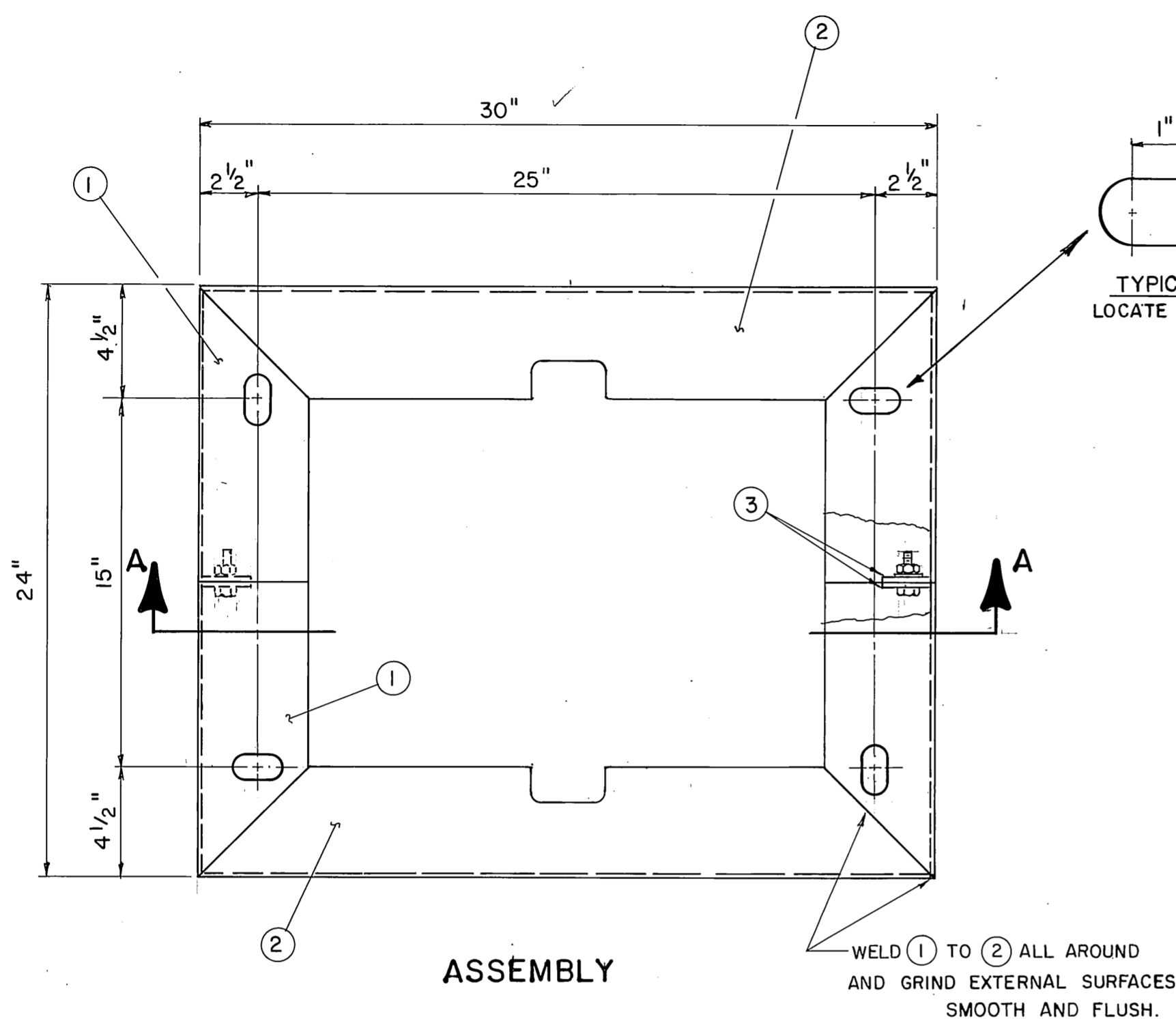


M-598 A

ALUMINUM

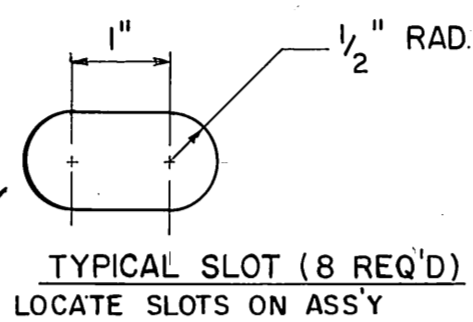
STEEL
OLD NO. 5-1158



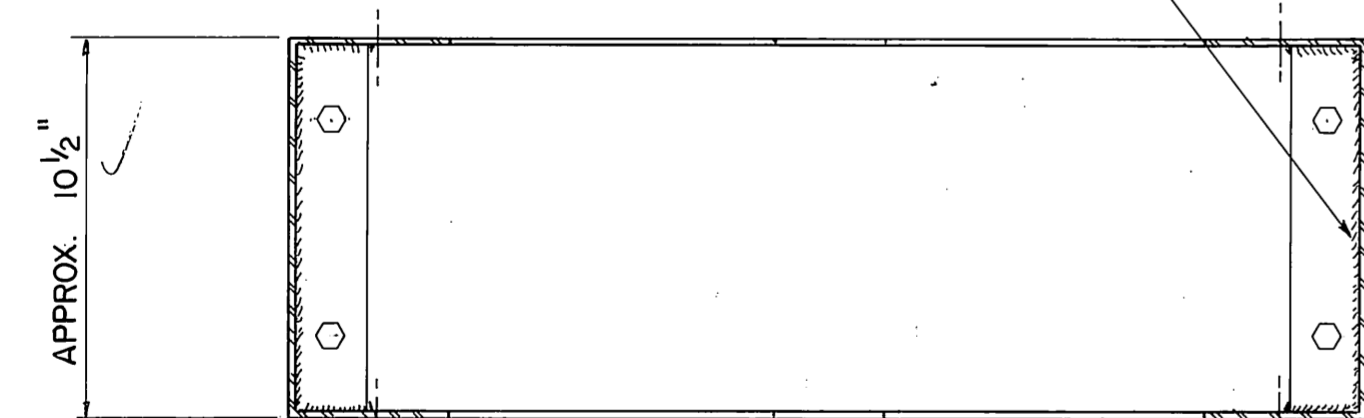
ASSEMBLY

WELD ① TO ② ALL AROUND AND GRIND EXTERNAL SURFACES SMOOTH AND FLUSH.

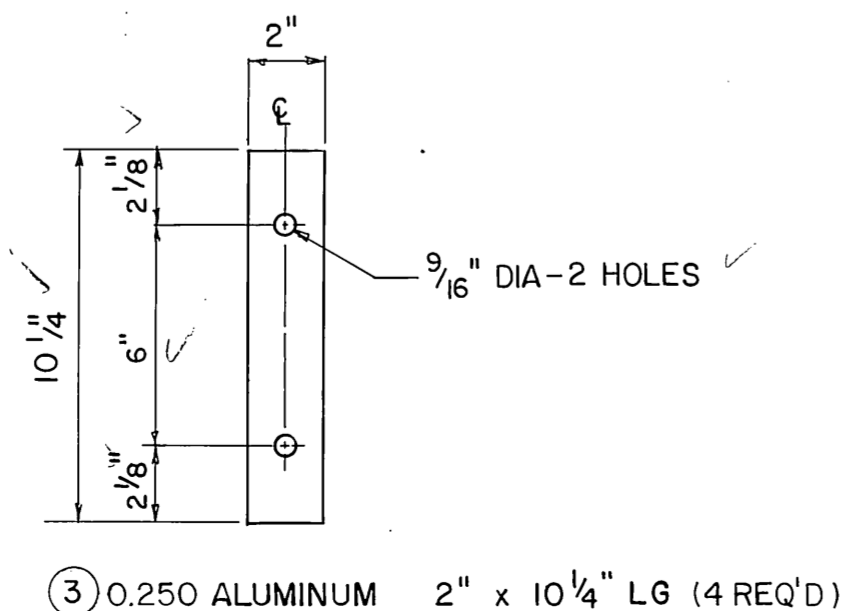
WELD ③ TO ① AS SHOWN



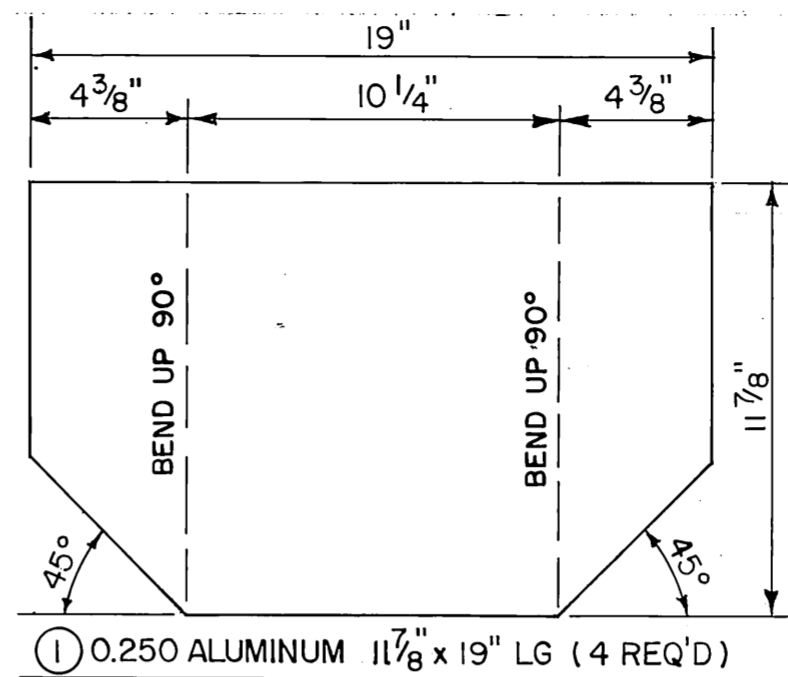
TYPICAL SLOT (8 REQ'D)
LOCATE SLOTS ON ASS'Y



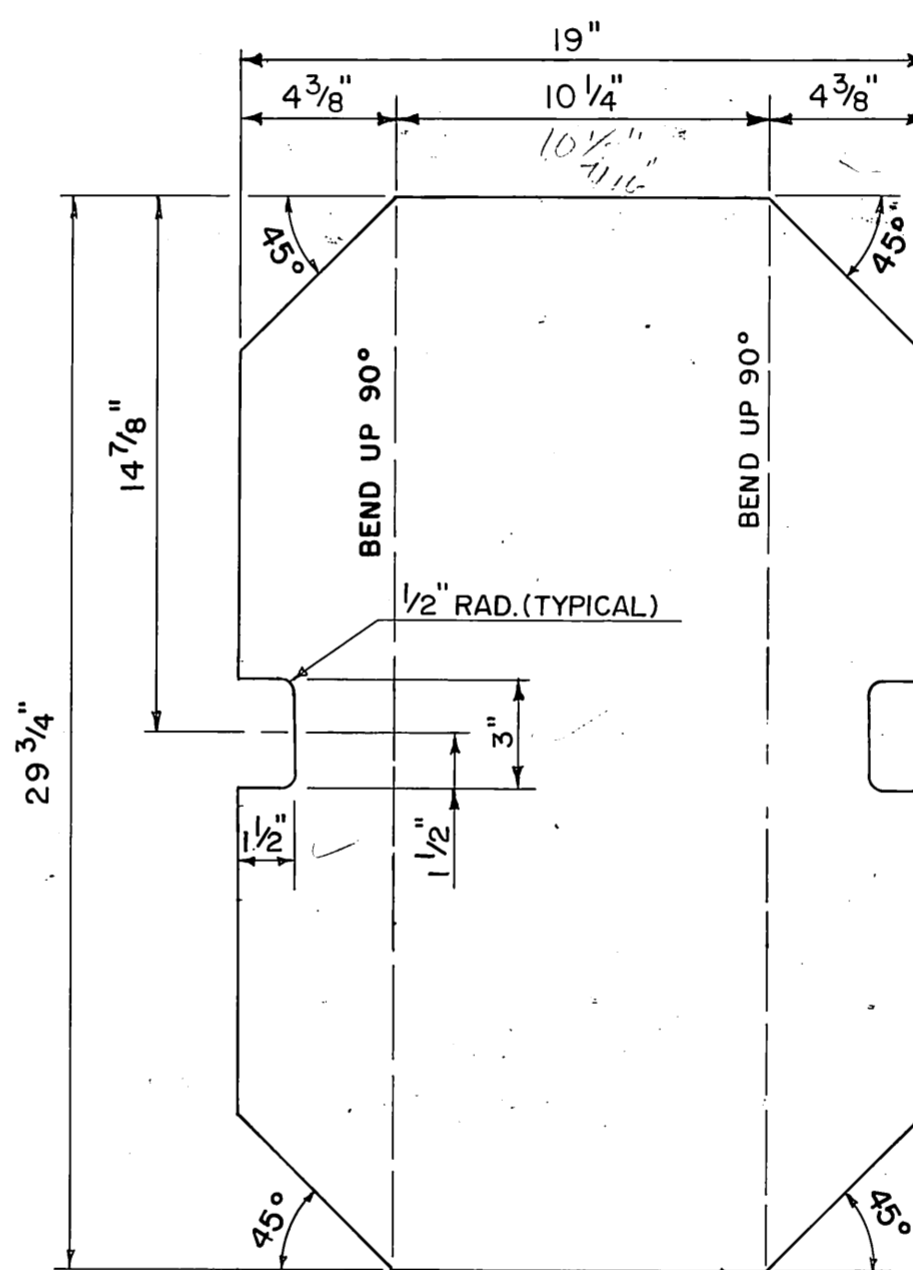
SECTION A-A



③ 0.250 ALUMINUM 2" x 10 1/4" LG (4 REQ'D)



① 0.250 ALUMINUM 11 7/8" x 19" LG (4 REQ'D)



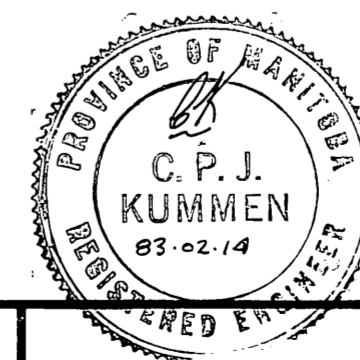
② 0.250 ALUMINUM 19" x 29 3/4" LG (2 REQ'D)

NOTES:

- ALUMINUM SHEET SHALL BE TYPE 5052-H32 ASTM B209-0.250 INCH THICK.
- ALL SEAMS SHALL BE CONTINUOUSLY WELDED. ALL EXTERIOR WELDS SHALL BE SMOOTH. ALL EDGES SHALL BE FILED TO A RADIUS OF 0.03125 INCH MINIMUM.
- WELDING SHALL BE DONE BY GAS TUNGSTON ARC (TIG) PROCESS. ER5356 ALUMINUM ALLOY BARE WELDING ELECTRODES CONFORMING TO AWS A5.10 REQUIREMENTS SHALL BE USED.
- APPLY AN ANODIC COATING TO ALL SURFACES AFTER CLEANING AND ETCHING. TO CLEAN AND ETCH THE SURFACES, IMMERSE IN INHIBITED ALKALINE CLEANER (OAKITE 61A, DIVERSEY 909 OR EQUAL IN MIX OF 6 TO 8 OUNCES PER GALLON OF DISTILLED WATER) AT 71°C FOR 5 MINUTES. RINSE IN COLD WATER. ETCH IN A SODIUM SOLUTION (0.5 OUNCE SODIUM FLUORIDE PLUS 5 OUNCES SODIUM HYDROXIDE MIX PER GALLON TO DISTILLED WATER) AT 66°C FOR 5 MINUTES. RINSE IN COLD WATER. DESMUT IN A 50% BY VOLUME NITRIC ACID SOLUTION AT 20°C FOR 2 MINUTES. RINSE IN COLD WATER.
- THE ANODIC COATING SHALL CONFORM TO MIL-A-8625C (ANODIC COATINGS FOR ALUMINUM AND ALUMINUM ALLOYS) FOR TYPE II, CLASS I COATING EXCEPT THE OUTER PEDESTAL SURFACE COATING SHALL HAVE A 0.0007 INCH MINIMUM THICKNESS AND A 27 MILLIGRAMS PER SQUARE INCH MINIMUM COATING WEIGHT. THE ANODIC COATING SHALL BE SEALED IN A 5% AQUEOUS SOLUTION OF NICKEL ACETATE (PH 5.0 TO 6.5) FOR 15 MINUTES AT 99°C.
- PEDESTAL HALVES SHALL BE JOINED WITH FOUR (4) 1/2 INCH DIAMETER BY 1/4 INCH LONG HEX HEAD BOLTS, LOCKWASHERS AND NUTS. ALL FASTENER HARDWARE SHALL BE STAINLESS STEEL. PEDESTALS SHALL BE FULLY ASSEMBLED WHEN DELIVERED.
- AT THE OPTION OF THE MANUFACTURER, THE PEDESTAL MAY BE CONSTRUCTED FROM TWO METAL SHEETS, EACH 19 INCHES WIDE BY 53 1/2 INCHES LONG.
- UNLESS OTHERWISE INDICATED, DIMENSION TOLERANCES SHALL BE ±0.0625 (±1/16) INCH. TOLERANCE OF HOLES SHALL BE -0.00 INCHES (+0.0625).

No	DATE	DESCRIPTION	CHKD
2.	91-07-24	MID. EDGE CUTOUT MADE RECTANGULAR	CK
1.	89-08-30	ALUMINUM CONSTRUCTION 1/2" MID-EDGE CUTOUT	C.K.

REVISIONS



THE CITY OF WINNIPEG
WORKS & OPERATIONS DIVISION
STREETS & TRANSPORTATION DEPARTMENT

DESIGNED BY: *W.E.*
CHECKED BY: *P.A.*
DATE: 83-02-10

APPROVED BY: *C. P. J. Kummen*
TRAFFIC SIGNALS ENGINEER
DATE: 83-02-14

10 INCH HIGH
ALUMINUM SUPPORT PEDESTAL
FOR MODEL 332 (TALL) CABINET

SCALE
3/16" = 1"

DRAWING No.
M-598 A