval. It is the customer's choice as to which anchor bolt installations would be necessary prior to form placement. Some factors to consider are types of anchors required, ease of access, and quality of placement location.
- Prepare the leveling pads to be within $\pm 1/8''$ of a flat plane. **This is for the initial placement only.**

Examples of Hold-down Clips

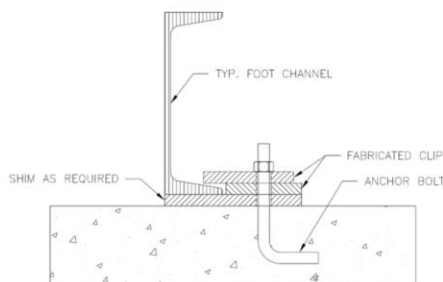
Note – All Hold-down Clips must withstand 5000# of uplift force



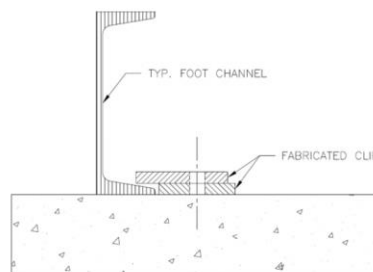
Option 1



Option 2



Option 3



Option 4

UPON DELIVERY OF FORM LOADS:

- Inspect all loads using the **Guidelines for Receipt and Initial Inspection of Forms or Equipment**.
- Verify form bed sequence numbers to position and place form sections in their pre-planned positions using the longitudinal centerline of the form for a reference. Forms should be held to within +/- 1/16" laterally from the straight center line.
- Multi-piece form sections should be assembled and bolted together longitudinally as a unit prior to being assembled to the next form in the bed sequence. Caution must be used to limit the moving of multi-piece form sections in the bolted condition.
- Form sections should be placed, assembled, and bolted together maintaining the centerline tolerance throughout the entire .. The use of a cable ratchet puller or "come along" device on each side of the form will help with this process.
- After all the form sections are set and bolted together, verify that the entire bed is straight and positioned laterally within 1/16" on the centerline.
- Shoot a final elevation from the top skin surface on both sides of the forms at 10' longitudinal increments. Also shoot the center elevation on multi-piece forms if applicable. This final leveling should be held to +/- 1/16" on a plane. Shim as required to meet this position.
- The center 10' of the bed should be rigidly attached to lock it's position.
- Install anchor clips on the forms to maintain a straight lateral position on approximately 5'-0" centers. The end 20' of self-stressing forms must be clipped on 2.5' centers.
- Anchor clips must withstand 5000# of uplift force and allow the form to expand and contract longitudinally while maintaining lateral position.
- After all anchor clips have been installed, self-stressing forms can have two strands loaded to less than 50% capacity approximately ¼ of the form width in from each side to remove any slack in joints. Application of small amounts of vibration at this time will also help eliminate any fine openings in joints.
- After the strands have been unloaded, the joint splice plates can be welded in their designated positions as shown on the approval drawing.
- For all forms with a continuous steel casting surface, joint splice plates should be welded in their designated positions as shown on the approval drawing.

