

**ELECTRICAL SPECIFICATION 1453
DIVISION OF ENGINEERING
DEPARTMENT OF TRANSPORTATION
CITY OF CHICAGO
REVISED MARCH 14, 2013**

MAST ARMS: ALUMINUM, TRUSS TYPE AND DAVIT TYPE

SUBJECT

1. This specification covers the requirements for aluminum mast arms for supporting street light luminaires. The aluminum arms will be supported by aluminum light poles.

GENERAL

2. (a) Specifications. The mast arms shall conform in detail to the requirements herein stated and to the requirements of the following organizations as cited herein:

Aluminum Association (AA)
American Association of State Transportation and Highway Officials (AASTHO)
American National Standards Institute (ANSI)
American Society for Testing and Materials (ASTM)
American Welding Society (AWS)
Society for Protective Coatings (SSPC)
- (b) Acceptance. Mast arms not conforming to this specification will not be accepted. The Commissioner will be the sole judge in determining if the arms meet this specification.
- (c) Bidders Drawings. Bidders must submit with their bids detailed scale drawings of the mast arm and bracket attachment proposed to be welded to the mast arm as the means for attaching these mast arms to poles. For davit arms, drawings must show how the davit is attached to the top of the light pole and is secured. The drawings must give every dimension necessary to show how the parts will fit each other and be properly held in assembly. These drawings must also be submitted in electronic format, in the latest version of either Microstation or Autcad, if so requested by the City.
- (d) Drawings. The drawings mentioned herein are drawings of the Department

of Transportation being an integral part of this specification cooperating to state the necessary requirements.

- (e) Sample. If requested by the Chief Procurement Officer, one complete mast arm of the manufacture intended to be furnished, must be submitted within fifteen (15) business days upon receipt of such request.
- (f) Warranty. The manufacturer shall warrant the performance and construction of the mast arms to meet the requirements of this specification and shall warrant all parts, components, and appurtenances against defects due to design, workmanship, or materials, developing within a period of five years after the mast arms have been delivered. This will be interpreted particularly to mean structural or mechanical failure of any element or weld, or any faults in the anodized surfaces. The warranty must be furnished in writing guaranteeing material replacement including shipment, free of charge to the City. The Commissioner will be the sole judge in determining which replacements are to be made. The Commissioner's decision will be final.
- (g) Structural Requirements. The arms shall be manufactured in accordance with AASTHO's 1994 version of the Standard Specifications for Structural Supports for Highway Signs, Luminaires and Traffic Signals. The arms must be designed to meet AASTHO's 1994 criteria for 80 MPH wind loading with a 30% gust factor. The arms shall be designed for Chicago street lighting applications. The arm manufacturer must provide structural calculations that verify that the arms are designed properly.

TRUSS ARM DESIGN

- 3. (a) Each mast arm must be a truss type fabricated of two (2) inch "standard" aluminum pipe or tube 6063-T4 alloy conforming to the requirements of ASTM B429, or ASTM B221, or other approved design. The arm must be heat treated to a T-6 temper after fabrication and welding.
- (b) Mast Arm Attachment. The mast must be attached to the pole by means of an extruded aluminum clamp with a bolting arrangement to hold the arm firmly in place. The extrusion must be aluminum alloy 6061-T6 conforming to the requirements of ASTM B221, B308, or an approved equal. The clamps shall be designed to securely fasten the mast arm to the pole so that the arm cannot be dislodged vertically or horizontally from its intended position on the pole by wind gusts, vibrations or other normally anticipated natural phenomena.
- (c) Dimensions. The truss type arm must have the dimensions indicated on Standard Drawing 943 or Standard Drawing 944 for the appropriate arm specified. Truss arms will be available in nominal horizontal lengths of 4 foot, 6 foot, 8 foot, 12 foot, and 15 foot, with either 4.5 inch or 6 inch

clamps. The distance between the lower and upper members, measured between the vertical centers of the upper and lower attachment plates, must be 1'-9". With the arm attached to the pole intended to be supplied, the vertical rise from the center of the top attachment plate to the horizontal centerline of the end of the arm must be no greater than 2'-8". The horizontal axis of the free end of the upper member, when attached to the pole, must not exceed 3° above the true horizontal without the luminaire weight, nor be less than 1/2° above the true horizontal with a 35 lb. weight supported at the free end of the arm.

- (d) Mating of Members. The upper and lower members shall be mated in such a manner as to assure that they will not separate due to vibration, weather conditions such as high wind gusts, icing, etc., or any other normally anticipated stress condition.
- (e) Interchangeability. Members of each truss arm size must be mutually interchangeable for assembly, so that no reworking will be required to make any member fit properly in the place of any other similar member of any other similar arm.

DAVIT ARM DESIGN

- 4. (a) Each arm must be fabricated from either 4.5 inch diameter or 6.0 inch diameter aluminum tubing of 6063-T4 alloy. After all fabrication and welding, the arm must be heat treated to a T6 temper.
- (b) The arm must be attached to the mast by slipping the bottom of the arm tube over the top of the mast. The arm must have four (4) holes pre-drilled at its base to accommodate two (2) through bolts set 90° apart, as shown on the Standard Drawings. The bottom bolt will be in direct line with the length of the arm. The holes must match the holes in the mast so that after assembly the arm and mast appear as a single continuous unit. When bolted to the pole, the arm must not shift or become dislodged by wind gusts, vibrations, or other phenomena.
- (c) The davit arm must be dimensioned as indicated on Standard Drawing 945, 946, 948, 949, or 950, for the appropriate arm specified. Davit arms must be available in nominal horizontal lengths of 8 foot and 12 foot for the 4.5 inch pole tops. Davit arms must be available in nominal lengths of 8 foot, 12 foot, and 15 foot for 6 inch pole tops. Davit arms will be single or twin as specified. A 2 3/8 inch diameter tenon will be attached to the end of each arm. The horizontal axis of the tenon, when the arm is attached to the pole, must not exceed 3° above the true horizontal without the luminaire weight, nor be less than 1/2° above the true horizontal with a 35 lb. weight supported by the tenon.

- (d) Interchangeability. All davit arms for a 4.5 inch pole top must be interchangeable with each other. The same is required of davit arms for a 6 inch pole top.

WELDING

- 5. (a) General. Every welded joint shall be made in conformity with the proper interpretation of the standard welding symbols of the American Welding Society as indicated on the drawings. Each bidder must submit with his proposal a drawing showing the sizes and types of welds, must state the type of electrode, and must describe the welding methods, he proposes to use in fabricating the arms.
- (b) Testing. All welds of five percent (5%) of the arms in every lot must be inspected for penetration and soundness of the welds by radiography or by penetrant inspection. Acceptance or rejection will be governed by the same conditions as in the TESTING Section.
- (c) Certifications. Welders must have proper certification for the welding operations required. Welding by non-certified personnel will not be allowed. Certifications must be made available upon request.

FINISH

- 6. (a) General. All completed arms shall have a brushed satin natural finish or an anodized finish, as required by the project or in the purchase order.
- (b) A satin aluminum finish requires that each arm be rotary sand finished. The satin finish shall be accomplished by using 40-50 grit belts to remove taper marks and scratches. A minimum of one pass with a 120 grit belt over the entire arm is required to provide a uniform appearance.
- (c) An anodized finish will be either matte black or semi-gloss black. A color sample must be submitted for approval before any factory production. The anodizing process must include cleaning, etching, anodizing, and sealing the aluminum arm. The etching process must meet the requirements of AA-C22. The anodizing process must meet the requirements of AA-A42. The contractor must submit his anodizing process for approval before any factory production.

HARDWARE

- 7. All hardware furnished for attachment of mast arm to pole must be series 300 stainless steel. All hardware necessary to complete the assembly of the arm to

the pole must be provided.

MAST ARM TESTS

8. (a) General. Five percent (5%) of the mast arms of each size in every order shall be tested for structural integrity.
- (b) Tests. The mast arms, when securely attached to a suitable and proper supporting structure, must withstand a horizontal (sideward) pulling force as indicated in Table A, and a vertical (downward) load as indicated in Table A. These loads may be applied independently. Each load must be applied at the end of the arm without any apparent permanent set, or damage to the welds joining the arm and mast arm attachment. The appropriate loading for each arm is indicated in Table A. On twin arms each arm extension must be tested.
- (c) Rejection. If the mast arms fail to meet the test, an additional three percent (3%) of the mast arms in the same lot must be tested. If any of these mast arms fail to meet the test requirements, the entire lot will be subject to rejection, except that the manufacturer may subject each mast arm in the lot to the test, and those which fulfill the requirements will be accepted.
- (d) All mast arms must meet the structural requirements of Section 2(g). All tests shall be certified by the manufacturer. Test results should be submitted to the Electrical Section of the Division of Engineering, upon request.

PACKAGING

9. (a) General. The mast arms must be shipped in bundles. Each arm or bundle shall be wrapped so that the arms can be handled and stored without damage to the surfaces.
- (b) Bundles. The bundles shall consist of fifty (50) to seventy five (75) arms laid to form an approximately rectangular bundle. Materials such as lumber (2"x4"), stainless steel banding, and other appropriate bundling materials must be used to make a rigid, long lasting, bundle capable of being handled, shipped and stored without shifting of contents or breaking, subject to approval. Any bundles, in which either the arms or packaging, is received broken, damaged, or with contents shifted, will not be accepted, and it will be the responsibility of the supplier to return the bundle to its original destination at no cost to the City of Chicago. The bundles should be capable of being stacked two (2) high without breaking, or shifting of the contents. Each bundle must be capable of being lifted by a fork lift truck or crane and the bundles must be shipped on a flat bed truck to facilitate unloading.
- (c) Hardware. The clamp backs and mounting hardware must be attached to the

clamp fronts on the end of the arm, and must be shipped with each mast arm bundle. Mounting hardware for the davit arms must be packed and shipped with each davit arm bundle. Payment will be withheld for any bundle delivered without the accompanying hardware. Cracked, broken or chipped parts will be considered as an incomplete delivery as regards payment.

TABLE A

ALUMINUM ARM	HORIZONTAL LOAD	VERTICAL LOAD	DRAWING #
Truss 4.5"x 4'	100#	250#	943
Truss 4.5"x 6'	100#	250#	943
Truss 4.5"x 8'	100#	250#	943
Truss 4.5"x 12'	100#	250#	943
Truss 4.5"x 15'	100#	250#	943
Davit 4.5"x 8'	100#	250#	945
Davit 4.5"x 12'	100#	200#	946
Davit 6.0"x 8'	100#	250#	948
Davit 6.0"x 12'	100#	250#	949
Davit 6.0"x 15'	100#	250#	950