



Standard Specification for Manhole Cover Assembly, Bolted, Semi-Flush, Oiltight and Watertight¹

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1. Scope

1.1 This specification provides design and construction criteria for a semi-flush, oiltight, and watertight bolted manhole cover assembly.

1.2 The manhole cover assembly depicted in this specification is for use in decks or bulkheads requiring oiltight and watertight covers that are not required to be completely flush. Manhole cover assemblies shall be complete with covers, mounting rings, gaskets, welded studs, washers, and nuts.

1.3 Handles, if required, shall be as specified in the ordering information.

1.4 The values stated in inch pound units are to be regarded as the standard. The values given in parentheses are for information only.

1.5 This specification is not applicable to certain hazardous cargos (see Section 46 CFR 153.254 and 46 CFR 154.340).

1.6 This specification provides design and construction for manhole cover assemblies subjected to lateral pressures such as resulting from vehicle loads or hydrostatic pressures. Where manhole cover assemblies are subjected to primary or cyclic loads, other reinforcement or construction criteria may be necessary to integrate the manhole assembly with the required structural reinforcement for openings in decks or bulkheads. Design of the manhole cover assembly for primary or cyclic loads is beyond the scope of this specification.

2. Referenced Documents

2.1 ASTM Standards:²

- A36/A36M Specification for Carbon Structural Steel
- A131/A131M Specification for Structural Steel for Ships
- A153/A153M Specification for Zinc Coating (Hot-Dip) on

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

Iron and Steel Hardware

B36/B36M Specification for Brass Plate, Sheet, Strip, And Rolled Bar

D2000 Classification System for Rubber Products in Automotive Applications

F783 Specification for Staple, Handgrab, Handle, and Stirrup Rung

2.2 ANSI Standards:

B1.1 Unified Inch Screw Threads³

Y14.5M Dimensioning and Tolerancing³

B18.2.1 Square and Hex Bolts and Screws, Inch Series³

2.3 American Bureau of Shipping Standard:

Rules for Building and Classing Steel Vessels⁴

2.4 Steel Structures Painting Council Standard:

SP-10 Surface Preparation Specification No. 10⁵

2.5 Code of Federal Regulations Standard:

CFR 46 Code of Federal Regulations⁶

3. Terminology

3.1 Definitions:

- 3.1.1 *manhole*—an accessway located in a tank structure.
- 3.1.2 *semi-flush*—placement of the cover over the ringed opening (without coaming).

4. Classification

4.1 *Type I*—15- by 23-in. (381- by 584-mm) size of access opening. *Type II*—18- by 24-in. (457- by 610-mm) size of access opening.

4.2 *Grade 1*— $\frac{1}{4}$ -in. (6.35-mm) thick cover plate. *Grade 2*— $\frac{3}{8}$ -in. (9.5-mm) thick cover plate. *Grade 3*— $\frac{1}{2}$ -in. (12.7-mm) thick cover plate.

³ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

⁴ Available from American Bureau of Shipping (ABS), ABS Plaza, 16855 Northchase Dr., Houston, TX 77060, <http://www.eagle.org>.

⁵ Available from Society for Protective Coatings (SSPC), 40 24th St., 6th Floor, Pittsburgh, PA 15222-4656, <http://www.sspc.org>.

⁶ Available from U.S. Government Printing Office Superintendent of Documents, 732 N. Capitol St., NW, Mail Stop: SDE, Washington, DC 20401, <http://www.access.gpo.gov>.

4.3 *Class A Manhole Cover Assemblies*—Class A manhole cover assemblies shall be abrasive blasted to near white metal in accordance with SSPC SP-10, and a commercial marine quality, nonhazardous, corrosion-inhibiting, and oil-resistant primer coating be applied for protection for a period of one year during shipping and in shipyard handling.

4.4 *Class B Manhole Cover Assemblies*—Class B manhole cover assemblies shall be galvanized in accordance with Specification **A153/A153M**.

5. Ordering Information

5.1 The purchasers ordering information shall include the following:

- 5.1.1 ASTM designation and year of issue,
- 5.1.2 Type (see 4.1),
- 5.1.3 Grade (see 4.2),
- 5.1.4 Class (see 4.3),
- 5.1.5 Quantity,
- 5.1.6 *Remarks*—Handles (are/are not) required,
- 5.1.7 *Approval*—Classification Society approval (is/is not) required, and
- 5.1.8 Gasket, if other than specified (see 6.6).

6. Materials and Manufacture

6.1 Plate for the cover and the ring shall be of Specifications **A36/A36M** or **A131/A131M** steel.

6.2 Round bar for the handle shall be in accordance with Specification **F783**, Type A.

6.3 Welded studs shall be $\frac{3}{4}$ -in. (19.05-mm) 10 UNC-2A by $1\frac{3}{4}$ in. (44.4 mm) long and manufactured of ordinary steel to commercial standards. Threads shall be the coarse thread series as specified in the latest issue of ANSI B1.1.

6.4 Washers shall be ANSI B18.2.1 Type A, $\frac{3}{4}$ -in. (19.05-mm) washer, 2-in. (50.8-mm) by 0.148-in. (3.8-mm) thick standard flat manufactured of yellow brass, Specification **B36/B36M**.

6.5 Heavy hex nuts shall be $\frac{3}{4}$ -in. (19.05-mm) 10 UNC-2B and manufactured of yellow brass, Specification **B36/B36M**. Threads in nuts shall conform to the dimensions for coarse threads with tolerances prescribed in ANSI B1.1. The nuts shall conform to dimensions prescribed in ANSI B18.2.1.

6.6 Unless otherwise specified in ordering information, gasket shall be rubber, $\frac{3}{16}$ in. (4.8 mm) thick, 50 ± 5 durometer prescribed per Classification **D2000** 5BC507 A14 E034. Manhole cover assemblies for government application, see **Annex A2** for type of gasket.

6.7 Welding shall conform to the latest issue of the American Bureau of Shipping rules or other classification society rules as may be applicable.

6.8 Details of bolted manhole cover assembly are shown in **Fig. 1**.

7. Dimensions

7.1 Dimensions of manhole cover assembly shall be as indicated in **Table 1**.

7.2 For plating up to and including $\frac{1}{4}$ -in. (6.4-mm) thickness, use cover plate of $\frac{1}{4}$ -in. (6.4-mm) thickness. Plating over $\frac{1}{4}$ in. (6.4 mm) up to, and including $\frac{3}{8}$ -in. (9.5-mm) thickness, use cover plate of $\frac{3}{8}$ -in. (9.5-mm) thickness. Plating over $\frac{3}{8}$ -in. (9.5-mm) thickness, use cover plate of $\frac{1}{2}$ -in. (12.7-mm) thickness.

8. Workmanship, Finish, and Appearance

8.1 Items produced under this specification shall be free of splinters, sharp edges, burrs, projections, and weld spatters.

9. Sampling

9.1 For orders for one or two manhole cover assemblies, each manhole cover assembly shall be inspected.

9.2 For orders for three to ten manhole cover assemblies, two manhole cover assemblies shall be selected at random. If any one of them fails to meet requirements, then all manholes in the order shall be inspected.

9.3 For orders for more than ten manhole cover assemblies, they shall be separated into groups of ten (or fraction thereof) for sampling purposes.

10. Inspection and Testing

10.1 *Responsibility*—Unless otherwise specified in the order, the manufacturer is responsible for the performance of all inspection and testing specified herein. The manufacturer may use his own facilities or any commercial facility acceptable to the purchaser. The purchaser reserves the right to perform any of the inspections and tests set forth where such are deemed necessary to assure that supplies conform to prescribed requirements. Nonconforming manhole cover assemblies shall not be offered for delivery.

10.2 *Inspection*—The dimensions of the manhole cover assembly and its components shall be checked to ensure that they are within specified tolerances.

10.3 *Test Methods*—Each manhole cover assembly shall be designed to the pressure listed in **Table 1** and tested to a pressure equal to 1.5 times the design pressure. The test pressure shall be held for a minimum of 5 min. There shall be no visible sign of leakage, permanent deformation, or other indications of structural failure of the manhole cover assembly.

10.3.1 Before delivery, the manhole cover assemblies shall be certified as to their watertight and oiltight integrity. Groups of manhole cover assemblies whose representative samples pass the tightness test shall be certified for watertight and oiltight integrity to their design pressure.

11. Product Marking

11.1 Each manhole cover assembly shall be marked with the purchase order number, item number from purchase order, ASTM designation number, type, grade, class, and manufacturer's name. Marking may be done by paint, stencil, or weatherproof tag.

12. Packaging and Package Marking

12.1 Unless otherwise specified, packaging shall conform to manufacturer's normal commercial practice, and in such a

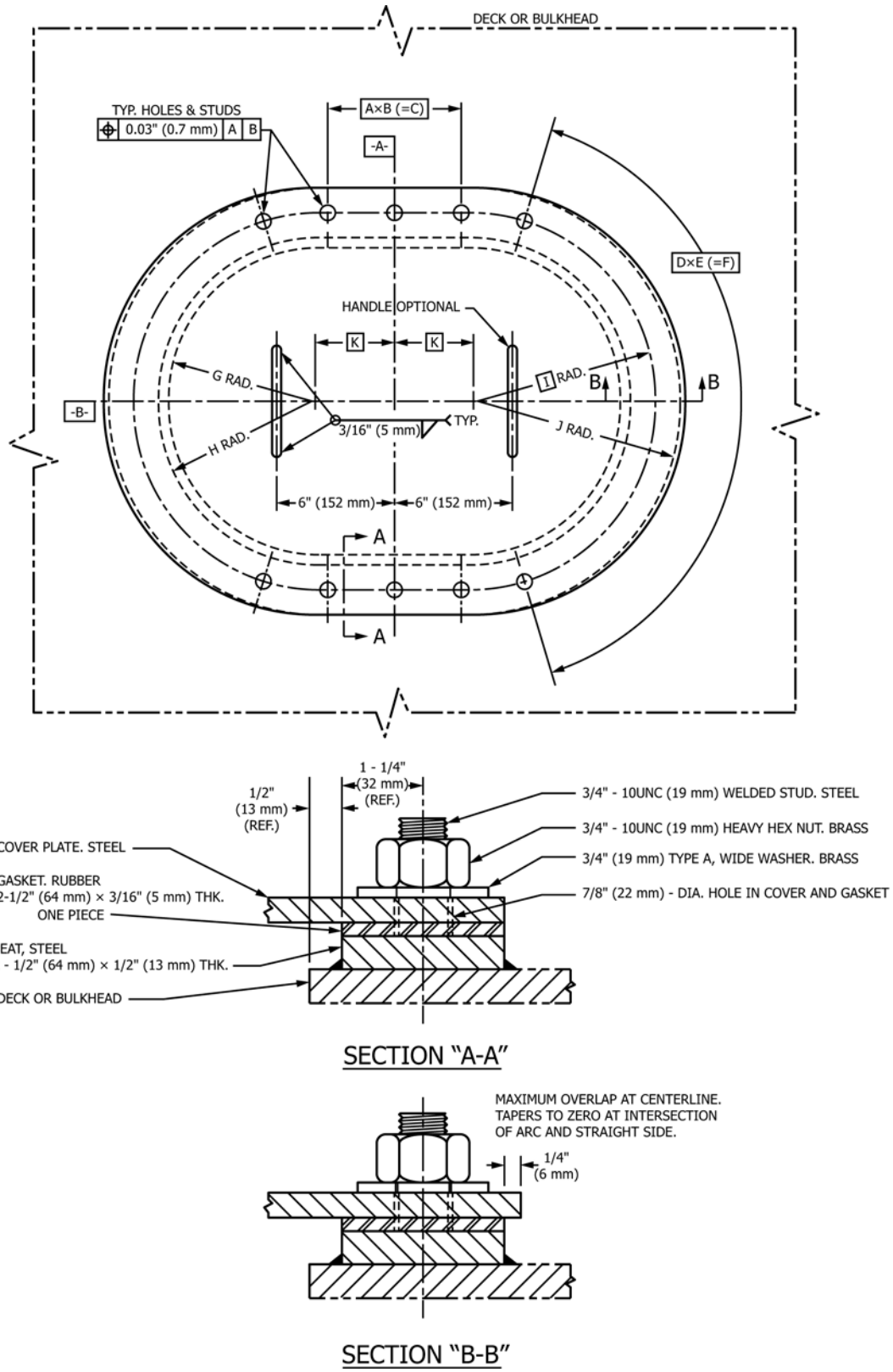


FIG. 1 Manhole Cover Assembly, Bolted, Semi-Flush, Oiltight and Watertight



TABLE 1 Dimensions for Bolted, Semi-Flush, Oiltight and Watertight Manhole Cover Assembly^A

NOTE 1—1 in. = 25.4 mm.

Type	Grade	Plate Thickness		Deck Cut Overall Size	A	B	C	D	E, °	F, °	G		H		I		J		K				
		in.	(mm)								in.	(mm)	in.	(mm)	in.	(mm)	in.	(mm)	in.	(mm)	in.	(mm)	in.
I	1	1/4	(6.5)	15 x 23	(381 x 584)	2	3 3/8	(86)	6 3/4	(171)	7	21	147	7 1/2	(191)	8	(203)	9 1/4	(235)	10 1/2	(267)	4	(102)
I	2	3/8	(9.5)	15 x 23	(381 x 584)	2	3 3/8	(86)	6 3/4	(171)	7	21	147	7 1/2	(191)	8	(203)	9 1/4	(235)	10 1/2	(267)	4	(102)
I	3	1/2	(12.5)	15 x 23	(381 x 584)	2	3 3/8	(86)	6 3/4	(171)	7	21	147	7 1/2	(191)	8	(203)	9 1/4	(235)	10 1/2	(267)	4	(102)
II	1	1/4	(6.5)	18 x 24	(457 x 610)	2	3 1/4	(83)	6 1/2	(165)	8	18	144	9	(229)	9 1/2	(241)	10 3/4	(273)	12	(305)	3	(76)
II	2	3/8	(9.5)	18 x 24	(457 x 610)	2	3 1/4	(83)	6 1/2	(165)	8	21	144	9	(229)	9 1/2	(241)	10 3/4	(273)	12	(305)	3	(76)
II	3	1/2	(12.5)	18 x 24	(457 x 610)	2	3 1/4	(83)	6 1/2	(165)	8	18	144	9	(229)	9 1/2	(241)	10 3/4	(273)	12	(305)	3	(76)

Stud Quantity	Design Pressure		Weight	
	psi	(kPa)	lb	(kg)
22	12.0	82.7	78	35
22	27.0	186.2	100	45
22	47.9	330.2	121	55
24	8.9	62.1	88	40
24	20.0	137.9	114	52
24	35.6	245.5	140	64

^A The letters in the headings designate the following:

- A = number of spaces on straight side,
- B = bolt spacing (straight side),
- C = total span,
- D = number of spaces on arc side,
- E = bolt spacing (arc side),
- F = arc span,
- G = accessway inner radius,
- H = seat and gasket inner radius,
- I = bolt circle arc radius,
- J = seat and gasket outer radius, and
- K = offset for radii from center of accessway and cover.

manner that will ensure acceptance by common carrier and afford protection against physical damage during shipment. Shipping containers shall conform to carrier regulations as applicable to the mode of transportation.

12.2 For government procurements for long-term storage or overseas shipment, the requirements of **Annex A1** apply. In such case, the required level of packaging shall be specified.

13. Keywords

13.1 bulkhead; decks; manhole cover assembly; marine technology; ships

ANNEXES

(Mandatory Information)

A1. PACKING FOR DoD PROCUREMENTS (GOVERNMENT APPLICATIONS)

A1.1 Referenced Documents (for this annex only)

- A1.1.1 *Federal Standards*: PPP-B-576 Box, Wood, Cleated, Veneer, Paper Overlaid⁷
- PPP-B-585 Boxes, Wood, Wirebound⁷
- PPP-B-591 Boxes, Fiberboard, Wood-Cleated⁷
- PPP-B-601 Boxes, Wood, Cleated—Plywood⁷
- PPP-B-621 Boxes, Wood, Nailed and Lock Corner⁷
- PPP-B-636 Box, Fiberboard⁷
- PPP-B-640 Boxes, Fiberboard, Corrugated, Triple, Wall⁷

A1.1.2 *Military Standard*: MIL-STD-129 Marking for Shipment and Storage⁷

A1.1.3 *Official Classification Committee Standard*: Uniform Freight Classification Rules⁸

A1.2 Packing—The manhole cover assembly shall be cushioned, blocked, or braced within the container in a manner to prohibit movement. Unless otherwise specified in the order,

one manhole cover assembly shall be packed per container. When more than one manhole cover assembly is required to be packed in each container, the gross mass of the wood or wood-cleated boxes shall not exceed approximately 100 kg.

A1.2.1 *Level A*—Manhole cover assembly shall be packed in containers conforming to any one of the following specifications at the option of the manufacturer:

<i>Specification:</i>	<i>Type or Class:</i>
PPP-B-576	Overseas
PPP-B-585	Class 3
PPP-B-591	Overseas
PPP-B-601	Overseas
PPP-B-621	Class 2
PPP-B-636	Weather Resistant
PPP-B-640	Class 2

A1.2.1.1 Boxes shall be closed and banded in accordance with the applicable box specification.

A1.2.2 *Level B*—Manhole cover assemblies shall be packed in boxes conforming to any of the following specifications at the option of the manufacturer:

<i>Specification:</i>	<i>Type or Class:</i>
PPP-B-576 PPP0-B-585	Domestic Class 1 or 2

⁷ Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, <http://www.dodssp.daps.mil>.

⁸ Available from Official Classification Committee, Uniform Classification Agent, Tariff Publications Officer, 222 S. Riverside Plaza, Chicago, IL 60606.

A2. DoD MANHOLE COVER ASSEMBLY SPECIAL APPLICATION

A2.1 Referenced Documents (for this annex only)

A2.1.1 *Military Standards*: MIL-C-6183 Cork and Rubber Composition Sheet for Aromatic Fuel and Oil Resistant Gaskets⁷

MIL-G-1149 Gasket Materials, Synthetic Rubber 50 and 65 Durometer Hardness⁷

MIL-R-900 Rubber Gasket Material, 45 Durometer Hardness⁷

MIL-R-83248 Rubber Fluorocarbon Elastomer, High Temperature, Fluid and Compression Set Resistant⁷

A2.2 Gasket materials used in DoD manhole cover assemblies shall be as follows:

Manhole Cover Assembly Service	Required Gasket Material
General service	MIL-R-900
Freshwater	MIL-G-1149, Class 2
Oil, gasoline, saltwater	MIL-C-6183, Class 1
Hydraulic machinery spaces using phosphate ester-based hydraulic fluid	MIL-R-83248

A2.3 DoD manhole covers shall be Class B.

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