



Florida Department of Transportation

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GOVERNOR

605 Suwannee Street
Tallahassee, FL 32399-0450

JARED W. PERDUE, P.E.
SECRETARY

November 2, 2023

Khoa Nguyen
Director, Office of Technical Services
Federal Highway Administration
3500 Financial Plaza, Suite 400
Tallahassee, Florida 32312

Re: State Specifications Office
Section: 649
Proposed Specification: **6490700 Galvanized Steel Poles, Mast Arms, and Monotube Assemblies.**

Dear Mr. Nguyen:

We are submitting, for your approval, two copies of the above referenced Supplemental Specification.

The changes are proposed by Andre Pavlov to ensure the hardware is correctly installed during initial construction and will not become loose during the service life of the structure.

Please review and transmit your comments, if any, within two weeks (10 business days). Comments should be sent via email daniel.strickland@dot.state.fl.us.

If you have any questions relating to this specification change, please call me at (850) 414-4130.

Sincerely,

Signature on File

Daniel Strickland, P.E.
State Specifications Engineer

DS/dh

Attachment

cc: Florida Transportation Builders' Assoc.
State Construction Engineer

**GALVANIZED STEEL POLES, MAST ARMS, AND MONOTUBE ASSEMBLIES.
(REV 6-22-23)**

ARTICLE 649-7 is deleted and the following is substituted:

649-7 Installation.

Install foundations in accordance with Section 455. Do not install poles, mast arm poles, or monotubes until the foundation has achieved 70% of the specified 28-day concrete strength and verifying test results have been submitted to the Engineer. Determine concrete strength from tests on a minimum of two test cylinders prepared and tested in accordance with ASTM C31 and ASTM C39. Before erecting the pole, clean the top of the foundation of any laitance, oils, grease or any other deleterious materials. Erect strain poles in an orientation which considering the rake and the application, cable forces will produce a plumb pole. Erect monotubes plumb at the time of installation. Plumb the pole supporting mast arms after the mast arms, traffic signals or sign panels have been placed.

If the traffic signals and/or sign panels are not in place within two working days after the mast arm is erected, furnish and install a 3 foot x 2 foot blank sign panel on the bottom of each mast arm within 6 feet of the mast arm tip and plumb the pole. Re-plumb the pole supporting mast arms after installation of traffic signals and sign panels.

Install ASTM F3125, Grade A325 bolt, nut, and washer assemblies in accordance with the following. Use bolt, nut and washer assemblies that are free of rust and corrosion and are lubricated properly as demonstrated by being able to easily hand turn the nut on the bolt thread for its entire length. Tighten nuts to a snug-tight condition to bring the faying surfaces of the assembly into firm contact with plies solidly seated against each other, but not necessarily in continuous contact. Snug-tight is defined as the maximum nut rotation resulting from the full effort of a person using an ordinary spud wrench. Visually inspect the connection after snugging all bolts, ensuring firm contact has been achieved at a minimum between faying surfaces beneath bolts within one bolt diameter of bolt hole edges. Re-snug bolts in a connection where faying surfaces are not in firm contact. After bringing the faying surfaces to a snug-tight condition, tighten nuts in accordance with Table 460-7, Nut Rotation from the Snug-Tight Condition. Maintain as close to uniform contact pressure as possible on the faying surfaces during snugging and turn-of-nut process by utilizing suitable erection methods and a bolt tightening pattern that balances the clamping force of each bolt, as closely as possible, with the equal clamping force of a companion bolt.

For this Specification, the retainer nuts (half-height or full-height) are installed on top of the plate washers and below the anchor nuts (full-height). Base plate installation steps are as follows:

1. Clean and lubricate the exposed threads of all anchor bolts. Clean and lubricate the threads and bearing surfaces of all leveling nuts. Re-lubricate the exposed threads of the anchor bolts and the threads of the leveling nuts if more than 24 hours ~~has~~ have elapsed since earlier lubrication, or if the anchor bolts and leveling nuts have become wet since they were first lubricated.

2. Verify that the nuts can be turned onto the bolts past the elevation corresponding to the bottom of each in-place leveling nut and be backed off by the effort of a person using an ordinary spud wrench, without employing a pipe extension on the wrench handle.

3. Turn the leveling nuts onto the anchor bolts and align the nuts to the same elevation less than or equal to one bolt diameter from the top of the foundation.
4. Place structural plate washers on top of the leveling nuts; one washer corresponding to each anchor bolt.
5. Install the base plate onto the leveling nut washers, place structural plate washers on top of the base plate; one washer corresponding to each anchor bolt, and turn ~~full or half-size anchor~~retainer nuts onto the anchor bolts.
6. Tighten ~~anchor~~retainer nuts against the top of the base plate to a snug-tight condition in a star pattern. A star tightening pattern is one in which the nuts on opposite or near opposite sides of the bolt circle are successively tightened in a pattern resembling a star. For an 8 bolt circle with bolts sequentially numbered 1 to 8, tighten nuts in the following bolt order: (1, 5, 7, 3, 8, 4, 6, 2).
7. Tighten leveling nuts to a snug-tight condition in a star pattern. The distance from the bottom of the leveling nuts to the top of the concrete must not exceed one anchor bolt diameter after tightening.
8. ~~Turn anchor nuts onto the anchor bolts and~~ Tighten each ~~full-size retainer nut~~ until it is in firm contact with the top surface of the ~~anchor~~retainer nut; then while preventing the ~~anchor~~retainer nut from rotating, tighten the ~~retainer~~anchor nut until it is snug-tight using a star pattern. Before final tightening of the ~~retainer~~anchor nuts, mark the reference position of each snug-tight ~~retainer~~ nut on one flat with a corresponding reference mark on the anchor nut and base plate on each bolt. Assure the retainer nut stays in this final position. Then while preventing the ~~anchor~~retainer nut from rotating, incrementally turn the ~~retainer~~anchor nuts using a star pattern until achieving the required nut rotation specified in Table 649-1. Turn the ~~anchor~~ nuts at least two full tightening cycles (passes). After tightening, verify the ~~anchor~~ nut rotation with respect to the retainer nut and verify the retainer nut has not rotated from its snug-tight condition with respect to the plate washer and base plate. Do not exceed the Table 649-1 value by more than 20 degrees. The final condition is a retaining nut that is snug-tight with respect to the plate washer, and an anchor nut that is rotated with respect to the reference mark on the retaining nut, plate washer, and base plate in accordance with Table 649-1.
9. Install a screen over the gap between the base plate and foundation concrete in accordance with 649-8, or place a structural grout pad in accordance with 649-9.

Anchor Bolt Diameter (inches)	Nut Rotation from Snug-Tight Condition
≤ 1-1/2	1/3 turn
> 1-1/2	1/6 turn

649-7.1 Camera Lowering Device Installation: Meet the requirements of 641-4.4.

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2. Verify that the nuts can be turned onto the bolts past the elevation corresponding to the bottom of each in-place leveling nut and be backed off by the effort of a person using an ordinary spud wrench, without employing a pipe extension on the wrench handle.

3. Turn the leveling nuts onto the anchor bolts and align the nuts to the same elevation less than or equal to one bolt diameter from the top of the foundation.
4. Place structural plate washers on top of the leveling nuts; one washer corresponding to each anchor bolt.
5. Install the base plate onto the leveling nut washers, place structural plate washers on top of the base plate; one washer corresponding to each anchor bolt and turn retainer nuts onto the anchor bolts.
6. Tighten retainer nuts against the top of the base plate to a snug-tight condition in a star pattern. A star tightening pattern is one in which the nuts on opposite or near opposite sides of the bolt circle are successively tightened in a pattern resembling a star. For an 8 bolt circle with bolts sequentially numbered 1 to 8, tighten nuts in the following bolt order: (1, 5, 7, 3, 8, 4, 6, 2).
7. Tighten leveling nuts to a snug-tight condition in a star pattern. The distance from the bottom of the leveling nuts to the top of the concrete must not exceed one anchor bolt diameter after tightening.
8. Turn anchor nuts onto the anchor bolts and tighten each until it is in firm contact with the top surface of the retainer nut; then while preventing the retainer nut from rotating, tighten the anchor nut until it is snug-tight using a star pattern. Before final tightening of the anchor nuts, mark the reference position of each snug-tight retainer nut on one flat with a corresponding reference mark on the anchor nut and base plate on each bolt. Assure the retainer nut stays in this final position. Then while preventing the retainer nut from rotating, incrementally turn the anchor nuts using a star pattern until achieving the required nut rotation specified in Table 649-1. Turn the anchor nuts at least two full tightening cycles (passes). After tightening, verify the anchor nut rotation with respect to the retainer nut and verify the retainer nut has not rotated from its snug-tight condition with respect to the plate washer and base plate. Do not exceed the Table 649-1 value by more than 20 degrees. The final condition is a retaining nut that is snug-tight with respect to the plate washer, and an anchor nut that is rotated with respect to the reference mark on the retaining nut, plate washer, and base plate in accordance with Table 649-1.
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Table 649-1	
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