



- NOTE:
- MATERIAL-HIGH STRENGTH LOW ALLOY STEEL 50,000 PSI MIN YIELD PER ASTM A572. POST AND MAST ARM MOUNTING BASE MATERIAL PER ASTM A36.
 - FINISH- HOT DIP GALVANIZED PER ASTM A123 WITH TOP COAT PAINTED MILLERBERND PLAT BLACK MILLERBERND 8PT-1-17-PDU-093-FR.
 - POST TO BE ROUND TUBE FABRICATED WITH ONE SUBMERGED ARC LONGITUDINAL SEAM WELD WITH 100% PENETRATION 6" FROM BASE PLATE AND 50% 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 6.3 OF AWS D1.1 SPECIFICATION. 100% OF THE POST/MAST ARM CONNECTION WELDS MAGNETIC PARTICLE TESTED (MT) AND A RANDOM 30% 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 A394BC GV A153 FOR SIZES OVER 1 1/2 DIA.
 - THE POST AND THE FOLLOWING ITEMS WILL BE SHIPPED UNASSEMBLED:
 - (1) 500845 M16 HH COVER
 - (1) 500844-2 M16 HH LATCH
 - (1) 5/16-18NC X 2 1/2 LG HX SCKT FL HD SCREW (18-8 SS)
 - (1) 500811-23 STEEL CAP
 - (1) 1/4-20NC X 3' LG SLOTTED RD HD MACHINE SCREW (18-8 SS)
 - (1) 1/4 FLAT WASHER (18-8 SS)
 - (1) 500843-1 M16 HH COVER
 - (1) 500843-2 M16 HH LATCH
 - (1) 5/16-18NC X 2' LG HX SCKT FL HD SCREW (18-8 SS)



PART NO.	QTY	DESCRIPTION	'A' POST TAG INFORMATION	'B' MAST ARM TAG INFORMATION
780B1312	1	SIGNAL POST	3/16 X 12.0 X 28'-6" POST	3/16 X 3.0 X 5.6 X 25.0

PO#2250-2138 / VT DOT: SKP.0284 (17) RICHMOND / US ROUTE 3, VT ROUTE 117, US ROUTE 2, OFF-RAMP (RAMP D) / MILLERBERND #51680

DWN BOUG F. REPHA-180/286-J300-VT ROUND SIGNAL POST
3/16 X 12.0 X 28'-6" POST
LUMINAIRE ARM AT 300 DEG

CHK: REBEKAH
SCALE: NTS

Millerbernd MANUFACTURING CO. WINDST, NH 780B1312

REV 1-20-14 DETAIL 2: ARM TO TOP GUSSET WELD WAS W/ISSU ARM PLATE TO GUSSET & BOTTOM WAS 5/16