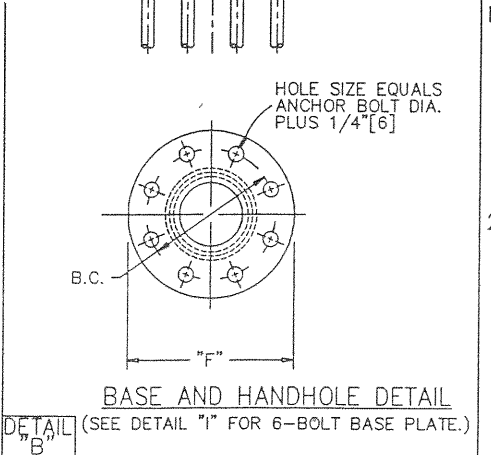


GENERAL NOTES	
MATERIAL SPECIFICATIONS	
SHAFT	ASTM A-570 OR A-572 W/ MINIMUM OF 50,000 PSI [345 MPa]
BASEPLATES AND FLANGES	ASTM A36
PIPE	ASTM A-53 GRADE "B"
ANCHOR BOLTS	ASTM F1554 GR. 55
MANUFACTURING PROCESSES	
LONGITUDINAL WELDS	BUTT WELDED BY SUBMERGED ARC PROCESS
FINISH COATING	
STRUCTURE	HOT DIP GALVANIZE PER ASTM A-123
HARDWARE	HOT DIP GALVANIZE PER ASTM A-153
DESIGN CRITERIA	
STRUCTURE AND HARDWARE	IN ACCORDANCE WITH THE "SPECIFICATIONS FOR STRUCTURAL SUPPORTS OF HIGHWAY SIGNS, LUMINAIRES AND TRAFFIC SIGNALS, AASHTO 1994 FOR 80 MPH (129 KM/H) x 1.3 GUST W/MAX. E.P.A. OF 36 SQ. FT AND 1000 LBS. MOUNTED AT THE TOP OF THE POLE
WELDING	IN ACCORDANCE WITH SECTION 1.4.2 OF THE SPECIFICATIONS FOR STRUCTURAL SUPPORTS OF HIGHWAY SIGNS, LUMINAIRES AND TRAFFIC SIGNALS, AASHTO 1994



- NOTES:
- EACH SECTION HAS 2 LONGITUDINAL SEAMS W/60% PENETRATION WELDS -EXCEPT- FOR THE LONGITUDINAL SEAM WELDS ON BOTH SECTIONS, AT A SLIP JOINT, WHICH SHALL BE A COMPLETE PENETRATION WELD FOR THE DISTANCE OF THE SLIP LENGTH PLUS 6" [150].
 - WELD INSPECTION:
 - 100% OF ALL COMPLETE PENETRATION LONGITUDINAL WELDS & BASE PLATE TO POLE SHAFT WELD SHALL BE INSPECTED BY ULTRASONIC METHOD.
 - 100% OF ALL PARTIAL PENETRATION WELDS ARE VISUALLY INSPECTED & 25% SHALL BE TESTED BY MAGNETIC PARTICLE METHOD.
 - ALL TEST RESULTS ARE TO BE MARKED WITH AN IDENTIFICATION NUMBER THAT IS MARKED ON THE POLE.
 - POLE SIZES ARE MEASURED FLAT TO FLAT.
 - ALL SECTIONS WILL BE MATCH MARKED WITH POLE NO. & SECTION LETTER. EXAMPLE: SECTION "A" FOR POLE NO. 1 WILL HAVE 1A WELD AT TOP OF SECTION. SECTION "B"&"C" WILL HAVE 1B&1C WELD AT TOP & BOTTOM OF SECTION. SECTION "D" WILL HAVE 1D AT BOTTOM OF SECTION.

APPROVED

APPROVED AS NOTED

REVISE AND RESUBMIT

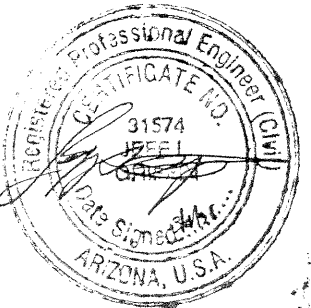
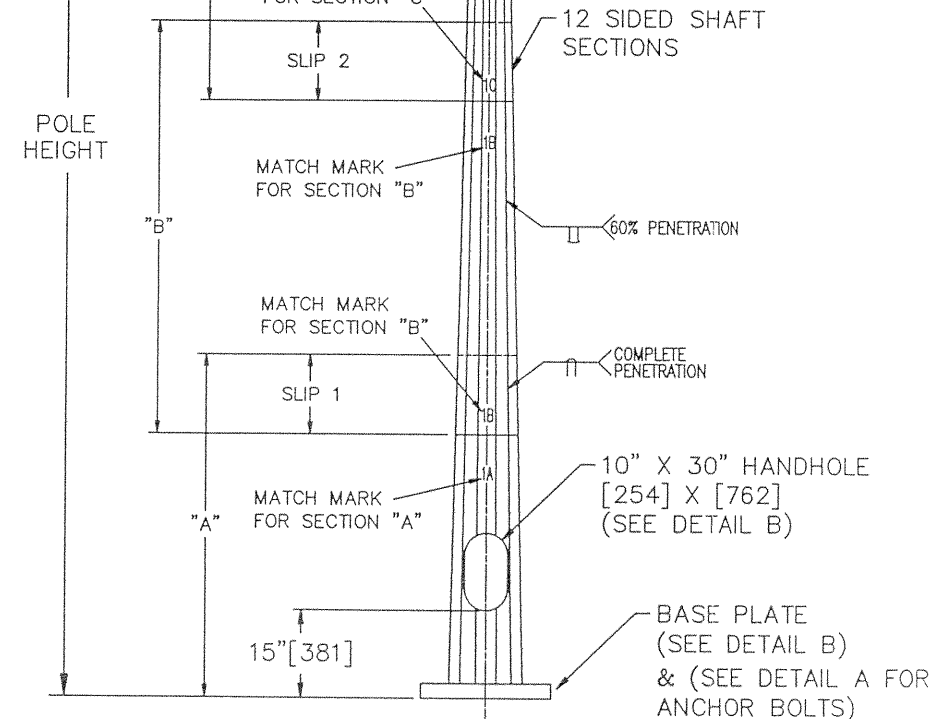
DISAPPROVED

A. Wojcikiewicz

DATE *Apr. 3, 98*

REVIEW IS ONLY FOR GENERAL CONFORMITY TO THE CONTRACT DRAWINGS AND SPECIFICATIONS, AND SHALL NOT RELIEVE THE CONTRACTOR OF HIS ENTIRE RESPONSIBILITY UNDER THE CONTRACT INCLUDING, AMONG OTHER THINGS DIMENSIONS TO BE USED AND CORRELATED AT THE JOB SITE, AND INFORMATION ON THAT PERTAINS TO THE FABRICATION PROCESSES OR TO TECHNIQUES OF CONSTRUCTION.

PARSONS, BRINCKERHOFF
QUADE & DOUGLAS, INC.
1501 W. FOUNTAINHEAD PKWY.
SUITE 400
TEMPE, ARIZONA
85282



MATERIAL LIST	
QTY.	DESCRIPTION

AGENCY: ARIZONA DOT
PROJECT:
PROJECT NO.:
DISTRIBUTOR:
CONTRACTOR:
CUSTOMER ORDER NO.:
AMERON NO.:

POLE NO.	MODEL NO.	POLE HEIGHT (FEET) [METERS]	POLE SECTION DETAIL												ANCHOR BOLT DATA			BASEPLATE DATA		
			SECTION "A" (BASE)	THK.	SLIP 1	SECTION "B"	THK.	SLIP 2	SECTION "C"	THK.	SLIP 3	SECTION "D"	THK.	QTY.	DIA.	LGTH.	B.C.	"T"	"F"	
	HM100-AZHM01	100'-0" [30.48]	20.00" x 16.54" x 24'-6" [508] x [420] x [7.47]	1/4" [6.35]	2'-6" [0.76]	17.52" x 11.87" x 40'-0" [445] x [301] x [12.19]	1/4" [6.35]	2'-0" [0.61]	12.65" x 7.00" x 40'-0" [321] x [178] x [12.19]	3/16" [4.76]										
	HM120-AZHM01	120'-0" [36.58]	22.50" x 16.68" x 42'-0" [573] x [424] x [12.80]	5/16" [7.94]	2'-6" [0.76]	17.65" x 11.83" x 42'-0" [448] x [300] x [12.80]	1/4" [6.35]	2'-0" [0.61]	12.61" x 7.00" x 40'-6" [320] x [178] x [12.34]	3/16" [4.76]										
	HM150-AZHM01	150'-0" [45.72]	27.00" x 21.59" x 37'-6" [686] x [548] x [11.43]	5/16" [7.94]	3'-0" [0.91]	22.7" x 17.01" x 40'-0" [577] x [432] x [12.19]	5/16" [7.94]	2'-6" [0.76]	18.12" x 12.35" x 40'-0" [460] x [314] x [12.19]	5/16" [8]	2'-0" [0.61]	13.27" x 7.50" x 40'-0" [337] x [191] x [12.19]	1/4" [6.35]	8	2 1/4" [57.1]	96" [2438]	33" [813]	2" [50.8]	38" [965]	

AMERON POLE PRODUCTS DIVISION

STATE OF ARIZONA
HI-MAST LIGHTING POLES

THIS DOCUMENT CONTAINS INFORMATION WHICH IS PROPRIETARY TO AMERON. IT SHALL NOT BE REPRODUCED OR DISCLOSED TO ANYONE WITHOUT THE PRIOR WRITTEN PERMISSION OF AMERON.

DRAWN: S.M.O. DATE: 12/97 SCALE: AZHM01 REV.
APPR: GM DATE: 12/97