GENERAL NOTES

DESIGN SPECIFICATION
For welding refer to the latest editions of the AWS Structural Welding Codes for Steel and Aluminum, the AASHTO Standard Specifications for Welding Structural Steel.

ALUMINUM MATERIALS
All aluminum materials shall meet the requirements of the Aluminum Association’s Alloy 6061-T6 and also the following ASTM specifications: Sheets and plates, B209 extruded tube, bars, rods & shapes, B221 and standard structural shapes, B318. Sheets are to be degreased, etched, neutralized and treated with Alodine 1200, Ti 6-2, Biondite TFG, or equivalent. No stenciling permitted on sheets. Aluminum welding rods shall meet the requirements of Aluminum Association Alloy No. 5356 filler wire.

STRUCTURAL STEEL
All structural steel shall meet the requirements of ASTM A36.

ALUMINUM BOLTS, NUTS, & WASHERS
Aluminum bolts shall meet the requirements of Aluminum Association Alloy 2024-T4 (ASTM F468). The bolts shall have an anodic coating at least 0.0002" thick and be Chromate sealed. Lock washers shall meet the requirements of Aluminum Association Alloy 7075-T6 (ASTM B221). Nuts shall meet the requirements of Aluminum Association Alloy 6061-T6 or 6262-T9 (ASTM F467).

STEEL BOLTS, NUTS, & WASHERS
All steel bolts, nuts and washers shall meet the requirements of ASTM A325.

ALTERNATE MATERIAL
Material meeting the requirements of ASTM R209 or Aluminum Association Alloys 5154-H356 or 5052-H356 may be used for sheet and plate. Material meeting the requirements of Aluminum Association Alloy 6351-T5 and ASTM B221 may be used for extruded bars, rods, shapes and tubes.

TOLERANCES
All above materials shall be in accordance with the governing ASTM specifications.

CALZANIZING
All steel shapes, angles, tees, plates, bolts, nuts and washers shall be galvanized in accordance with Standard Specifications 96Z7.

BASE CONNECTION
High strength bolts L4 in the base connection shall be tightened only to the torque shown in the table on sheets 3 of 3. Overtightened base connections will not be accepted.

FUSE PLATES
All holes in fuse plates shall be drilled. All plate cuts shall be preferably, be saw cuts however, flame cutting will be permitted provided all edges are ground. Metal projecting beyond the plane of the plate face will not be tolerated.

SIGN FACE
All sign face corners shall be rounded. See Sign Layout Sheet.

SHOP DRAWINGS
When ground sign supports are fabricated in accordance with these plans no shop drawings are required. Shop drawings will be required for approval when the column length exceeds the length shown in the plans by more than 2'-0". However, shop drawings for sign panels, messages, lettering and quantities shall be submitted to the Engineer of Record for approval.

FABRICATOR NOTE
All bolts shall be high strength bolts. All bolts, except 1/2" bolts and gus to post bolts, shall be tightened in the shop following a method approved by the engineer. Tightening shall be to such a degree as to attain in each bolt the residual tension specified in the tabulation on sheet 1 of 3.

FOUNDATION
Contractor may use precast foundations in pre-drilled holes a minimum of 12" larger than the foundation indicated on the plans in either wet or dry conditions. The holes shall be clean and without loose material. Temporary casing shall be required if the soil is unstable. The holes shall be filled with flowable fill after the precast foundation is in place. The cost of flowable fill, installing and removal of casing shall be included in the unit price of Sign Multi-Pole.

2008 FDOT Design Standards
MULTI-COLUMN GROUND SIGN
Sheet No. 1
1 of 3
1200