

4. 00-

THREADED STUD P112-0562

-NOTES-

- 1. FINISH: HOT DIP GALVANIZE PER ASTM-A153 (LATEST REVISION).
- 2. BASEPLATE TO BE PERPENDICULAR TO SHAFT AXIS (±1°) AND HOLE CENTERLINE TO BE CONCENTRIC (±. 188) TO SHAFT AXIS.
- STENCIL MIN. 1/2 IN. LETTERS MANUFACTURER'S NUMBER AFTER GALVANIZING.
- 4. PILOT POINT AND SHAFT AXES TO BE CONCENTRIC (±. 125 FIM) AND IN LINE (±2°).
- PREHEAT, TUMBLEBLAST, HANDGRIND, AND CLEAN BASEPLATE, HELIX, AND PILOT POINT ON ALL WELDED PARTS.
- 5. FLAMECUT IRREGULARITIES PERMISSIBLE: (1) VALLEYS NOT TO EXCEED 3/32 IN. BELOW NOMINAL SURFACE LEVEL, (2) PEAKS OR POSITIVE IRREGULARITIES NOT TO EXCEED 1/32 IN. ABOVE NOMINAL SURFACE LEVEL OR INTERSECTIONS OF NOMINAL SURFACES.
- MANUFACTURER TO HAVE IN EFFECT INDUSTRY RECOGNIZED WRITTEN QUALITY CONTROL FOR ALL MATERIALS AND MANUFACTURING PROCESSES.
- 8. BASEPLATE IS PERMANENTLY STAMPED WITH MANUFACTURER'S IDENTIFICATION "ABC" IN 1/2" LETTERS AND THE JULIAN DATE CODE IN 1/4" LETTERS.
- 9. ALL MATERIAL IS TO MEET THE FOLLOWING SPECIFICATIONS:

BASEPLATE: ASTM A36-(LATEST REVISION) STRUCTURAL STEEL

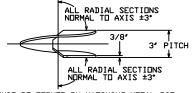
SHAFT: ASTM A252-(LATEST REVISION) GRADE 2, STEEL PIPE PILES.
ALTERNATE MATERIAL: ASTM A53-(LATEST REVISION) TYPE
E OR S, GRADE B, STEEL PIPE OR ASTM A500-(LATEST REVISION) GRADE B, STRUCTURAL STEEL TUBING.

HELIX: ASTM A635-(LATEST REVISION) 3/8" THICK HOT ROLLED STEEL PLATE OR COIL.

PILOT POINT: ASTM A575-(LATEST REVISION) 1-1/4" DIAMETER HOT ROLLED STEEL BAR

BOLTS: SPECIAL 1" DIAMETER HOT DIP GALVANIZED STUDS THREADED AT BOTH ENDS.

- 10. FLAME CUT TWO SLOTS IN SHAFT PERPENDICALAR TO THE BASEPLATE.
- 11. BASEPLATE PERMANENTLY MARKED TO INDICATE CABLEWAY OPENING IN SHAFT.



HELIX MUST BE FORMED BY MATCHING METAL DIE

VIEW "A-A"

(SIDE VIEW OF TRUE HELICAL FORM)

LIGHTING FOUNDATION CAT. NO. T112-0294

1'-8UNC

