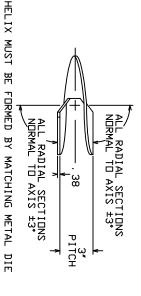


(SIDE VIEW OF

TRUE HELICAL FORM

## 7' DIA. CENTER HOLE 180 444 φ NOTE-5 ----3,63" DIA. D.D. 25" WALL THICKNESS 15, X 2.5" HEX HEAD BOLTS LOCKWASHERS ROUND WASHERS 1" DIA. DRIVE HOLES 13" SPACED 14.5° DIA. BOLT CIRCLE DRILLED AND TAPPED SQ. ဖ ω ល់ ល 4 ŊΗ ω



IGHTING FOUNDATION T. NO. T11202940101

- 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.
  STENCIL MIN. 1/2 IN. LETTERS MANUFACTURER'S NUMBER

- AFTER GALVANIZING.
  PILOT POINT AND SHAFT AXES TO BE CONCENTRIC (±, 125 FIM) AND IN LINE (±2\*).

- FLAME CUT TWO SLOTS IN SHAFT PERPENDICULAR TO THE BASEPLATE. PREHEAT, TUMBLEBLAST, HANDGRIND, AND CLEAN BASEPLATE, PREHEAT, TUMBLEBLAST, HANDGRIND, AND CLEAN BASEPLATE, HELIX, AND PILOT POINT ON ALL WELDED AREAS. FLAMECUT TRREGULARITIES PERMISSIBLE: (1) VALLEYS NOT TO EXCEED 3/32 IN. BELOW NOMINAL SURFACE LEVEL, (2) PEAKS OR POSITIVE TRREGULARITIES 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.

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DIA. HELIX

- HELLIX: ASTM A635-(LATEST REVISION)  $3/8^{\prime\prime}$  THICK HOT ROLLED STEEL PLATE OR COIL.
- PILOT POINT: ASTM A575-(LATEST REVISION) 1-1/4' DIAMETER HOT ROLLED STEEL BAR.
- BDLTS: HEX HEAD BOLT, 1-8UNC-2A PER ANSI B18.2.1, GRADE 5. SAE J429
- 10. BASEPLATE IS PERMANENTLY STAMPED WITH MANUFACTURER'S IDENTIFICATION "ABC" AND F2 IN 1/2" LETTERS. DATE CODE IN 1/4" LETTERS.

  BASEPLATE PERMANENTLY MARKED TO INDICATE CABLEWAY OPENING IN SHAFT.

