



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

-NOTES-

1. FINISH: HOT DIP GALVANIZE PER ASTM-A153 (LATEST REVISION).
2. BASEPLATE TO BE PERPENDICULAR TO SHAFT AXIS ($\pm 1^\circ$) AND HOLE CENTERLINE TO BE 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. PREHEAT, TUMBLEBLAST, HANDGRIND, AND CLEAN BASEPLATE, HELIX, AND PILOT POINT ON ALL WELDED PARTS.
6. 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.
7. 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) 1/2" THICK HOT ROLLED STEEL PLATE OR COIL.

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

BOLTS: HEX BOLT 1-8UNC-2A PER ANSI B-18.2.1, SAE J429 GRADE 5

NUTS: HEAVY HEX NUT PER ASTM A194 GRADE 2H, OR ASTM A563 GRADE DH, MEETING SUPPLEMENTARY REQUIREMENTS OF ASTM A563, 1-8UNC-2B PER ANSI B18.2.2.

10. FLAME CUT TWO SLOTS IN SHAFT PERPENDICULAR TO THE BASEPLATE.

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		SIZE SBI SA112-0673	DWG NO. SBI SA112-0673
DO NOT SCALE THIS DRAWING	DRN BY KSH	DATE 1/28/05	SHEET 1/1
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