



Florida Department of Transportation

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SECRETARY

November 15, 2016

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: **6490401 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 Steve Duke of the State Materials Office to update an Industry reference. ASTM A325 and ASTM A490 have been withdrawn and consolidated into new ASTM F3125.

Please review and transmit your comments, if any, within two weeks. Comments should be sent via email to dan.hurtado@dot.state.fl.us.

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

Sincerely,

Signature on file

Dan Hurtado, P.E.
State Specifications Engineer

DH/dt

Attachment

cc: Florida Transportation Builders' Assoc.
State Construction Engineer

GALVANIZED STEEL POLES, MAST ARMS, AND MONOTUBE ASSEMBLIES.
(REV 9-20-16)

SUBARTICLE 649-4.1 is deleted and the following substituted:

649-4.1 Galvanizing: Galvanize all components in accordance with ASTM A123, except galvanize all fastener assemblies in accordance with [ASTM A153](#) [Section 962](#). Use galvanizing methods which provide surfaces suitable for painting.

ARTICLE 649-5 is deleted and the following substituted:

649-5 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 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 full contact which is referred to as snug-tight. Snug-tight is defined as the maximum nut rotation resulting from the full effort of one person using a 12 inch long wrench or equivalent. 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 uniform contact pressure on the faying surfaces during snugging and turn-of-nut process, by using 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.

Base plate installation steps are as follows:

1. 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 one person on a 12 inch long wrench, without employing a pipe extension on the wrench handle.
2. 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 elapsed since earlier lubrication, or if the anchor bolts and leveling nuts have become wet since they were first lubricated.

3. Turn the leveling nuts onto the anchor bolts and align the nuts to the same elevation.

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 the top nuts onto the anchor bolts.

6. Tighten top nuts 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.

8. Before final tightening of the top nuts, mark the reference position of each tip nut in a snug-tight condition with a suitable marking on one flat with a corresponding reference mark on the base plate at each bolt. Then incrementally turn the top nuts using a star pattern until achieving the required nut rotation specified in Table A. Turn the nuts at least 2 full tightening cycles (passes). After tightening, verify the nut rotation. Do not exceed the Table A value by more than 20 degrees.

9. Tighten each retainer or jam nut until it is in firm contact with the top surface of the anchor bolt nut; then while preventing the anchor bolt nut from rotating, tighten the jam nut until it is snug tight.

10. Install a screen over the gap between the base plate and foundation concrete in accordance with 649-6, or place a structural grout pad in accordance with 649-7.

Table A

Anchor Bolt Diameter (inches)	Nut Rotation from Snug-Tight Condition
$\leq 1\text{-}1/2$	1/3 turn
$> 1\text{-}1/2$	1/6 turn

649-5.1 Camera Lowering Device Installation: Meet the requirements of 641-4.4.

GALVANIZED STEEL POLES, MAST ARMS, AND MONOTUBE ASSEMBLIES.
(REV 9-20-16)

SUBARTICLE 649-4.1 is deleted and the following substituted:

649-4.1 Galvanizing: Galvanize all components in accordance with ASTM A123, except galvanize all fastener assemblies in accordance with Section 962. Use galvanizing methods which provide surfaces suitable for painting.

ARTICLE 649-5 is deleted and the following substituted:

649-5 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 full contact which is referred to as snug-tight. Snug-tight is defined as the maximum nut rotation resulting from the full effort of one person using a 12 inch long wrench or equivalent. 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 uniform contact pressure on the faying surfaces during snugging and turn-of-nut process, by using 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.

Base plate installation steps are as follows:

1. 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 one person on a 12 inch long wrench, without employing a pipe extension on the wrench handle.
2. 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 elapsed since earlier lubrication, or if the anchor bolts and leveling nuts have become wet since they were first lubricated.

Commented [FC1]: A325 structural bolts are now grades under the new F3125 specification; I believe the reference ASTM spec is needed.

3. Turn the leveling nuts onto the anchor bolts and align the nuts to the same elevation.

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 the top nuts onto the anchor bolts.

6. Tighten top nuts 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.

8. Before final tightening of the top nuts, mark the reference position of each tip nut in a snug-tight condition with a suitable marking on one flat with a corresponding reference mark on the base plate at each bolt. Then incrementally turn the top nuts using a star pattern until achieving the required nut rotation specified in Table A. Turn the nuts at least 2 full tightening cycles (passes). After tightening, verify the nut rotation. Do not exceed the Table A value by more than 20 degrees.

9. Tighten each retainer or jam nut until it is in firm contact with the top surface of the anchor bolt nut; then while preventing the anchor bolt nut from rotating, tighten the jam nut until it is snug tight.

10. Install a screen over the gap between the base plate and foundation concrete in accordance with 649-6, or place a structural grout pad in accordance with 649-7.

Table A

Anchor Bolt Diameter (inches)	Nut Rotation from Snug-Tight Condition
$\leq 1\text{-}1/2$	1/3 turn
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