



MATERIAL SPECIFICATION	
SHAFT	STEEL OF 60000 P.S.I. MINIMUM YIELD AFTER FABRICATION ASTM A-372 GR.50 ASTM A-302 OR A ASTM A-702 OR GR.50 ASTM A-1011 OR GR.50 ASTM A-1018 OR 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 PL, FLANGES & MISC. PLATE	ASTM A-36 STEEL
PIPE	ASTM A-53 GRADE \"B\" OR ASTM A-500 GRADE \"B\"
ANCHOR BOLTS	ASTM F-1554 OR 1553 PER ASTM A-123
PIPE FINISH	HOT DIP GALVANIZED PER ASTM A-153
HARDWARE FINISH	HOT DIP GALVANIZED PER ASTM A-153
WELDS LONGITUDINAL	BUTT WELD BY THE ELECTRICAL RESISTANCE PROCESS
WELDS CIRCUMFERENTIAL	BUTT WELD WITH PERMANENT BACK-UP RING (CONTINUOUS)

NOTES

WELD: ALL BUTT WELDS TO BE GROUND FLUSH WITH BASE METAL. WELDING OF STRUCTURES SHALL BE IN ACCORDANCE WITH THE LATEST EDITION OF THE AWS STRUCTURAL WELDING CODE D1.1 - STEEL LONGITUDINAL SEAM WELD IS 60% MIN. PENETRATION, EXCEPT FOR 6" FROM END OF SECTION AT FLANGE, BASEPLATE AND SLIP JOINT ARE 100% PENETRATION.

TOLERANCES SHALL BE IN ACCORDANCE WITH SECTIONS 5.14.1 THROUGH 5.14.3 OF THE SPECIFICATION FOR STRUCTURAL SUPPORTS OF HIGHWAY SIGNS, LUMINAIRES AND TRAFFIC SIGNALS AASHTO 2009.

THE PERMISSIBLE VARIATION FOR STRAIGHTNESS OF THE TAPERED SECTIONS SHALL BE (.025 X SHAFT LENGTH) [19].

EXAMPLE:
A POLE WITH A SHAFT LENGTH OF 30' [9.1] SHALL NOT VARY MORE THAN 3/4" --- (.025 X 30) = .75 [19].

THE MOUNTING HEIGHTS WHICH ARE LISTED ON DRAWING(S) SHALL HAVE A PERMISSIBLE TOLERANCE OF ±8" [152].

- 1 OMITTED.
- 2 IF DESIRED SIGNAL ARM LENGTH IS NOT LISTED IN TABLES, THE NEXT LONGEST SIGNAL ARM SHALL BE USED WITH THE END CUT OFF TO FORM APPROPRIATE LENGTH.
- 3 3" SCH. 40 PIPE FOR LUM. ARMS 10' [3] AND LESS. 3 1/2" SCH. 40 PIPE FOR LUM. ARMS 12' [3.7] AND LARGER.
- 4 3 1/2" SCH. 40 PIPE FOR LUM. ARMS 10' [3] AND LESS. 4" SCH. 40 PIPE FOR LUM. ARMS 12' [3.7] AND LARGER.
- 5 DIMENSIONS IN [] ARE METRIC. INCHES CONVERTED TO MILLIMETERS AND FEET TO METERS.
- 6 3/4" PL. TO BE WELDED TO POLE TOP, SKIPPING SLOTTED AREA, THEN CONE IS WELD IN PLACE.
- 7 WHERE DISTANCE BETWEEN EXTENSION & TOP OF SMA CONNECTION BOX IS LESS THAN 8", HANDHOLE TO BE LOCATED AT CENTER OF BOX, OPPOSITE THE ARM AND CABLE HOOK LOCATED @ 90°.
- 8 USE 7 GAGE MIN. BACKING RING FOR 7 GAGE SHAFTS. USE 1/4" MIN. BACKING RING FOR ALL OTHER SHAFT THICKNESSES. BACKING RING TO BE 1" MINIMUM HEIGHT.



APPROVED
 Manufacturer's Pole Plan
 Approved For Listing As A
 Pre-Approved Drawing
 WSDOT Bridge & Structures Office
 By GB Date 1-29-2015

REV	DATE	DESCRIPTION	BY	APPR
K	12/14	PER WA. D.O.T. REQUEST	ST	GM
J	12/11	GENERAL REVISIONS	MHM	GM
I	9/07	REV. DTL. "A" ANCHOR PL.	BB	JB

Amperon POLE PRODUCTS DIVISION	
STATE OF WASHINGTON TYPE II AND III SERIES	
DRAWN: MMH DATE: 6/02 SCALE: N.T.S. DWG. NO. W3724-1 K	
APPR: JB	DATE: 6/02 SHEET 1 OF 2