



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).
2. BASEPLATE TO BE PERPENDICULAR TO SHAFT ($\pm 1^\circ$) AND HOLE CENTERLINE CONCENTRIC ($\pm .188$) TO SHAFT AXIS.
3. STENCIL MIN. 1/2 IN. LETTERS MANUFACTURER'S NUMBER AFTER GALVANIZING.
4. FLAME CUT TWO SLOTS IN SHAFT PERPENDICULAR TO THE BASEPLATE.
5. 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.
8. ALL MATERIAL IS TO BE NEW, UNUSED AND MILL TRACEABLE MEETING THE FOLLOWING SPECIFICATIONS:

BASEPLATE: ASTM A36-(LATEST REVISION) HOT ROLLED STEEL PLATE

SHAFT: STEEL TUBING, PER ASTM 500 GRADE B STRUCTURAL.

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

9. BASEPLATE PERMANENTLY MARKED TO INDICATE CABLEWAY OPENINGS IN SHAFT.

*MAT'L: HOT DIP GALVANIZED STEEL
HARDWARE ORDERED SEPARATELY*

DECORATIVE LIGHTING FOUNDATION
CAT. NO. T1120905
MOUNTING HARDWARE ORDER T112-0392

CHANCE TOLERANCE CHART <small>X ± .050 FRAC ±1/16 ANGLES ±2° XX ± .009 ADD DRAFT (UNLESS NOTED) XXX ± .005 CASTING 3° FINISHES</small>			
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