



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

RAILROAD SIGNAL FOUNDATION  
CAT. NO. T1121010

-NOTES-

1. FINISH: HOT DIP GALVANIZE PER ASTM-A153 (LATEST REVISION).
2. BASEPLATE TO BE PERPENDICULAR TO SHAFT AXIS (±1°) AND HOLE CENTERLINE CONCENTRIC (±.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 (±.125 FIM) AND IN LINE (±2°).
5. FLAME CUT TWO SLOTS IN SHAFT PERPENDICULAR TO THE BASEPLATE. PREHEAT, TUMBLEBLAST, HANDGRIND, AND CLEAN BASEPLATE, HELIX, AND PILOT POINT ON ALL WELDED AREAS.
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. ALL MATERIAL IS TO BE NEW, UNUSED AND MILL TRACEABLE MEETING THE FOLLOWING SPECIFICATIONS:
8. BASEPLATE: ASTM A36--(LATEST REVISION) STRUCTURAL STEEL (CONFORM TO AASHTO TECH. BUL. #270).
9. SHAFT: STEEL PIPE PILES, SEAMLESS OR STRAIGHT WELDED, GRADE-2 PER ASTM A252 ALL MATERIAL. STEEL PIPE TYPE E OR S, GRADE B, STEEL PIPE OR ASTM A53.
10. HELIX: ASTM A635 (LATEST REV'N) 3/8" THICK HOT ROLLED STEEL PLATE OR COIL.
11. PILOT POINT: ASTM A575 (LATEST REV'N) 1-1/4" DIAMETER HOT ROLLED STEEL BAR.
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.

CHANCE		 HUBBELL POWER SYSTEMS	
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SIZE	DWG NO.	DRN BY	DATE
SB	S1121010	ALDM	4/21/10
DO NOT SCALE THIS DRAWING	REV	DATE	SHEET
	B		1/1