



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.
2. STENCIL MIN. 1/2 IN. LETTERS MANUFACTURER'S NUMBER AFTER GALVANIZING.
3. PILOT POINT AND SHAFT AXES TO BE CONCENTRIC (±.125 FIM) AND IN LINE (±2°).
4. FLAME CUT TWO SLOTS IN SHAFT PERPENDICULAR TO THE BASEPLATE. PREHEAT, TUMBLEBLAST, HANDGRIND, AND CLEAN BASEPLATE, HELIX, AND PILOT POINT ON ALL WELDED AREAS.
5. 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.
6. 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:
- 7.
- 8.
- 9.

BASEPLATE: MATERIAL WILL CONFORM TO AASHTO TECH. BUL. #270 DWG PA6-1

SHAFT: MATERIAL WILL CONFORM TO AASHTO TECH. BUL. #270 DWG PA6-1

HELIX: ASTM A29-(LATEST REVISION) 3/8" THICK HOT ROLLED PLATE OR COIL.

PILOT POINT: ASTM A107-(LATEST REVISION) 1-1/4" DIAMETER HOT ROLLED STEEL BAR.

BOLTS: CARRIAGE BOLT PER .75-10UNC-2A ANSI B-18.5, SAE J429 GRADE 5 WITH NUT.

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. 1112-0679

CHANCE			
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