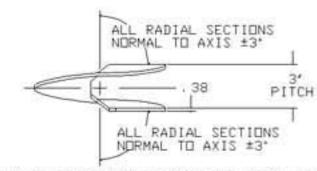
CENTER HOLE 1' X 4' CARRIAGE BOLTS WITH NUTS 15. 75' SQ. 11' TO 17' DIA BOLT CIRCLE 2.5' NOTE-5 8. 63' DIA D. D. 25' WALL THICKNESS 14' DIA HELIX



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.
- 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.
- 7. FLAMECUT IRREGULARITIES PERMISSIBLE: (1) VALLEYS NOT TO EXCEED 3/32' BELOW NOMINAL SURFACE LEVEL, (2) PEAKS OR POSITIVE IRREGULARITIES NOT TO EXCEED 1/32 IN. ABOVE NOMINAL SURFACE LEVEL OR INTERSECTIONS OF NOMINAL SURFACES.
- 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:
 - 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.
 - BOLTS: CARRIAGE BOLT, 1-BUNC-2A PER ANSI B-18.5, SAE J429 GRADE-5.
 - NUTS: HEAVY HEX NUTS PER ASTM A194 GRADE 2H DR ASTM A563 GRADE DH, MEETING THE SUPPLEMENTARY REQUIREMENTS DF ASTM A563; 1-8UNC-2B PER ANSI B18, 2, 2.
- 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 CABLEVAY OPENING IN SHAFT.

LIGHTING FOUNDATION CAT. NO. C11242QG4VP

