

EXAMPLE SPECIFICATION FOR 6730 XR-5®

1.01
scope of work

1.02
products

1.03
submittals

1.04
factory
fabrication

1.05
inspection
& testing of
factory seams

1.06
certification
& test reports

1.07
panel packaging
& storage

1.08
qualifications
of suppliers

1.09
subgrade
preparation
by others

1.10
lining installation

1.11
XR-5® field
seaming

1.12
inspection

1.13
patching

1.14
warranty

1.01 SCOPE OF WORK

Furnish and install flexible membrane lining in the baffle system shown on the drawings. All work shall be done in strict accordance with the project drawings, these specifications and baffle system fabricator's approved shop drawings.

Geomembrane panels will be supplied sufficient to cover all areas, including appurtenances, as required in the project and shown on the drawings. The fabricator/installer of the liner shall allow for shrinkage and wrinkling of the field panels.

1.02 PRODUCTS

The lining material shall be 6730 XR-5® as manufactured by Seaman Corporation, (1000 Venture Boulevard, Wooster, Ohio 44691; 330-262-1111), with the following physical specifications:

| 6730 XR-5® fabric | Standard | Metric |
|---|--|---|
| Base Fabric Type | Polyester | |
| Base Fabric Weight (nominal) | 7.0 oz/yd ² | 240 g/m ² |
| Coating - Type | Elvaloy® based XR-5® compound | |
| Finished Coated Weight ASTM D751 | 30.0 oz/yd ² ± 2 oz/yd ² | 1017 g/m ² ± 70 g/m ² |
| Tongue Tear ASTM D751 | 8" x 10" sample@12 in/min 70/50 lb _f | 20.3 cm x 25.4 cm sample@30.5 cm/min 312/223 lb _f |
| Grab Tensile ASTM D751 | 600/550 lb _f | 2670/2450 N |
| Strip Tensile ASTM D751 Procedure B | 450/400 lb _f /in | 400/356 daN/5 cm |
| Adhesion ASTM D751 Dielectric Weld | 15 lb _f /in | 13.5 daN/5 cm |
| Hydrostatic Resistance ASTM D751 Procedure A | 800 psi | 5.51 MPa |
| Low Temperature ASTM D2136 1/8" mandrel, 4 hr | Pass @ -30° F min. | Pass @ -34° C min. |

1.03 SUBMITTALS

The fabricator of panels used in this work shall prepare shop drawings with a proposed panel layout to construct the baffle shown in the project plans. Shop drawings shall indicate the direction of factory seams and shall show panel sizes consistent with the material quantity requirements of 1.01.

Details shall be included to show the termination of the panels at the perimeter of the baffle, the methods of sealing around penetrations, and methods of anchoring.

Placement of the lining shall not commence until the shop drawings and details have been approved by the Owner, or his representative.

1.04 FACTORY FABRICATION

The individual 6730 XR-5® liner widths shall be factory fabricated into large sheets custom designed for this project so as to minimize field seaming.

A two-inch overlap seam done by heat or RF welding is recommended. The surface of the welded areas must be dry and clean. Pressure must be applied to the full width of the seam on the top and bottom surface while the welded area is still in a melt-type condition. The bottom welding surface must be flat to insure that the entire seam is welded properly. Enough heat shall be applied in the welding process that a visible bead is extruded from both edges being welded. The bead insures that the material is in a melt condition and successful chemical bond between the two surfaces is accomplished.

2" seams must withstand a minimum of 210 pounds per inch width dead load at 70°F. and 105 pounds per inch at 160°F. as outlined in Mil-T-52983E or ASTM D751. All seams must exceed 550 lbs. bonded seam

strength per ASTM D-751 bonded seam strength.

1.05 INSPECTION AND TESTING OF FACTORY SEAMS

The fabricator shall monitor each linear foot of seam as it is produced. Upon discovery of any defective seam, the fabricator shall stop production of panels used in this work and shall repair the seam, and determine and rectify the cause of the defect prior to continuation of the seaming process.

The fabricator must provide a Quality Control procedure to the Owner or his representative which details his methods of visual inspection and periodic system checks to ensure leak-proof factory fabrication.

1.06 CERTIFICATION AND TEST REPORTS

Prior to installation of the panels, the fabricator shall provide the Owner, or his representative, with written certification that the factory seams were inspected in accordance with Section 1.05.

1.07 PANEL PACKAGING AND STORAGE

Factory fabricated panels shall be accordion-folded, or rolled, onto a sturdy wooden pallet designed to be moved by a forklift or similar equipment. Each factory fabricated panel shall be prominently and indelibly marked with the panel size. Panels must be protected as necessary to prevent damage to the panel during shipment. Panels that have been delivered to the project site should be stored in a dry area.

1.08 QUALIFICATIONS OF SUPPLIERS

The fabricator of the lining shall be experienced in the installation of floating diversion baffle, and provide the Owner, or his representative, with a list of not less than 5 projects and not less than 100,000 square feet of successfully installed XR-5[®] synthetic lining used in baffle applications. The project list shall show the name, address and telephone number of an appropriate party to contact in each case. The manufacturer of the sheet goods shall provide similar documentation with a 10 million square foot minimum. The installer shall provide similar documentation to that required by the fabricator.

1.09 INSTALLATION AREA PREPARATION BY OTHERS

Lining installation shall not begin until a proper base has been prepared to accept the membrane lining. Base material should be free from angular rocks, roots, grass and vegetation.

1.10 BAFFLE INSTALLATION

Prior to placement of the baffle, the installer will indicate in writing to the owner or his representative that he believes the area to be adequately prepared for the baffle placement.

The baffle shall be placed over the prepared area in such a manner as to assure minimum handling. The sheets shall be of lengths and widths and shall be placed in such a manner as to minimize field seaming.

In areas where wind is prevalent, baffle installation should be started at the upwind side of the project and proceed downwind. The leading edge of the liner should be secured at all times with sandbags or other means sufficient to hold it down during high winds.

Sandbags or rubber tires may be used as required to hold down the lining in position during installation. Materials, equipment or other items must not be dragged across the surface of the liner or be allowed to slide down slopes on the lining. All parties walking or working on the lining material should wear soft-sole shoes.

1.11 XR-5[®] FIELD SEAMING

All requirements of Sections 1.04 and 1.05 apply. A visible bead should be extruded from the hot air welding process.

Field fabrication of lining material will not be allowed.

1.12 INSPECTION

All field seams will be tested using the Air Lance Method per ASTM D4545. A compressed air source will deliver a minimum of 50 psi to a 3/16-inch nozzle. The nozzle will be directed to the lip of the field seam in a near perpendicular direction to the length of the field seam. The nozzle will be held 4 inches maximum from the seam and travel at a rate not to exceed 40 feet per minute. Any loose flaps of 1/8" or greater will require repair.

All joints, on completion of the work, shall be tightly bonded. Any lining surface showing injury due to scuffing, penetration by foreign objects or distress from rough area, should be, as directed by the owner, or representative, replaced or covered and sealed with an additional layer of lining of the proper size, in accordance with the patching procedure.

1.13 PATCHING

Any repairs to the lining should be patched with the lining material. The patch material shall extend a minimum of four inches (4") in each direction from the damaged area.

Seam repairs or seams that are questionable should be cap stripped with a 1" wide (min.) strip of the liner material. The requirements of Section 1.11 apply to this cap stripping.

1.14 WARRANTY

The lining material should be warranted on a pro-rated basis for 10 years against weathering in accordance with Seaman Corporation warranty for 6730 XR-5[®]. Workmanship of installation should be warranted for one year on a 100% basis.