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1. FINISH: HOT DIP GALVANIZE PER ASTM-A153 (LATEST REVISION).
2. BASEPLATE TO BE PERPENDICULAR TO SHAFT AXIS ($\pm 1^\circ$) AND HOLE CENTERLINE CONCENTRIC ($\pm .188$) TO SHAFT AXIS.
3. STENCIL MIN. 1/2 IN. LETTERS MANUFACTURER'S NUMBER AFTER GALVANIZING.
4. PILOT POINT AND SHAFT AXES TO BE CONCENTRIC ($\pm .125$ FIM) AND IN LINE ($\pm 2^\circ$).
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.
8. ALL MATERIAL IS TO BE NEW, UNUSED AND MILL TRACEABLE MEETING THE FOLLOWING SPECIFICATIONS:
9. BASEPLATE: ASTM A36-(LATEST REVISION) HOT ROLLED STEEL PLATE


SHAFT: STEEL PIPE PILES, SEAMLESS OR STRAIGHT WELDED, GRADE-2 PER ASTM A252. ALT. MATERIAL: STEEL PIPE TYPE E OR S, GRADE-B PER ASTM A53.

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

10. PILOT POINT: ASTM A107-(LATEST REVISION) 1-1/4" DIAMETER HOT ROLLED STEEL BAR.
11. BOLT: HEX HEAD MACHINE BOLT 1-8UNC, PER ANSI B.18.2.1, SAE J429 GRADE 5
12. BASEPLATE IS PERMANENTLY STAMPED WITH MANUFACTURER'S IDENTIFICATION "ABC" IN 1/2" LETTERS AND DATE COND IN 1/4" LETTERS.
13. ALL HARDWARE IS HOT DIP GALVANIZED.

HELIX MUST BE FORMED BY MATCHING METAL DIE
(SIDE VIEW OF TRUE HELICAL FORM)

LIGHTING FOUNDATION
CAT. NO. T1120363

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