

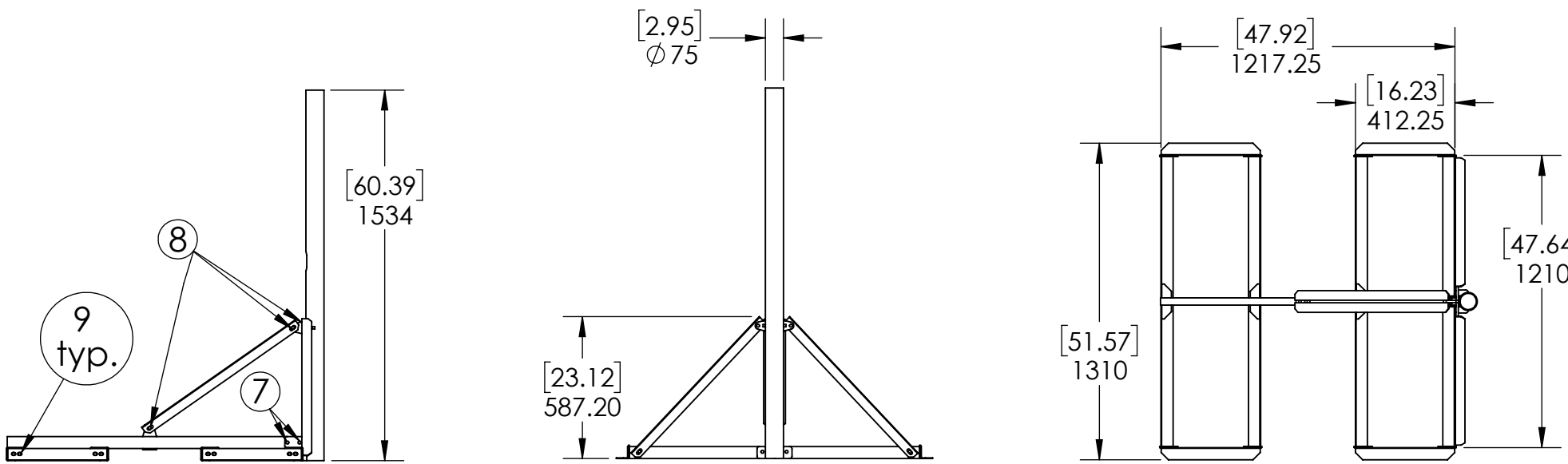
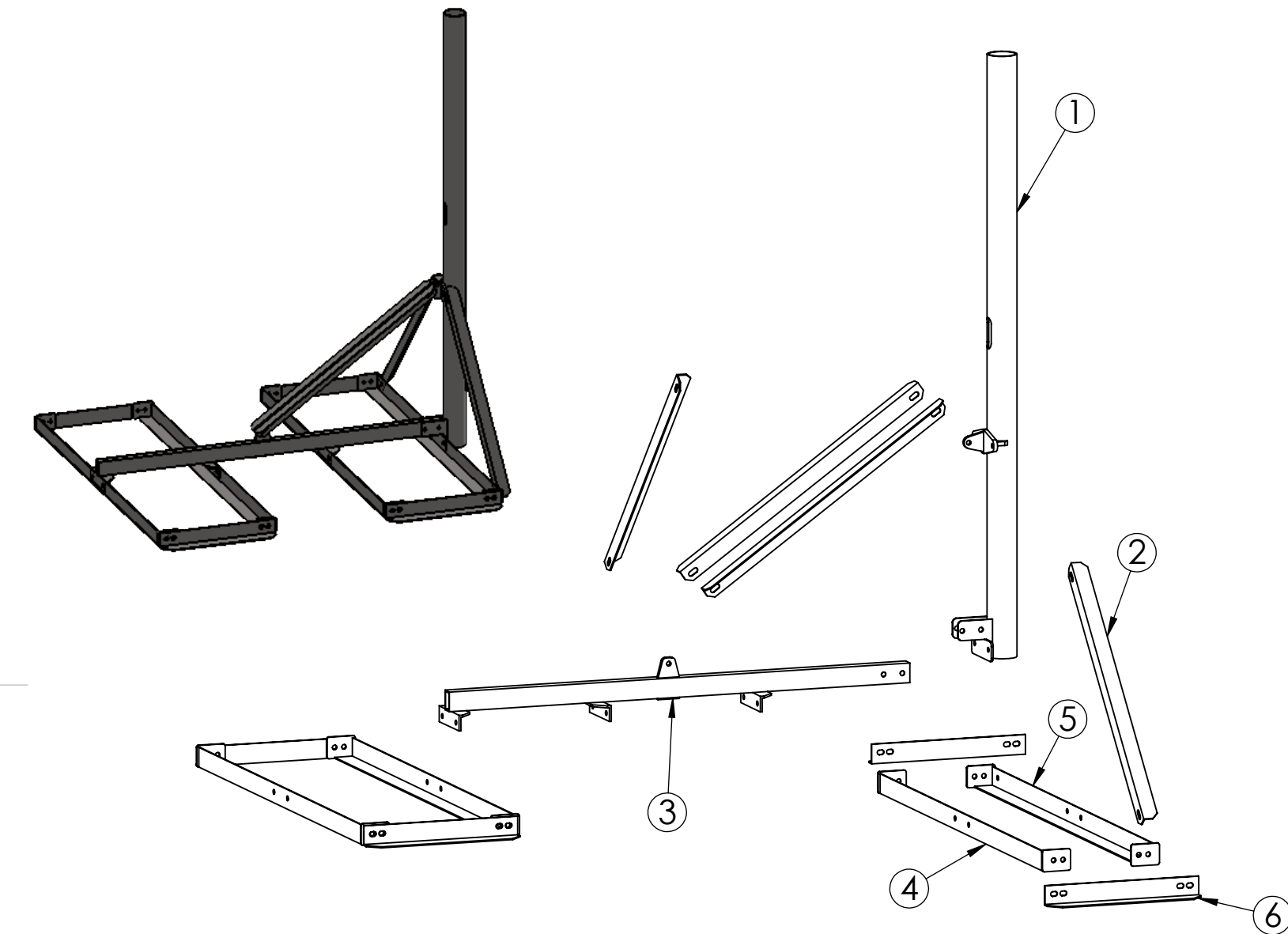
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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	initial release	2/24/18	MGC
B	Added assembly instructions	4/10/18	MGC

Bill of Materials		
NO.	DESCRIPTION	QTY.
1	Mast	1
2	Diagonal Chord	4
3	Horizontal Tray Chord	1
4	RA 1210mm	3
5	RA 1210mm w/ diagonal chord mounting holes	1
6	RA 410mm	4
7	M10x1.5 x 65mm (GR 8.8) or equivalent (HDG)	2
8	M10x1.5 x 35mm (GR 8.8) or equivalent (HDG)	4
9	M10x1.5 x 25mm (GR 8.8) or equivalent (HDG)	26
	M10 Washer	64
	M10 Nut	32

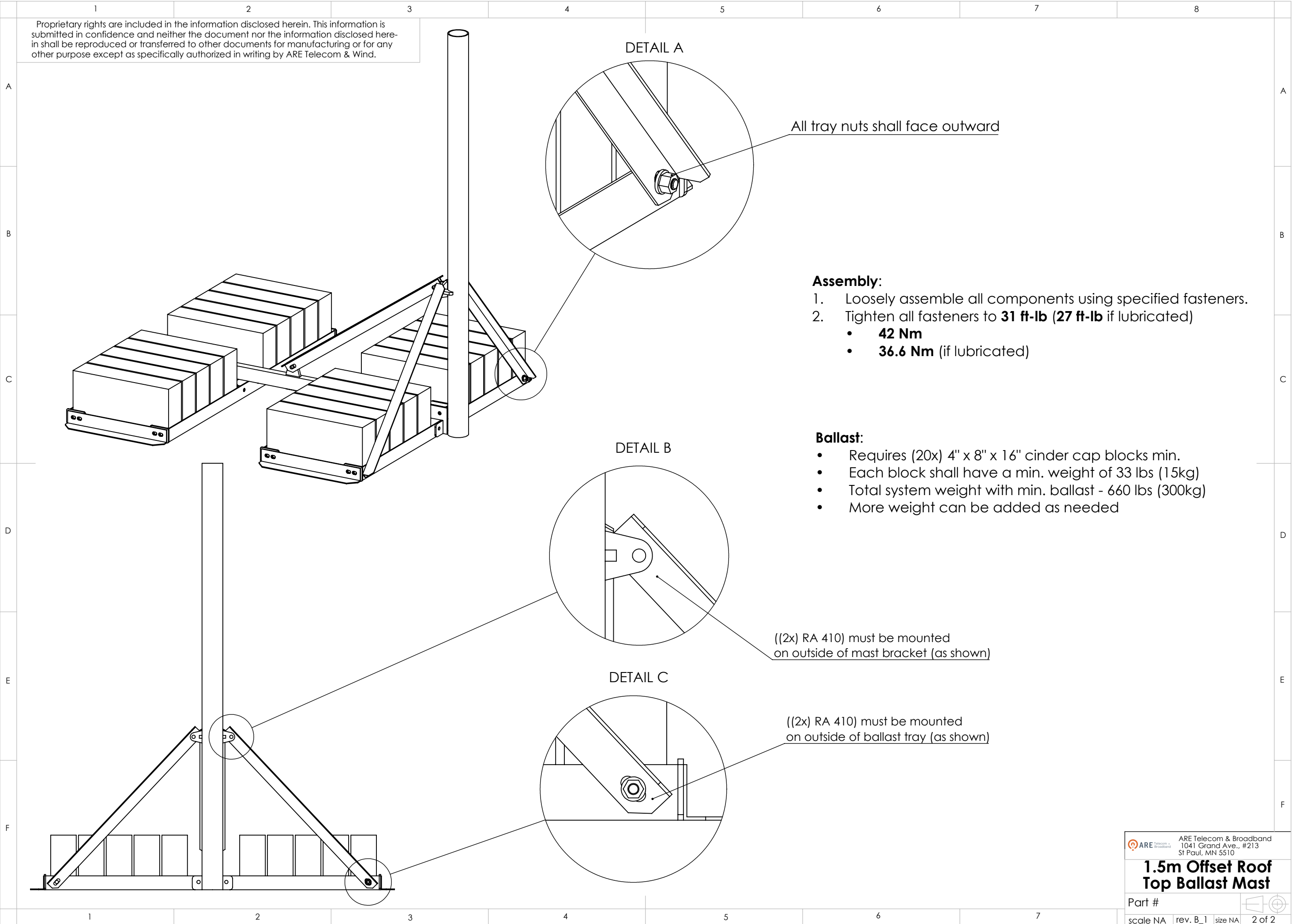
Notes:

- All plate material shall have a minimum yield strength of 345 MPa (50 ksi)
- Round Tube shall be 3" x .158" (75mm x 4mm) DOM 1026 or equivalent
- Rectangular tube shall be 1.25" x 2" x .158" (30mm x 50mm x 4mm) A513 - 1026 or equivalent
- All right angles shall be ASTM A36 or equivalent
- All welding shall conform to the minimum requirements of AWS D1.1
- All welding shall be done by welders qualified under AWS specifications, using E80XX, low hydrogen electrodes
- All components shall Hot Dip Galvanized in accordance with ASTM A123
- Debur all sharp edges



40.5 kg (89 lbs) Weight does not include fasteners	CAD-generated drawing do not manually update		ARE Telecom & Broadband 1041 Grand Ave., #213 St Paul, MN 55105
	APPROVALS	DATE	
MATERIAL See Notes	DRAWN MGC	2/24/18	1.5m Offset Roof Top Ballast Mast Details and dimensions not shown on this drawing can be found in CAD file
FINISH See Notes	CHECKED		
DO NOT SCALE DRAWING	RESP ENG		CAD file : scale NA rev. B_1 size NA 1 of 2
	MFG ENG		
	QUAL ENG		

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DETAIL A

All tray nuts shall face outward

Assembly:

1. Loosely assemble all components using specified fasteners.
2. Tighten all fasteners to **31 ft-lb (27 ft-lb if lubricated)**
 - **42 Nm**
 - **36.6 Nm (if lubricated)**

DETAIL B

((2x) RA 410) must be mounted on outside of mast bracket (as shown)

DETAIL C

((2x) RA 410) must be mounted on outside of ballast tray (as shown)

ARE Telecom & Broadband
1041 Grand Ave., #213
St Paul, MN 5510

1.5m Offset Roof Top Ballast Mast

Part # ☰

scale NA rev. B_1 size NA 2 of 2