Michigan Department
of Transportation
0388 (09/16)

HEAT STRAIGHTENING PLAN

To be completed by the Heat Straightening Contractor
and submitted to the Engineer for approval.
Naming Convention: 0388 SN-CS-JN YYYY-MM-DD Heat Straightening Plan.pdf

GENERAL INFORMATION

PROJECT DESCRIPTION	CONTROL SECTION	Bridge Field Services Approval Block
CONTRACTOR	JOB NUMBER	
HEAT STRAIGHTENING CONTRACTOR	STRUCTURE NUMBER	
PREPARED BY	DATE	

KEY STAFF MEMBERS

NAME	Please list all key staff members who will be working on the project. Key staff members must be onsite and directly supervising the heat straightening operations at all times. Key staff members not listed will not be allowed to work on the jobsite. Non-key staff members applying jacking forces or heat must be listed in the comments section below.
NAME	
NAME	
NAME	

COMMENTS

SPECIFICATIONS & TOLERANCES

The Contractor must comply with subsection 713.03.G of the MDOT Standard Specifications for Construction and all other contract requirements.

- Steel must be heated to a temperature no greater than 1200 °F unless otherwise specified in the contract.
- Torch tips must be between ¾” and 1”.
- Limit “V” heat angles to 20° and “V” heat angle bases to 6”.
- Flange plates and angles must be straightened to within ¼” of the tilt rotation at the edges from the web, with ½” of sweep over 20’, ¾” at the point of impact.
- Webs must be straightened to less than ½” out of plumb.
- Reduce localized deflections in the web to no greater than ½”, vertically and horizontally.

TOOLS & EQUIPMENT

STEEL THICKNESS	STEEL GRADE
ORIFICE TYPE	ORIFICE SIZE
TEMPERATURE SENSING DEVICES	
JACK CALIBRATION DATE	

HEAT STRAIGHTENING PROCEDURE