



NOTE:

- MATERIAL - 100% STRENGTH LOW ALLOY STEEL 50,000 PSI MIN YIELD PER ASTM A572. POST AND MASTARM MOUNTING BASE MATERIAL PER ASTM A36.
- FINISH - HOT DIP GALVANIZED PER ASTM A123 WITH TOP COAT PAINTED MILLERBERND FLYN BLACK MILLERBERND #PX-1-17-VTD-D93-3R
- POST TO BE ROUND TUBE FABRICATED WITH ONE SUBMERGED ARC LONGITUDINAL SEAM WELD WITH 100% PENETRATION 6" FROM BASE PLATE AND 60% FOR REMAINDER. GAS METAL ARC WELDING PROCESS TO BE USED FOR REMAINDER OF WELDED FABRICATION WITH 100% PENETRATION WELD FOR BASE PLATE TO SHAFT CIRCUMFERENTIAL WELD.
- WELD TESTING - 100% PENETRATION WELDS ULTRASONIC TESTED (UT) USING THE CYCLICALLY LOADED ACCEPTANCE/REJECTION CRITERIA TABLE 6.8 OF AWS D11 SPECIFICATION. 100% OF THE POST/MASTARM CONNECTION WELDS MAGNETIC PARTICLE TESTED (MT) AND A RANDOM 50% OF REMAINING FILLET WELDS & PARTICLE PENETRATION LONGITUDINAL SEAM WELDS MAGNETIC PARTICLE TESTED (MT).
- HX HD BOLTS & NUTS (UNLESS SPECIFIED) ASTM A325 GALV A153 FOR SIZES 1/4 TO 1 1/2 DIA & ASTM A354BC OR A193 FOR SIZES OVER 1 1/2 DIA.
- THE POST AND THE FOLLOWING ITEMS WILL BE SHIPPED UNASSEMBLED:
 - (1) 500B45 HX HD COVER
 - (1) 500B44-2 HX HD LATCH
 - (1) 5/16-18NC X 2 1/2 LG HX SCKT FL HD SCREW (18-8 SS)
 - (1) 598B11-2 STEEL CAP
 - (1) 1/4-20NC X 3" LG SLOTS RD HD MACHINE SCREW (18-8 SS)
 - (1) 1/4 FLATWASHER (18-8 SS)
 - (1) 500B43-1 HX HD COVER
 - (1) 500B43-2 HX HD LATCH
 - (1) 5/16-18NC X 2" LG HX SCKT FL HD SCREW (18-8 SS)



IDENTIFICATION TAG EXAMPLE

REV 1-28-14 BEFORE 2. ARR TO TOP GUSSET WAS W/1889 ARM PLATE TO GUSSET BOTTOM WAS 5/16
 REV 11-27-13 GUS PILE BAR, WAS 1/2" DIA 1/4
 REV 11-19-13 REPAIR POST, WAS REPAIR-180/286-15-VT
 REV 10-21-13 CORRECT UPPER HAND HOLE CALLOUT ON MAIN VIEW FROM HIG HX TO HIG HX

PART NO	QTY	DESCRIPTION	BY	DATE
708B1273	1	SIGNAL POST	3/16X12.0X28.6	3/16 X 12.0 X 28.6

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DATE: 9-17-13

CHK: REBEKAH

SCALE: NTS

RE28A-180/286-J315-VT ROUND SIGNAL POST
 3/16 X 12.0 X 28.6" POST
 LUMINAIRE ARM AT 315 DEG

Millerbernd MANUFACTURING CO. WINDSTED, MN

780B1273