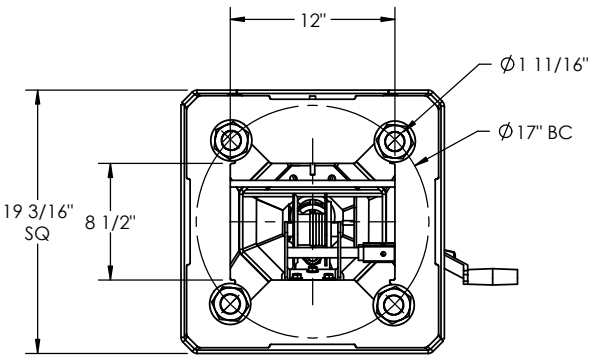
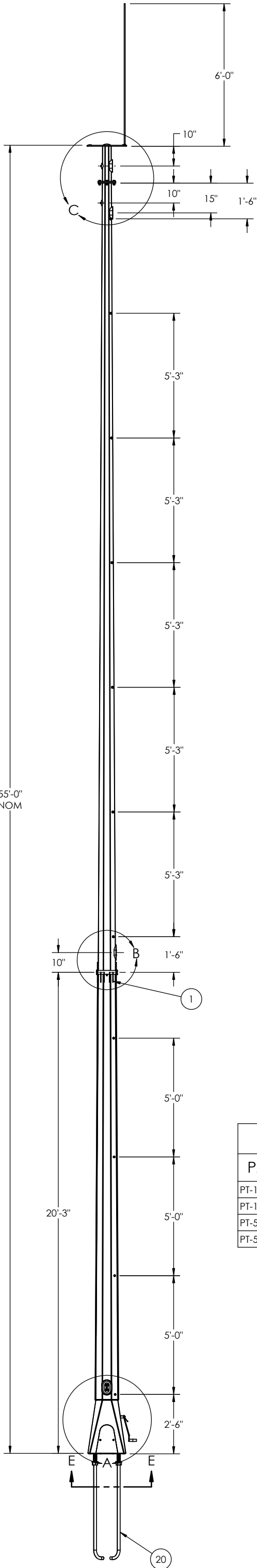
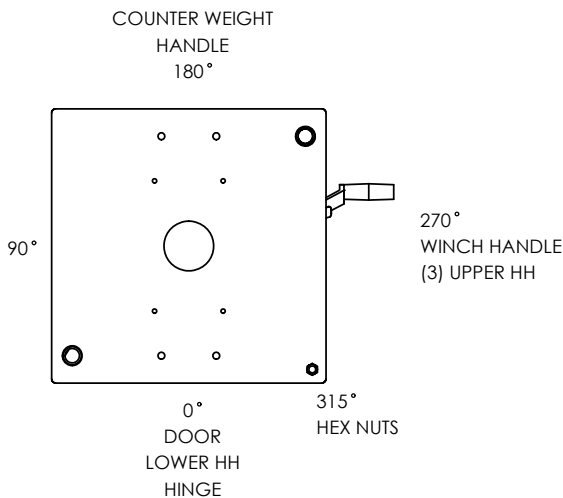


REVISIONS				
REV.	ECO	DESCRIPTION	DATE	DRFT
A		REF 37HH12250-550-1TS-001	4/30/2025	TK



SECTION E-E
SCALE 1 : 14



POLE DESIGNED TO MEET:

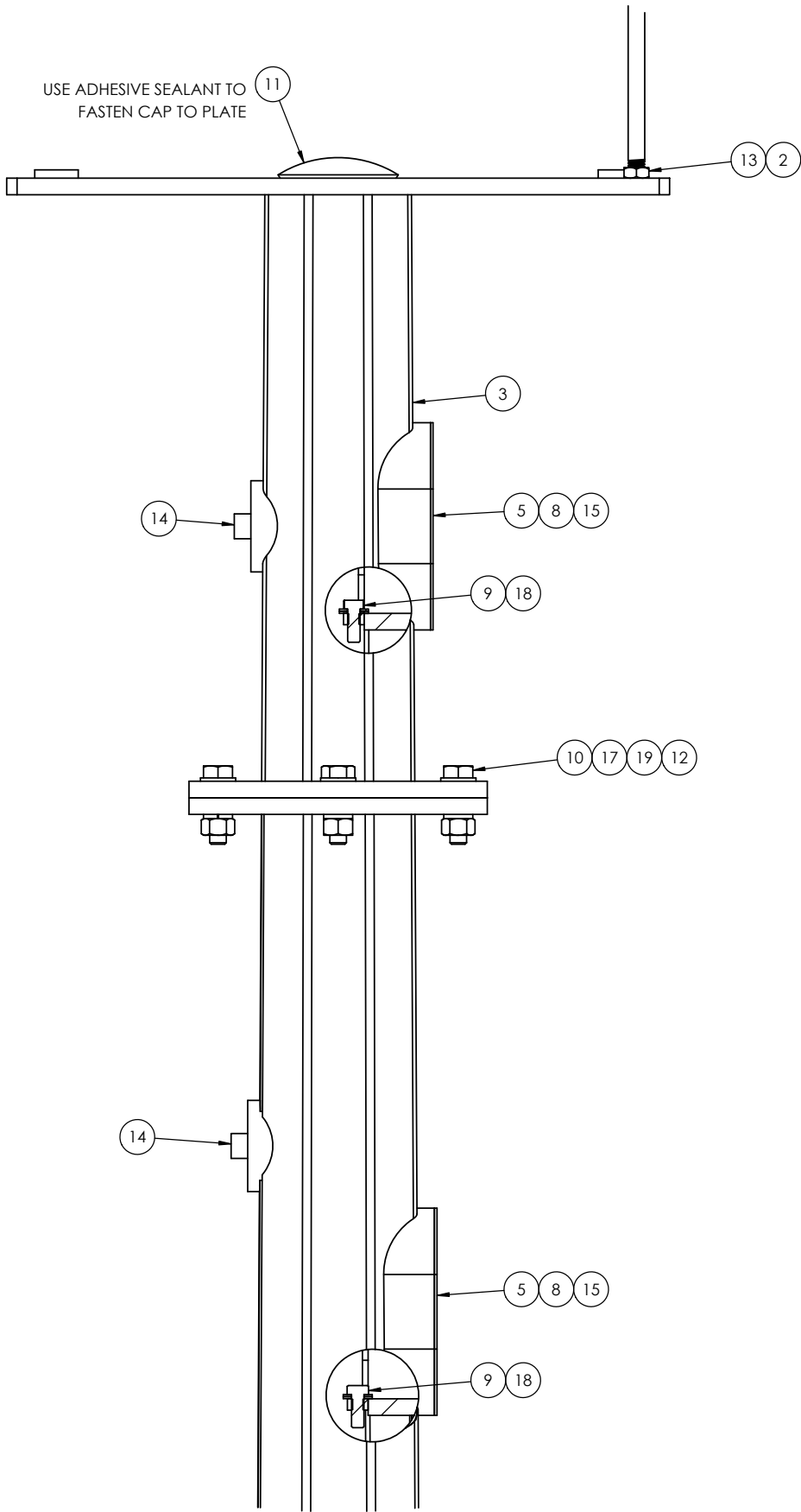
Max EPA - 4.3 sq. ft

Max weight - 200 lbs

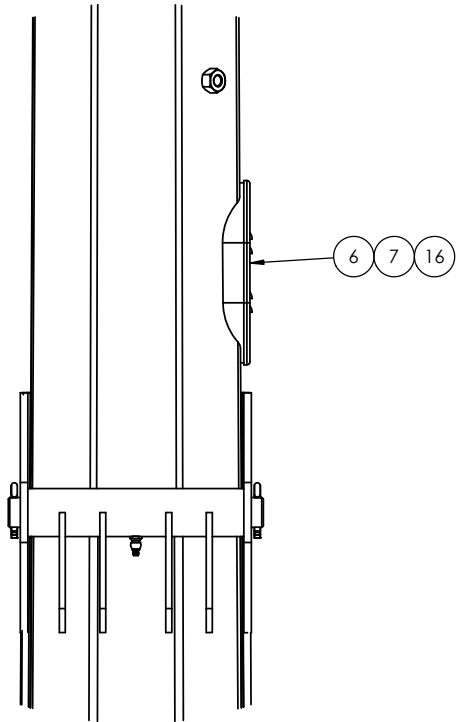
**ALTERNATE ORANGE & WHITE IN 7 EQUAL
SPACES APPROXIMATELY 7'10" APART START
WITH ORANGE & END W/ORANGE**

ITEM NO.	PART NUMBER	DESCRIPTION	QTY PER	ASSY	FINISH
1	1058550	ASSY POLE HINGE 53'6	1		X
2	1059474	COPPER CLAD LIGHTNING ROD 1/2"X6'0 - 1" THD	1		
3	1079228	WLDMT ADAPTER 3/16 X 1'6" (3/16X6.01X5.8X1'6 8S SHAFT)	1		X
4	500A319	WINCH CRANK HANDLE ASSY (K1051)	1		
5	8800267	COVER HH M15 3X5 FORMED	2		X
6	9900029-GV	COVER HH M16 4X6	2		X
7	9900030	LATCH HH M16 4X6	2		
8	9900037	LATCH HH M15 3X5	2		
9	BOLTA3/8-16X1"A	BOLT HX HD 3/8-16NC X 1" F593C SS	2	X	
10	BOLTB1/2-13X2"B	BOLT HVYHXHD 1-2-13NC X 2" A325 GV	4		
11	CAP-DELTECH-8600015	CAP PLASTIC DELTECH RD. 3 1/2" DIA	1		X
12	NUTHVYHX1/2-13A563GV	NUT HVY HX 1-2-13NC A563 GV (DH)	4		
13	NUTHXJM1/2-13SS	NUT HX JM 1-2-13NC SS	1		
14	PLUG-THD-GV-2"	PLUG THREADED 2"SQ HD METAL PLUG GV	2	X	
15	SCRWA5/16-18X2"SS	SCRWA HX SK FL HD 5-16-18NC X 2 SS	2		
16	SCRWA5/16-18X2-1/2SS	SCRWA HX SK FL HD 5-16-18NC X 2-1-2 SS	2		
17	WASHFLAT1/2GV	WASHER FLAT 1/2 GV	4		
18	WASHFLAT3/8BRASS-001	WASHER FLAT .395IDX7/8OD X .064THK	4	X	
19	WASHLOCK1/2GV	WASHER LOCK 1/2 GV	4		
20	460A12-6DNW-C-T-12"	AB 1-1/2"X55 3/4"-F1554-SET/4-DNW W/CAGE AND TEMPLATE	4		REF

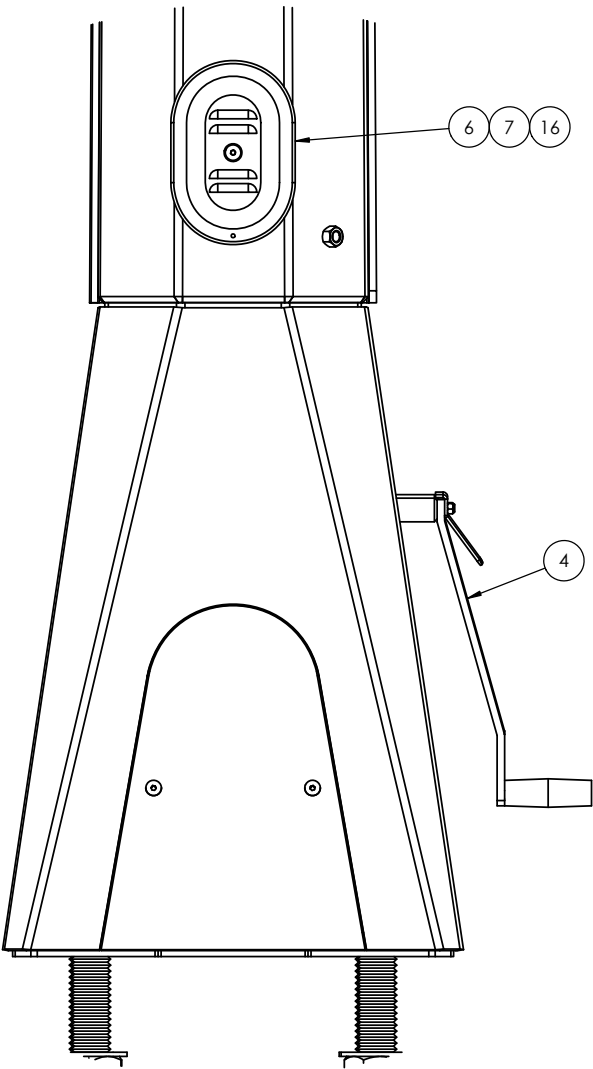
FINISH			MATERIAL SPECIFICATIONS	
PAINT PART #	DESCRIPTION	QTY	POST: ASTM A572 GR 50 BASE PLATE: ASTM A36 MAST ARM: MOUNTING PLATE: LUMINAIRE ARM: HARDWARE FINISH: ASTM A153 ANCHOR BOLTS: AASHTO M314 GR105 SIZE: 1 1/2"	
PT-1-17-FTU-009-FR	HIGH GLOSS FIN COAT ULTRA AVIATION WHITE FREDA	REF	DESIGN CRITERIA	
PT-1-17-FTU-010-FR	HIGH GLOSS FIN COAT AVIATION ORANGE URETHANE	REF	2015 AASHTO STANDARD SPECIFICATIONS FOR STRUCTURAL SUPPORTS ON HIGHWAY SIGNS, LUMINAIRES & TRAFFIC SIGNALS. ICE LOAD: 3.0 psf FOR ALL SURFACES AS REQUIRED BY SECTION 3.7 WINDS: 140 MPH VORTEX SHED: N/A FATIGUE CAT: NO GALLOPING: N/A NATURAL WIND GUST: N/A TRUCK GUST: N/A	
PT-5-17-FTU-009-FR-EA	HIGH GLOSS FIN COAT ULTRA AVIATION WHITE FREDA		WELD SPECIFICATION	
PT-5-17-FTU-010-FR-EA	HIGH GLOSS FIN COAT AVIATION ORANGE URETHANE		THE POST AND MAST ARM TO BE A TAPERED TUBE FABRICATION WITH ONE SUBMERGED ARC LONGITUDINAL SEAM WELD WITH 100% PENETRATION 6" FROM BASE PLATE AND 60% FOR REMAINDER. GAS METAL ARC WELDING PROCESS WITH 60% PENETRATION MAY BE USED FOR REMAINDER OF WELDED FABRICATION. WELD TESTING: 100% OF ALL WELDS VISUAL TESTED (VT), 100% OF ALL COMPLETE JOINT PENETRATION (CJP) WELDS ULTRASONIC TESTED (UT) BASED ON THE THINNEST MATING MATERIAL: (PER AASHTO 2013 5.15.5-WELD INSP) THICKNESS. < 6MM (0.25 IN) MT ≥ 6MM (0.25 IN) UT A RANDOM 30% OF ALL FILLET WELDS AND PARTIAL JOINT PENETRATION (PJP) LONGITUDINAL SEAM WELDS MAGNETIC PARTICLE TESTED (MT).	
 MILLERBERND 622 6TH ST. SO. WINSTED, MN 55395 THIS DOCUMENT CONTAINS CONFIDENTIAL INFORMATION AND IS THE PROPERTY OF MILLERBERND MFG AND MAY NOT BE COPIED, REPRODUCED OR DISCLOSED IN ANY MATTER WITHOUT THE EXPRESS WRITTEN CONSENT FROM MILLERBERND MFG SALES ORDER NO.: QTY: STATE: SHEET 1 OF 2 DESCRIPTION: SHIP POLE HINGE 55'0 HALI-BRITE L-801 6'0 BEACON EST. WEIGHT: 1802.01 DRAWING NO: AGL-HINGE-15-140-55-H PROJECT NAME:			FINISH SPECIFICATION	
			GALV. OR PRIME COAT: HOT DIP GALV PER ASTM A123 FINISH COAT: COLOR: CHART FEDERAL OR RAL SPEC.: WEIGHT W/GALV.: 1858.77 WEIGHT W/GALV.&PAINT: 1874.09 WEIGHT W/PAINT: 1802.01 SURFACE AREA: 49867.29 GAL. OF PAINT: 1.91797	
PROJECT LOCATION:				
DWN BY: TRAVIS K.		DATE: 04-30-2025		
CHK BY:		DATE:		



DETAIL C
SCALE 1 : 5



DETAIL B
SCALE 1 : 8



DETAIL A
SCALE 1 : 8

MATERIAL SPECIFICATIONS	
POST: ASTM A572 GR 50 BASE PLATE: ASTM A36 MAST ARM: MOUNTING PLATE: LUMINAIRE ARM: HARDWARE FINISH: ASTM A153 ANCHOR BOLTS: AASHTO M314 GR105 SIZE: 1 1/2"	
DESIGN CRITERIA	
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WELD SPECIFICATION	
THE POST AND MAST ARM TO BE A TAPERED TUBE FABRICATION WITH ONE SUBMERGED ARC LONGITUDINAL SEAM WELD WITH 100% PENETRATION 6" FROM BASE PLATE AND 60% FOR REMAINDER. GAS METAL ARC WELDING PROCESS WITH 60% PENETRATION MAY BE USED FOR REMAINDER OF WELDED FABRICATION. WELD TESTING: 100% OF ALL WELDS VISUAL TESTED (VT), 100% OF ALL COMPLETE JOINT PENETRATION (CJP) WELDS ULTRASONIC TESTED (UT) BASED ON THE THINNEST MATING MATERIAL: (PER AASHTO 2013 5.15.5-WELD INSP) THICKNESS. < 6MM (0.25 IN) MT ≥ 6MM (0.25 IN) UT A RANDOM 30% OF ALL FILLET WELDS AND PARTIAL JOINT PENETRATION (PJP) LONGITUDINAL SEAM WELDS MAGNETIC PARTICLE TESTED (MT).	
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622 6TH ST. SO.
WINSTED, MN 55395

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SALES ORDER NO.:	QTY:	STATE:	SHEET 2 OF 2		
DESCRIPTION: SHIP POLE HINGE 55'0 HALI-BRITE L-801 6'0 BEACON					
EST. WEIGHT: 1802.01		DRAWING NO: AGL-HINGE-15-140-55-H			
PROJECT NAME:					
PROJECT LOCATION:					
DWN BY: TRAVIS K.		DATE: 04-30-2025			
CHK BY:		DATE:			