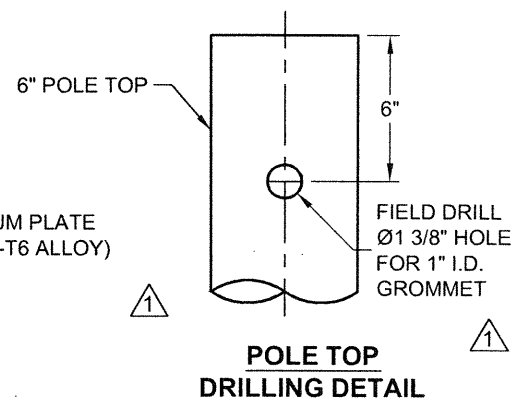
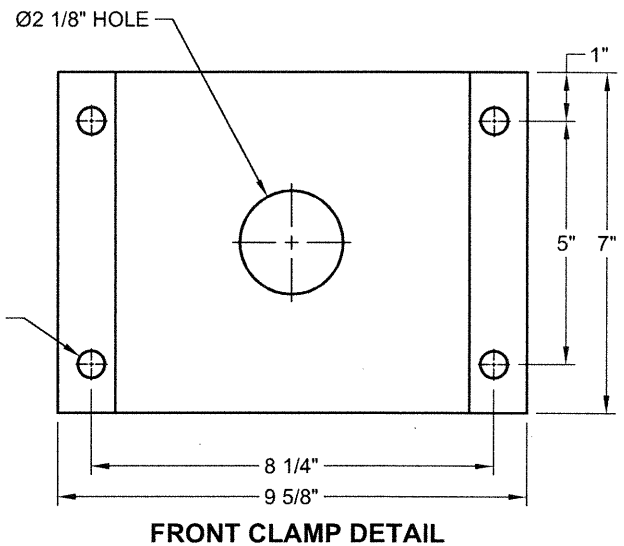
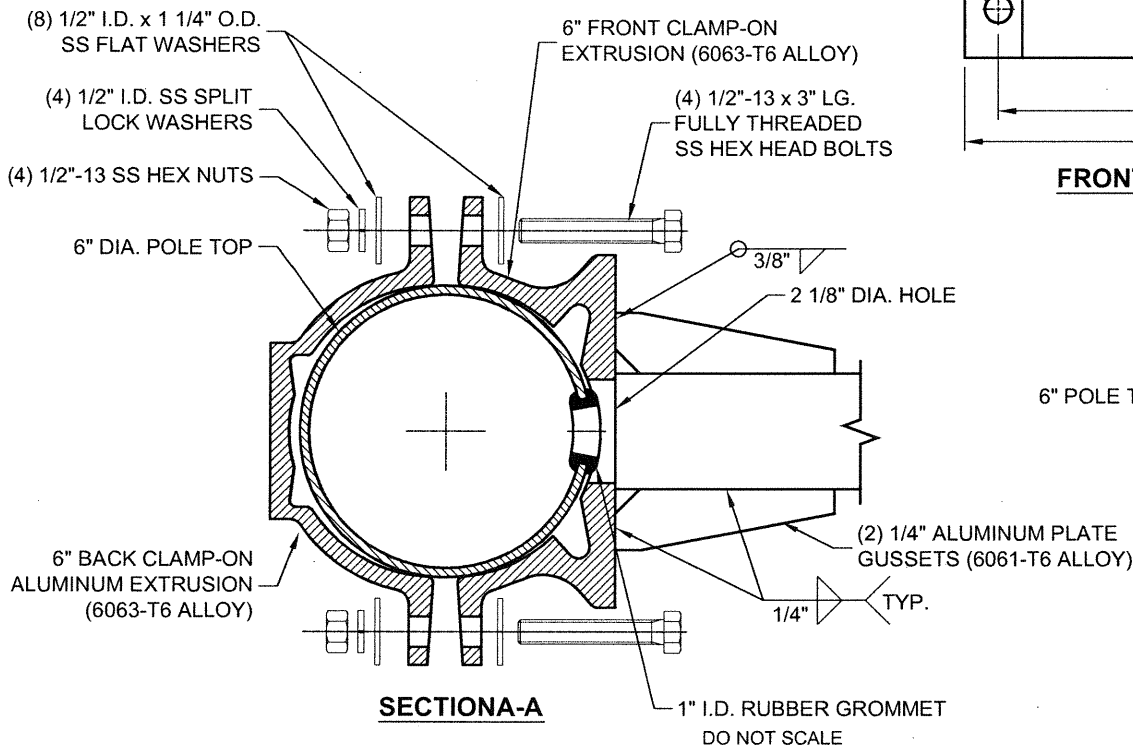


**NOTE:**

1. WELDING WIRE (ER4043).
2. MAST ARM HEAT TREATED AFTER FABRICATION TO T6 CONDITION.
3. ALL HARDWARE IS 300 SERIES STAINLESS STEEL.
4. ALL HARDWARE TO BE COATED WITH ANTI-SEIZE COMPOUND BY CONTRACTOR IF REQUIRED.

**TIGHTENING SEQUENCE**

1. TIGHTEN WITH HAND
2. APPLY 31.50 FT.LBS
3. APPLY 40.00 FT.LBS
4. APPLY 42.00 FT.LBS



**valmont**

Valmont Industries, Inc. Structures Division  
20805 Eaton Ave Farmington, Minnesota 55024-7932  
Phone: (651) 463-8990 (800) 899-7577  
Fax: (651) 463-3349

**\*\*CONFIDENTIAL\*\***

The information contained in this drawing is privileged and confidential, and may be protected from disclosure. Please be aware that any use or dissemination of this drawing may be subject to legal restriction or sanction.

TITLE: S 4' x 24" x 3.5" SGL MS ARM 6.0" CL F.S.

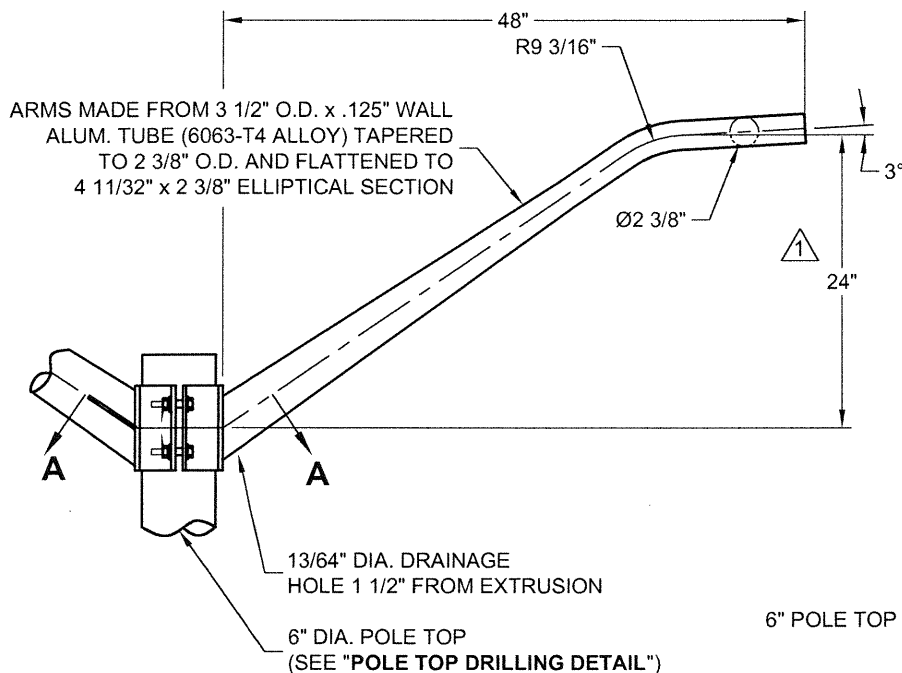
PART NO.: 1MA0424C60Z  
MATERIAL: ALUMINUM ALLOY  
FINISH: 100 GRIT SATIN POLISH  
PROJECT:  
SOLD TO: WISDOT  
SHIP TO:  
P.O. NO:  
REP:

QTY:

DWN BY: SLF  
CHK'D BY:  
APPR BY: *CEW*  
DATE: 03/10/11

REV	DATE	REVISION DESCRIPTION
1	01/19/15	CH'D ARM RISE DEGREE TO 3°; ADDED NOTE
2	01-22-13	ADDED GUSSETS, ADDED NOTES

DWG NO: DR1154  
PAGE: 8 / 25

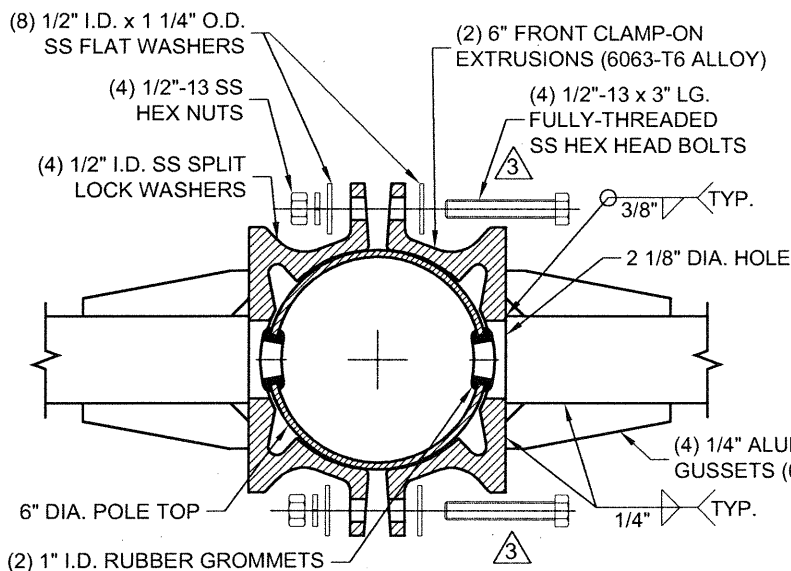


#### NOTE:

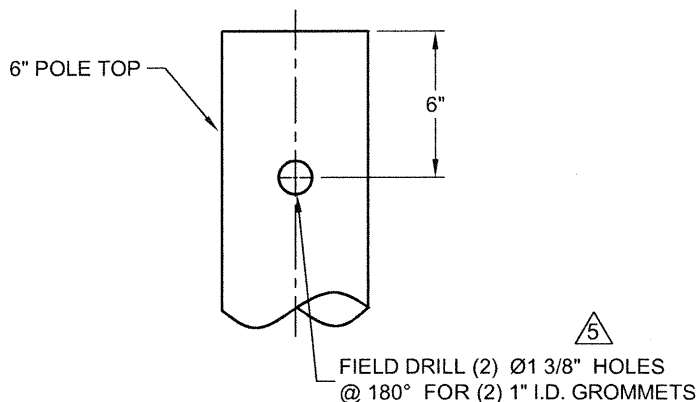
1. WELDING WIRE (ER4043).
2. MAST ARM HEAT TREATED AFTER FABRICATION TO T6 CONDITION.
3. ALL HARDWARE IS 300 SERIES STAINLESS STEEL.
4. ALL HARDWARE TO BE COATED WITH ANTI-SEIZE COMPOUND BY CONTRACTOR IF REQUIRED.

#### TIGHTENING SEQUENCE <sup>6</sup> FOR Ø1/2" STAINLESS STEEL BOLTS

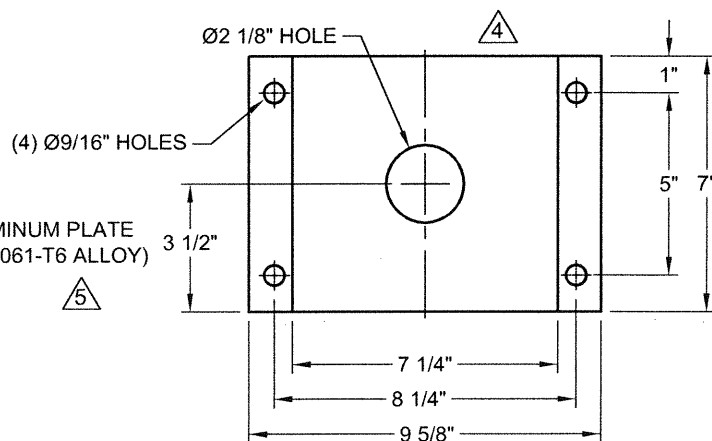
1. TIGHTEN WITH HAND
2. APPLY 31.50 FT.LBS
3. APPLY 40.00 FT.LBS
4. APPLY 42.00 FT.LBS



**SECTION A-A**



**POLE TOP DRILLING DETAIL**



**FRONT CLAMP DETAIL**

DO NOT SCALE

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Fax: (651) 463-3349

TITLE: S 4' x 24" x 3.5" DBL MS ARM 6" CL F.S.

PART NO.: 2MA0424C60Z  
MATERIAL: ALUMINUM ALLOY  
FINISH: 100 GRIT SATIN POLISH  
PROJECT: WISDOT  
SOLD TO:  
SHIP TO:  
P.O. NO:  
REP:

QTY:

OWN BY: BMS  
CHK'D BY:

APPR BY: *CEW*  
DATE: 12/12/05

**\*\*CONFIDENTIAL\*\***

The information contained in this drawing is privileged and confidential, and may be protected from disclosure. Please be aware that any use or dissemination of this drawing may be subject to legal restriction or sanction.

REV	DATE	REVISION DESCRIPTION	BY
1	01-22-15	ADDED NOTE	KPS
2	01/21/13	UPDATED NOTES	PVB
3	03/10/10	CHANGED PAGE NUMBERING, UPDATED DETAIL	SLF
21	12/12/05		21 / 25