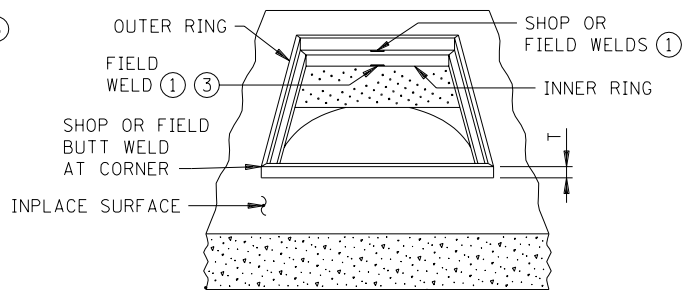
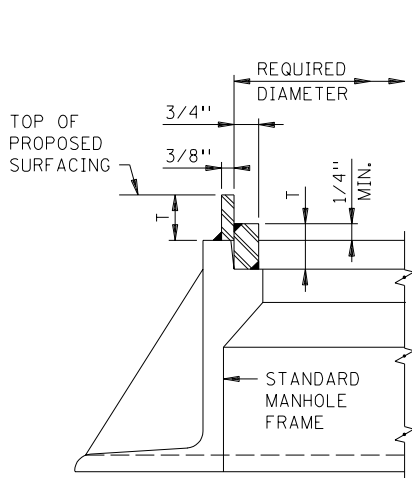


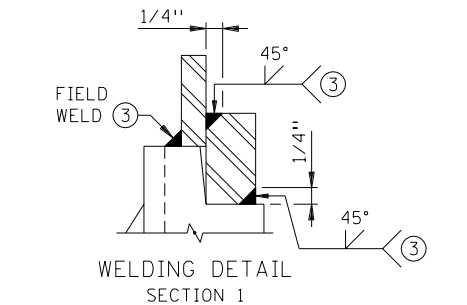
ROUND CASTING



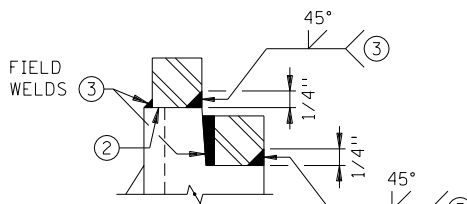
SQUARE OR RECTANGULAR CASTING



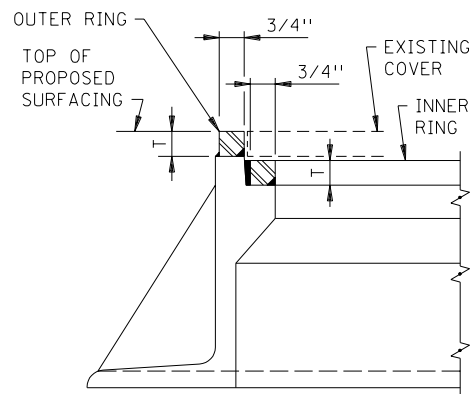
SECTION 1  
USE WHEN THE COVER IS THINNER THAN THE DEPTH OF THE OVERLAY.



WELDING DETAIL SECTION 1



WELDING DETAIL SECTION 2



SECTION 2  
USE WHEN THE COVER IS THICKER THAN THE DEPTH OF THE OVERLAY.

NOTES:

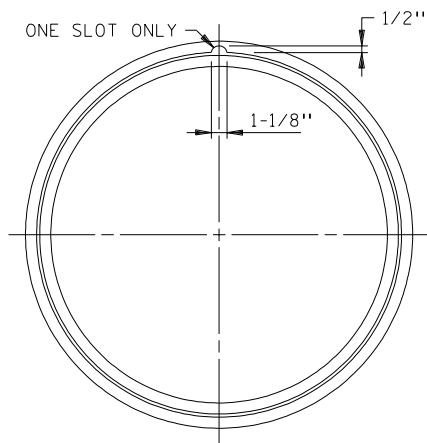
DIMENSION T IS EQUAL TO AN ADJUSTMENT THICKNESS WITH A 3/4" MIN. AND INCREASE IN 1/4" INCREMENTS.

WELDING BETWEEN STEEL AND CAST IRON SHALL BE DONE PER SPEC. 2471.3 USING NI-55 WELDING RODS AND AS APPROVED BY THE ENGINEER.

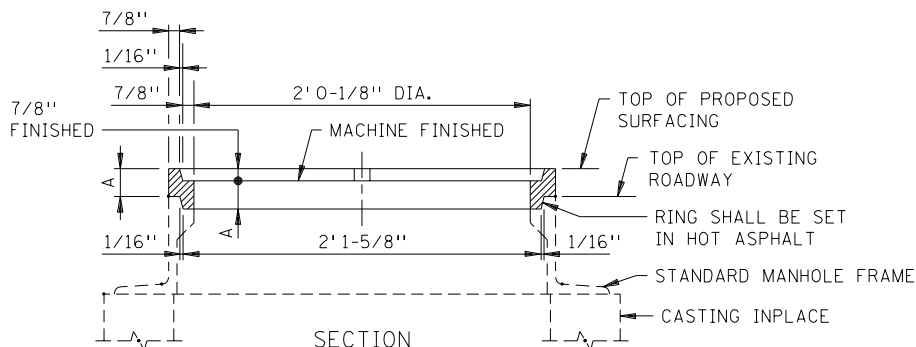
SURFACES OF ADJUSTING RINGS AND MANHOLE CASTINGS SHALL BE CLEANED BY WIRE BRUSHING AND SOLVENT WASH TO ELIMINATE RUST, DIRT OIL, GREASE, ETC., PRIOR TO WELDING OR APPLICATION EPOXY AND AS APPROVED BY THE ENGINEER.  
RING STEEL SHALL CONFORM TO SPEC. 3306. FIELD COAT WITH PRIMER CONFORMING TO SPEC. 3506 AFTER WELDING.

- ① IN LIEU OF WELDING TO CASTINGS, A SPECIALLY FORMULATED EPOXY MAY BE USED AROUND THE TOTAL MATING SURFACE AS APPROVED BY THE MATERIALS ENGINEERING SECTION, WITH APPROVAL OF THE ENGINEER.
- ② WHEN THE OUTER RING IS WIDER THAN THE TOP EDGE OF THE CASTING, EPOXY IS RECOMMENDED TO JOIN THE SURFACES.
- ③ MAKE 2" LONG WELDS AT 1'0" SPACES AROUND CIRCUMFERENCE OR PERIMETER.

STEEL ADJUSTING RING



TOP VIEW



SECTION  
SHOWING CASTING IN POSITION ON STANDARD MANHOLE RING

NOTE: THE AUXILIARY CASTING SHALL BE USED WITH THE FOLLOWING RING CASTINGS, NO. 700-7 TO 700-10 & 770.

- A = 2", CASTING NO. 790-2
- A = 3", CASTING NO. 790-3
- A = 4", CASTING NO. 790-4
- A = 5", CASTING NO. 790-5
- A = 6", CASTING NO. 790-6

CAST IRON ADJUSTING RING

APPROVED March 6, 1991  
*B. M. Hill*  
DIRECTOR  
OFFICE OF TECHNICAL SUPPORT

STATE OF MINNESOTA  
DEPARTMENT OF TRANSPORTATION  
ADJUSTING RINGS  
FOR CATCH BASINS AND MANHOLES

SPECIFICATION REFERENCE  
2506

STANDARD PLATE NO.  
4108F