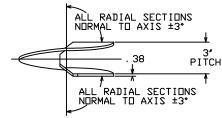
1-8 UNC X 2.5" 4 - 3/4 X 2.5" HEX BOLTS INSTALLATION HEX BOLT ROUND WASHERS AND 4 SPRING LOCKWASHERS 12" SQ. 8" DIA. BOLT CIRCLE 5" DIA. TAPPED . 771-10UNS-2B CENTER HOLE 12" NDTE-5 6.63 DIA. D.D. . 28" WALL THICKNESS 12" 12" DIA. HELIX 72"



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

-NOTES-

- 1. FINISH: HOT DIP GALVANIZE PER ASTM-A153 (LATEST REVISION).
- BASEPLATE TO BE PERPENDICULAR TO SHAFT AXIS (±1°) AND HOLE CENTERLINE CONCENTRIC (±. 188) TO SHAFT AXIS.
- STENCIL MIN. 1/2 IN. LETTERS MANUFACTURER'S NUMBER AFTER GALVANIZING.
- PILOT POINT AND SHAFT AXES TO BE CONCENTRIC (±, 125 FIM) AND IN LINE (±2*).
- 5. FLAME CUT TWO SLOTS IN SHAFT 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) 3/8" THICK HOT ROLLED STEEL PLATE OR COIL.

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

BDLTS: 3/4"-10 UNC X 2-1/2" HEX BDLT SAE J429 GRADE 5 DR ASTM A193 GRADE B7.

- 10. BASEPLATE IS PERMANENTLY STAMPED WITH MANUFACTURER'S IDENTIFICATION "ABC" IN 1/2" LETTERS AND DATE CODE IN 1/4" LETTERS.
- 11. BASEPLATE PERMANENTLY MARKED TO INDICATE CABLEWAY OPENING IN SHAFT.

LIGHTING FOUNDATION CAT. NO. T112-0648

