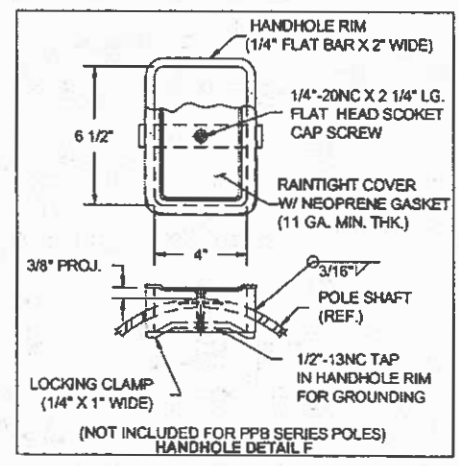
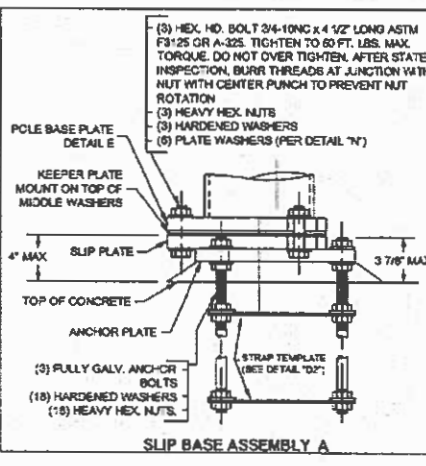
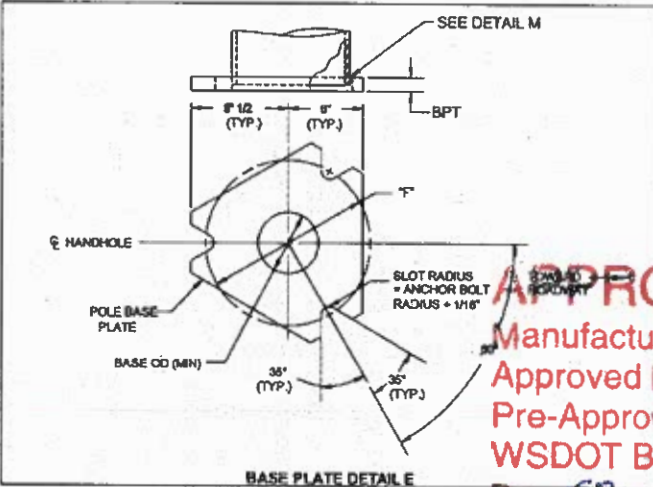
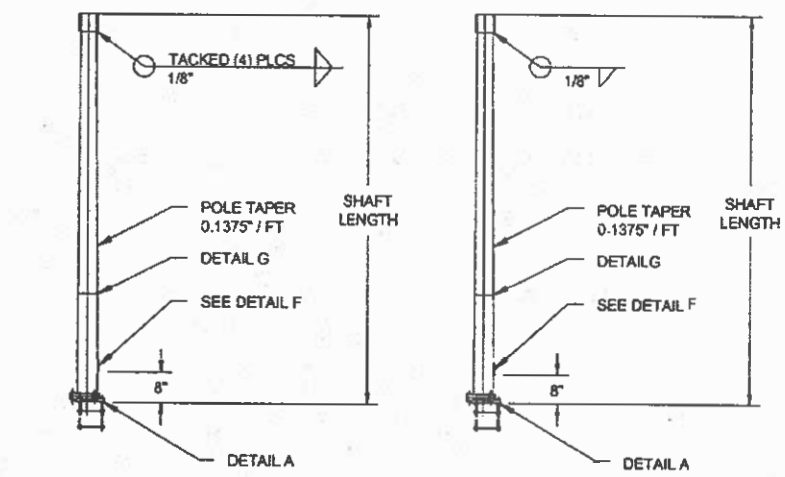
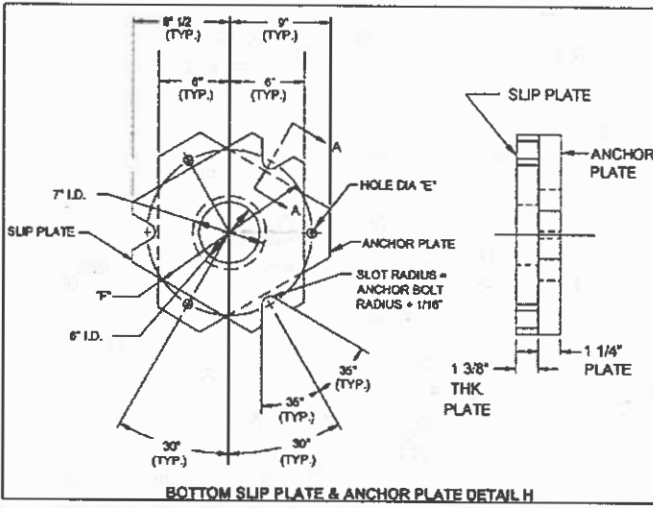
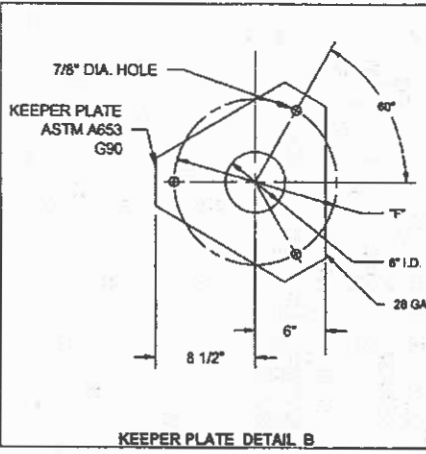
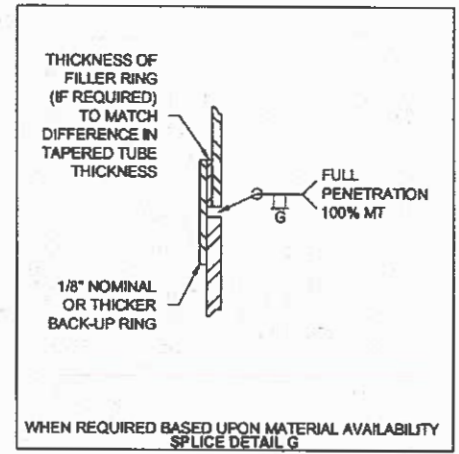
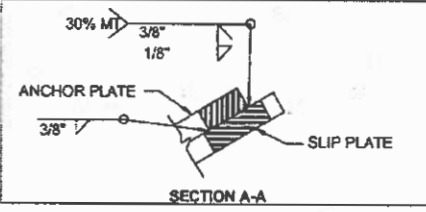
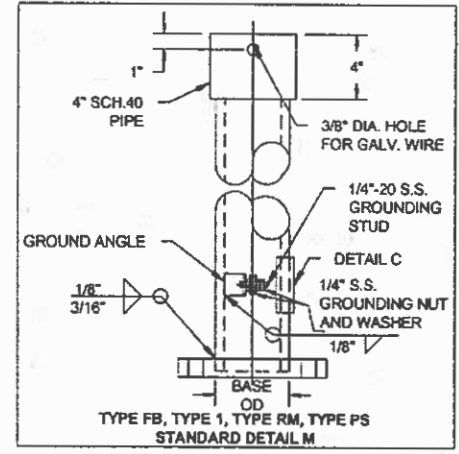
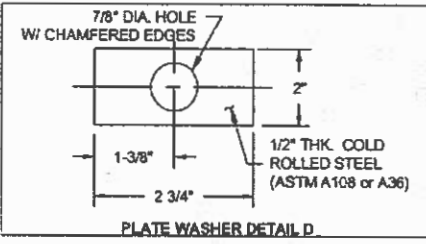
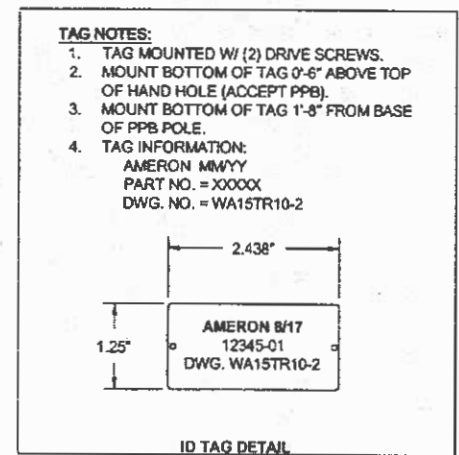
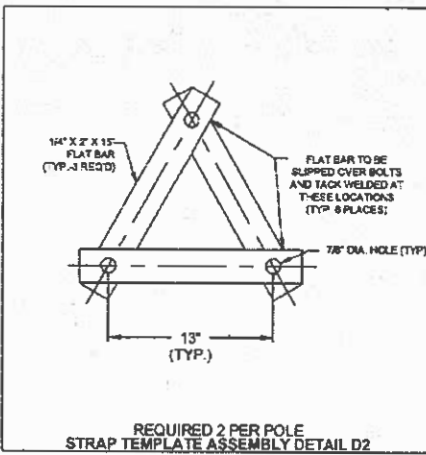


POLE DATA (SLIP BASE)

POLE DESCRIPTION	SHAFT LENGTH	BASE OD	END OD	THK	ANCHOR BOLTS							MAX EPA AT POLE TOP	
					BOLT CIRCLE "F"	BASE THK "BPT"	BASE I.D. "ID"	QTY	DIA	STD. LENGTH	CURB LENGTH		HOLE DIA "E"
Type PS-SB	8'-0"	5 1/4"	4 1/8"	.1196"	15"	3/4"	5 1/4"	3	3/4"	30"	36"	1"	25 R ²
Type 1-SB	10'-0"	5 1/4"	3 7/8"	.1196"	15"	3/4"	5 1/4"	3	3/4"	30"	36"	1"	25 R ²
Type RM-SB	10'-0"	5 1/4"	3 7/8"	.1196"	15"	3/4"	5 1/4"	3	3/4"	30"	36"	1"	25 R ²
Type FB-12-SB	12'-0"	5 1/4"	3 5/8"	.1196"	15"	3/4"	5 1/4"	3	3/4"	30"	36"	1"	24 R ²
Type FB-14-SB	14'-0"	5 13/16"	3 7/8"	.1196"	15"	3/4"	5 13/16"	3	3/4"	30"	36"	1"	19 R ²

GENERAL NOTES	
MATERIAL SPECIFICATIONS	
*STEEL TO HAVE SILICON CONTENT OF 0.0-0.06 OR 0.15-0.25	
*SHAFT	STEEL OF 50 K.S.I. MINIMUM YIELD. ASTM A-572 GR.50, ASTM A-595 GR. A, ASTM A-709 GR.50, ASTM A-1008 GR.50, ASTM A-1011 GR.50, ASTM A-1018 GR.50. THE ABOVE LISTED MATERIALS ARE USED BASED UPON AVAILABILITY AT TIME OF PURCHASE OF MATERIAL LOTS FOR PRODUCING POLE AND ARM SHAFTS
*BASE PLATE	ASTM A-36 STEEL
*MISC. PLATE	ASTM A-36
*PIPE	ASTM A-53 GR."B" OR ASTM A-500 GR."B"
*ANCHOR BOLTS	ASTM F-1554 GR. 55 ANCHOR BOLT MIN.
MANUFACTURING PROCESSES	
LONGITUDINAL WELDS	BUTT WELDED BY HIGH FREQUENCY ELECTRICAL RESISTANCE PROCESS
CIRCUMFERENTIAL	BUTT WELDED WITH PERMANENT BACKUP RING (CONTINUOUS)
FINISH COATING	
STRUCTURE	HOT DIP GALVANIZE PER ASTM A-123
HARDWARE	HOT DIP GALVANIZE PER ASTM F2329
DESIGN CRITERIA	
STRUCTURE AND HARDWARE	IN ACCORDANCE WITH TO 2015 AASHTO LRFD STANDARD SPECIFICATIONS FOR STRUCTURAL SUPPORTS FOR HIGHWAY SIGNS, LUMINAIRES, AND TRAFFIC SUPPORTS



APPROVED
 Manufacturer's Pole Plan
 Approved For Listing As A
 Pre-Approved Drawing
 WSDOT Bridge & Structures Office
 By GB Date 2-1-2019



WELDING INSPECTION:

- WELDING INSPECTION SHALL BE IN ACCORDANCE WITH THE REQUIREMENTS OF WASHINGTON STATE DEPARTMENT STANDARD SPECIFICATION SECTION 6-03.3(25) AND 2015 AASHTO, INCLUDING LATEST INTERIMS, WELD INSPECTION SECTION 14.5.3
- ALL LONGITUDINAL PARTIAL PENETRATION SEAM WELDS SHALL BE INSPECTED BY MAGNETIC PARTICLE METHOD ON THE OD FOR 30% OF LENGTH.
- COMPLETE JOINT PENETRATION (CJP) SEAM WELD WITH A SHAFT THICKNESS 0.3125 AND GREATER SHALL BE 100% ULTRASONICALLY INSPECTED.
- CJP WELD WITH A SHAFT THICKNESS OF LESS THAN 0.3125 SHALL BE MAGNETIC PARTICLE INSPECTED ON BOTH SIDES OF THE WELD WHEN BACKING IS NOT USED. THE CJP WELD SHALL BE INSPECTED THE ENTIRE LENGTH ON THE OD AND ID OF ALL SHAFTS. FOR SHAFTS WITH A NOMINAL OD LESS THAN 10.5 INCHES, WHERE ACCESS TO THE ID IS RESTRICTED, THE ID SHALL BE INSPECTED FOR A MINIMUM LENGTH OF 2 INCHES. SHAFTS WITH OD LESS THAN OR EQUAL TO 6 INCHES REQUIRE VISUAL INSPECTION ONLY AND SHALL BE PERFORMED PRIOR TO GALVANIZING.

WELDING:

- WELDING OF STRUCTURES SHALL BE IN ACCORDANCE WITH THE LATEST EDITION OF THE AWS STRUCTURAL WELDING CODE D1.1-STEEL. 60% MINIMUM PENETRATION IS REQUIRED FOR ALL LONGITUDINAL SEAM WELDS OF POLE AND ARM SECTIONS EXCEPT FOR THE FOLLOWING LOCATIONS WHICH REQUIRE 100% PENETRATION:
- 6 INCHES ADJACENT TO COMPLETE JOINT PENETRATION WELDS OF SHAFT TUBE TO BASEPLATE, FLANGE PLATE AND BUTT WELDED SPLICES WITH A NOMINAL OD OF 5" OR GREATER.
- 1.5 TIMES THE DIAMETER PLUS 6" ON ALL SLIP JOINTS OF THE FEMALE SECTION OF SHAFTS WITH A NOMINAL OD OF 10" OR GREATER.
- ONE DIAMETER ON ALL SLIP JOINTS OF FEMALE SECTION OF SHAFTS WITH A NOMINAL OD LESS THAN 10"

- NOTES:**
- TAPERED ROUND SHAFT WITH 0.1375 TAPER WITH 4 1/2" O.D. SLIP FITTER.
 - REFERENCE WASHINGTON D.O.T. STANDARD PLAN J-20.16-02 PEDESTRIAN SIGNAL STANDARD J-21.15-01 TYPE 1 SIGNAL STANDARD J-22.15-02 RAMP METER SIGNAL STANDARD J-21.16-01 FLASHING BEACON TYPE 1 SIGNAL STANDARD J-21.10-04 FOUNDATION DETAILS
 - AASHTO 2015 LRFD DESIGN PARAMETERS
 - LOCATION: STATE OF WASHINGTON
 - WIND VELOCITY: 115 MPH
 - MEAN RECURRENCE INTERVAL: 1700
 - NO FATIGUE
 - FOR P.S. POLES WITH "E" MOUNTING PEDESTRIAN SIGNALS, POLE WILL BE 10' TALL WITH THE SAME CHARTED DIMENSIONS AS THE TYPE 1 POLE.
 - SS STUD, NUTS & WASHERS ARE FIELD INSTALLED
 - AMERON RESERVES THE RIGHT TO INSTALL TOOLING LUGS OR HOLES TO FACILITATE IN THE GALVANIZING PROCESS. THESE LUGS/HOLES WILL NOT IMPEDE WITH THE FIT, FORM, OR FUNCTION OF THE FINISHED PRODUCT AND ARE TO BE USED SOLELY BY THE MANUFACTURE.
 - 10 GA. (0.1345") TUBE MAY BE SUBSTITUTED FOR 11 GA. (0.1196") BASED ON MATERIAL AVAILABILITY.
 - BACK-UP RING AND FILLER RING MATERIAL TO BE ASTM A36 OR AS LIST FOR SHAFT MATERIAL.
 - CUSTOMER TO SPECIFY IF POLE IS TO BE SLIP BASE AT TIME OF PLACING ORDER.
 - ORDERING INFORMATION:

SERIES	
TYPE PS-8-SB-DWG. NO.	
POLE HEIGHT	
SLIP BASE	

REV	DATE	DESCRIPTION	BY	CHK
C	1/24/19	REVISED DETAIL "F" RAINBOW RADIUS	BAHW	GM
B	9/10/18	REVISED PER WASHINGTON DOT COMMENT	ST	GM
A	9/4/18	REVISED PER WASHINGTON DOT COMMENT	ST	GM
REV	DATE	DESCRIPTION	BY	CHK

AMERON POLE PRODUCTS DIVISION
 STATE OF WASHINGTON
 AASHTO 2015 - LRFD
 TYPE PS, 1, RM & FB DETAILS

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DRAWN BY	DATE: 8/22/18	APPR. BY	DATE: 8/22/18
DRAWING NUMBER	WA15TR10-2	REVISION SHEET	C 1 OF 1
		SCALE	NTS