

APPENDIX E – ANCHOR ROD TIGHTENING REQUIREMENTS FOR METAL POLES

Anchor Rod Nut Tightening Requirements for Metal Poles

Prior to installation

Protect the anchor rod threads from damage during storage and installation of anchor rod assemblies.

Before placing anchor rods in foundations, turn nuts onto and off rods past leveling nut locations. Turn nuts with the effort of one workman using an ordinary wrench without a cheater bar. Report to the Engineer any thread damage that requires extra effort to turn nuts.

Arrange anchor rods symmetrically about center of base plate locations as shown in the plans. Set anchor rod elevations based on required projections above top of foundations. Securely brace and hold rods in the correct position, orientation, and alignment with a steel template. Do not weld to reinforcing steel, temporary casings or anchor rods.

During installation

Install top and leveling (bottom) nuts, washers, and the base plate for each anchor rod assembly in accordance with the following procedure:

1. Turn leveling nuts onto anchor rods to a distance of one nut thickness between the top of foundation and bottom of leveling nuts. Place washers over anchor rods on top of leveling nuts.
2. Determine if nuts are level using a flat rigid template on top of washers. If necessary, lower leveling nuts to level the template in all directions or if applicable, lower nuts to tilt the template so the metal pole or upright truss will lean as shown in the plans. If leveling nuts and washers are not in full contact with the template, replace washers with galvanized beveled washers.
3. Verify the distance between the foundation and leveling nuts is no more than one nut thickness.
4. Place base plate with metal pole or upright truss over anchor rods on top of washers. High mount luminaires may be attached before erecting metal poles but do not attach cables, mast arms or trusses to metal poles or upright trusses at this time.
5. Place washers over anchor rods on top of base plate. Lubricate top nut bearing surfaces and exposed anchor rod threads above washers with beeswax, paraffin, or other approved lubricant.
6. Turn top nuts onto anchor rods. If nuts are not in full contact with washers or washers are not in full contact with the base plate, replace washers with galvanized beveled washers.
7. Tighten top nuts to snug tight with the full effort of one workman using a 12” wrench. Do not tighten any nut all at once. Turn top nuts in increments following a star pattern cycling through each nut at least twice.
8. Repeat (7) for leveling nuts.
9. Replace washers above and below the base plate with galvanized beveled washers if the slope of any base plate face exceeds 1:20 (5%), any washer is not in firm contact with the base plate or any nut is not in firm contact with a washer. If any washers are replaced, repeat (7) and (8).
10. With top and leveling nuts snug-tight, mark each top nut on a corner at the intersection of 2 flats and a corresponding reference mark on the base plate. Mark top nuts and base plate with ink or paint that is not water-soluble. Use the turn-of-nut method for pretensioning. Do not pretension any nut all at once. Turn top nuts in increments for a total turn that meets the following nut rotation requirements:

NUT ROTATION REQUIREMENTS (Turn-of-Nut Pretensioning Method)	
Anchor Rod Diameter, inch	Requirement
$\leq 1 \frac{1}{2}$	1/3 turn (2 flats)
$> 1 \frac{1}{2}$	1/6 turn (1 flat)

Follow a star pattern cycling through each top nut at least twice.

11. Ensure nuts, washers, and base plate are in firm contact with each other for each anchor rod.
12. Between 4 and 14 days after pretensioning top nuts, use a torque wrench calibrated within the last 12 months to check nuts in the presence of the Engineer. Completely erect mast arm poles and cantilever signs and attach any hardware before checking top nuts for these structures. Check that top nuts meet the following torque requirements:

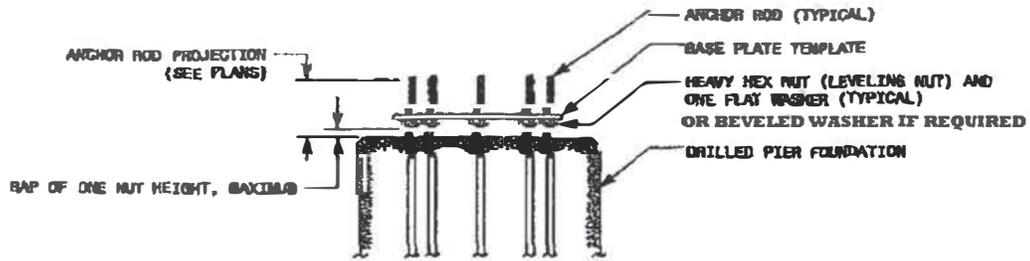
TORQUE REQUIREMENTS	
Anchor Rod Diameter, inch	Requirement, ft-lb
7/8	180
1	270
1 1/8	380
1 1/4	420
≥ 1 1/2	600

If necessary, retighten top nuts in the presence of the Engineer with a calibrated torque wrench to within ± 10 ft-lb of the required torque. Do not overtighten top nuts.

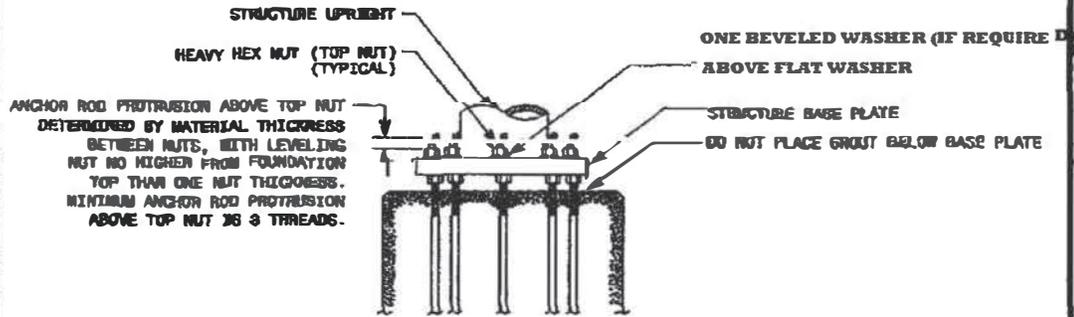
13. Do not grout under the base plate.

FOUNDATION BASE PLATE ANCHOR NUT AND HARDWARE INSTALLATION DETAILS

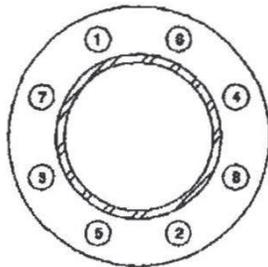
INSTALL LEVELING NUTS ON ANCHOR RODS



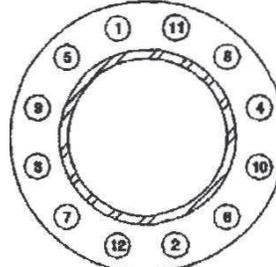
INSTALL STRUCTURE ON FOUNDATION



SEQUENCE OF TOP NUT SNUGGING, TOP NUT TIGHTENING, AND LEVELING AND TOP NUT TORQUE CHECKING



8 NUT PATTERN



12 NUT PATTERN