



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

- נֿט בֿי FINISH: HOT DIP GALVANIZE PER ASTM-A153 (LATEST REVISION). BASEPLATE TO BE PERPENDICULAR TO SHAFT AXIS (±1ú) 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 THE CONCENTRIC (±, 12

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- IN LINE (±20).

 FLAME CUT SLOT PERPENDICULAR TO THE BASEPLATE,
 FLAME CUT SLOT PERPENDICULAR TO THE BASEPLATE,
 PREHEAT, TUMBLEBLAST, HANDGRIND, AND CLEAN BASEPLATE,
 HELIX, AND PILOT POINT ON ALL WELDED AREAS.
 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. ABDVE NOMINAL
 SURFACE LEVEL OR INTERSECTIONS OF NOMINAL SURFACES.
 MANUFACTURER TO HAVE IN EFFECT INDUSTRY RECOGNIZED WRITTEN
 QUALLTY COUNTROL FOR ALL MATERIALS AND MANUFACTURING PROCESSES.
 ALL MATERIAL IS TO BE NEW, UNUSED AND MILL TRACEABLE
 MEETING THE FOLLOWING SPECIFICATIONS:

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BASEPLATE: ASTM A36-(LATEST REVISION) HOT ROLLED STEEL PLATE, (CONFORM TO AASHTO TECH. BUL. #270)

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.

HELL IX: ASTM A635 (LATEST REVISION) HOT ROLLED STEEL

PILOT POINT: ASTM A575 (LATEST REVISION) STEEL BAR CARR BOLT PER

10. BASEPLATE IS PERMANENTLY S' IDENTIFICATION "ABC" IN 1/1 IN 1/4" LETTERS.

DRN BY:

DATE

SE® (CA) CENTRALIA, MI. USA SA 11242NG4VP	TITE SETLIGHT FOUNDATION C E	IGINEER	QUANTITY: 10	ETLIGHT FOUNDATION NO. C11242NG4VP	ARE CUNFIDENTI	AL AND THE FXC	RMANENTLY STAMPED WITH MANUFACTURER'S ABC' IN 1/2' LETTERS AND DATE CODE	R BOLT PER ANSI B-18.2.1, SAE J429 GRADE-5.
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