

HELIX MUST BE FORMED BY MATCHING METAL DIE
(SIDE VIEW OF TRUE HELICAL FORM)

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1. FINISH: HOT DIP GALVANIZE PER ASTM-A153 (LATEST REVISION).
2. BASEPLATE TO BE PERPENDICULAR TO SHAFT AXIS ($\pm 1^\circ$) AND HOLE CENTERLINE CONCENTRIC ($\pm .188$) TO SHAFT AXIS.
3. STENCIL MIN. 1/2 IN. LETTERS MANUFACTURER'S NUMBER AFTER GALVANIZING.
4. PILOT POINT AND SHAFT AXES TO BE CONCENTRIC ($\pm .125$ FIM) AND IN LINE ($\pm 2^\circ$).
5. FLAME CUT SLOT PERPENDICULAR TO THE BASEPLATE.
6. PREHEAT, TUMBLEBLAST, HANDGRIND, AND CLEAN BASEPLATE, HELIX, AND PILOT POINT ON ALL WELDED AREAS.
7. 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.
8. MANUFACTURER TO HAVE IN EFFECT INDUSTRY RECOGNIZED WRITTEN QUALITY CONTROL FOR ALL MATERIALS AND MANUFACTURING PROCESSES.
9. ALL MATERIAL IS TO BE NEW, UNUSED AND MILL TRACEABLE MEETING THE FOLLOWING SPECIFICATIONS:

BASEPLATE: ASTM A36-(LATEST REVISION) STRUCTURAL STEEL (CONFORM TO AASHTO TECH. BUL. #270).

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) HOT ROLLED STEEL. MEETS OR EXCEEDS ASTM A29.

PILOT POINT: ASTM A575-(LATEST REVISION) STEEL BAR.


BOLTS: BOLT PER ANSI B-18.2.1, SAE J429 GRADE-5. MEETS OR EXCEEDS ASTM A325.

NUTS: HEAVY HEX NUTS PER ASTM A325 AND ANSI B18.2.2. ALT. MATERIAL GRADE 2H PER ASTM A194 AND ANSI B18.2.2. MEETS OR EXCEEDS ASTM A563 GRADE D OR DH.

WASHERS: PER ASTM F436.

10. BASEPLATE IS PERMANENTLY STAMPED WITH MANUFACTURER'S IDENTIFICATION 'ABC' IN 1/2" LETTERS AND DATE CODE IN 1/4" LETTERS.

STREETLIGHT FOUNDATION
CAT. NO. T112-0355

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