



HELIX MUST BE FORMED BY MATCHING METAL DIE  
<SIDE VIEW OF TRUE HELICAL FORM>

LIGHTING FOUNDATION  
CAT. NO. T112-0644

-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: 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.
10. HELIX: ASTM A635-(LATEST REVISION) 3/8" THICK HOT ROLLED STEEL PLATE OR COIL.
11. PILOT POINT: ASTM A575 (LATEST REVISION) 1-1/4" DIAMETER HOT ROLLED STEEL BAR
12. BOLTS: CARRIAGE BOLT 1-8UNC-2A PER ANSI B-18.5, SAE J429 GRADE-5. RETAINING WASHERS: 1/64" THICK STRESS RELIEF ANNEALED STEEL, BEVELED FORMED HOLDING TABS WITH AN OUTER STABILIZING FLANGES.
13. BASEPLATE IS PERMANENTLY STAMPED WITH MANUFACTURER'S IDENTIFICATION 'ABC' IN 1/2" LETTERS AND THE JULIAN DATE CODE IN 1/4" LETTERS.
14. BOLT CLEARANCE SLOTS IN SHAFT UNDER BASEPLATE.
15. MAXIMUM GROUNDLINE BENDING MOMENT CANNOT EXCEED 13,000 FT.-LBS. ON THIS DESIGN. IF DESIGN REQUIREMENTS EXCEED THIS LIMIT, CONTACT THE MANUFACTURER FOR OTHER ALTERNATIVES.
16. BASEPLATE PERMANENTLY MARKED TO INDICATE CABLEWAY OPENING IN SHAFT.

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| <b>CHANCE</b>         |            |                       |              |
| HUBBELL POWER SYSTEMS |            | HUBBELL POWER SYSTEMS |              |
| TITLE                 |            | TITLE                 |              |
| LIGHTING FOUNDATION   |            | LIGHTING FOUNDATION   |              |
| SIZE                  | DWG NO.    | DO NOT SCALE          | THIS DRAWING |
| SB                    | SA112-0644 |                       |              |
| REV                   |            | DEN BY KSH            | DATE 11/9/04 |
| A                     |            |                       | SHEET 1/1    |