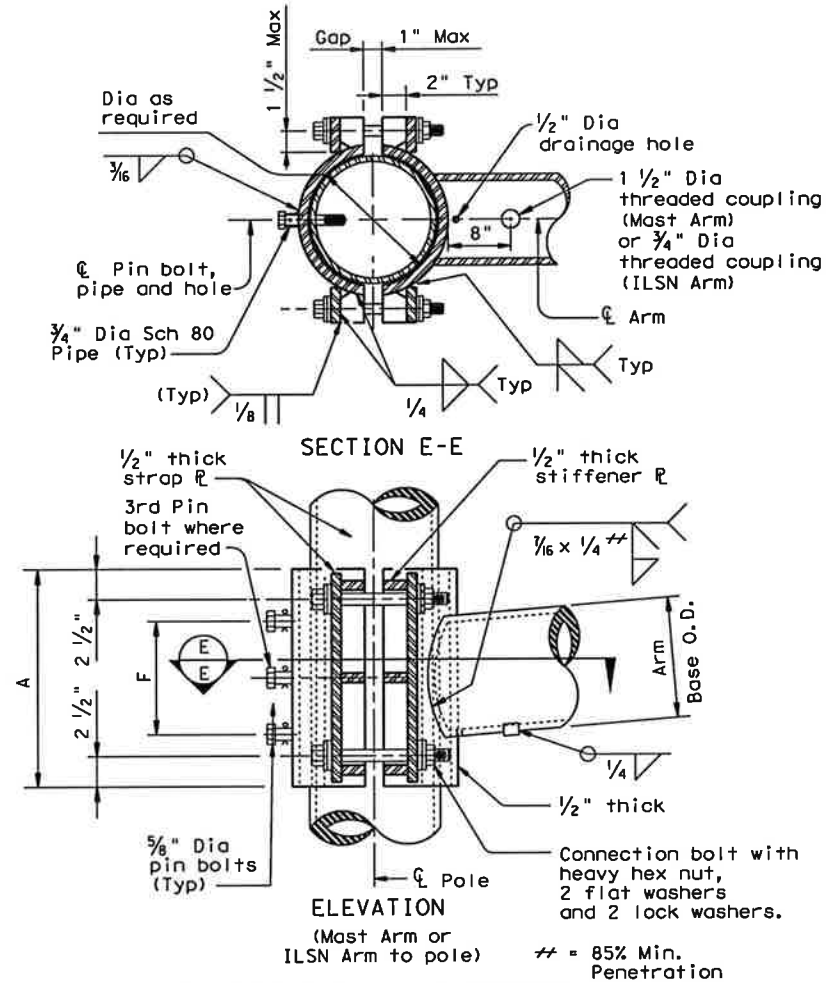


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**CLAMP-ON CONNECTION**

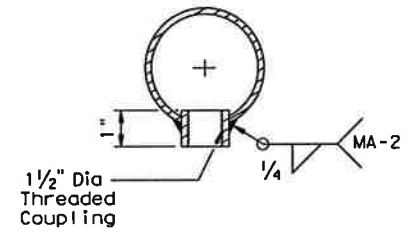
80 MPH WIND										
Clamp-on Arm Lc	ROUND ARMS					POLYGONAL ARMS				
	L <sub>1</sub>	D <sub>1</sub>	D <sub>2</sub>	thk (12)	Rise	L <sub>1</sub>	D <sub>1</sub>	D <sub>2</sub>	thk (12)	Rise
ft.	ft.	in.	in.	in.		ft.	in.	in.	in.	
20	19.1	6.5	3.8	.179	1'-9"	19.1	7.0	3.5	.179	1'-8"
24	23.1	7.5	4.3	.179	1'-10"	23.1	7.5	3.5	.179	1'-9"
28	27.1	8.0	4.2	.179	1'-11"	27.1	8.0	3.5	.179	1'-10"
32	31.0	9.0	4.7	.179	2'-1"	31.0	9.0	3.5	.179	2'-0"
36	35.0	9.5	4.6	.179	2'-4"	35.0	10.0	3.5	.179	2'-1"
40	39.0	9.5	4.1	.239	2'-8"	39.0	9.5	3.5	.239	2'-3"
44	43.0	10.0	4.1	.239	2'-11"	43.0	10.0	3.5	.239	2'-6"

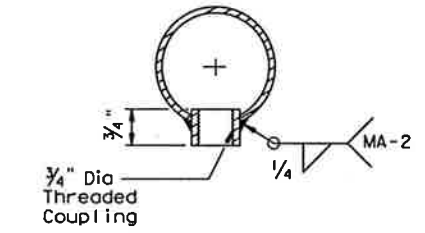
100 MPH WIND										
Clamp-on Arm Lc	ROUND ARMS					POLYGONAL ARMS				
	L <sub>1</sub>	D <sub>1</sub>	D <sub>2</sub>	thk (12)	Rise	L <sub>1</sub>	D <sub>1</sub>	D <sub>2</sub>	thk (12)	Rise
ft.	ft.	in.	in.	in.		ft.	in.	in.	in.	
20	19.1	8.0	5.3	.179	1'-8"	19.1	8.0	3.5	.179	1'-7"
24	23.1	9.0	5.8	.179	1'-9"	23.1	9.0	3.5	.179	1'-8"
28	27.1	9.5	5.7	.179	1'-10"	27.1	10.0	3.5	.179	1'-9"
32	31.0	9.5	5.2	.239	1'-11"	31.0	9.5	3.5	.239	1'-10"
36	35.0	10.0	5.1	.239	2'-0"	35.0	10.0	3.5	.239	1'-11"
40	39.0	10.5	5.1	.239	2'-3"	39.0	11.0	3.5	.239	2'-1"
44	43.0	11.0	5.1	.239	2'-8"	43.0	11.5	4.0	.239	2'-3"

D<sub>1</sub> = Arm Base O.D.  
D<sub>2</sub> = Arm End O.D.  
L<sub>1</sub> = Shaft Length  
Lc = Clamp-on Arm Length

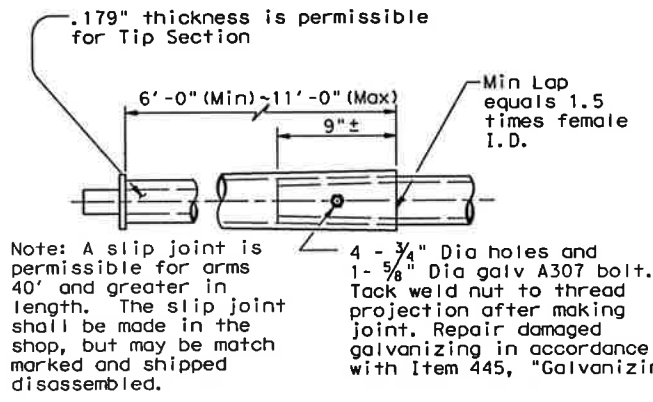
(12) Thickness shown is minimum, thicker materials may be used.



**ARM COUPLING DETAIL**



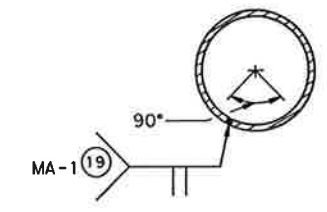
**ILSN ARM COUPLING DETAIL**



**SLIP JOINT DETAIL (CLAMP-ON ARM)**

Stainless steel bands (or Cables) and cast bracket as in "Astro-Brac", "Sky Bracket" or "Easy Bracket" with 1 1/2 inch Dia Threaded Coupling.

**BRACKET ASSEMBLY**



**ARM WELD DETAIL**

(19) Longitudinal Seam Weld must be oriented within the lower 90° of the signal arm. 60% Min penetration 100% penetration within 6" of circumferential base welds.

CLAMP-ON ARM CONNECTION					
ILSN Arm Size		A	F	4 Conn. Bolts	5/8" Dia. Pin Bolts
Sch 40 pipe Dia	Thick				
in.	in.	in.	in.	in.	ea
3	.216	10	4	3/4	2

Mast Arm Size		A	F	4 Conn. Bolts	5/8" Dia. Pin Bolts
Base Dia	Thick				
in.	in.	in.	in.	in.	ea
6.5	.179	12	6	1	2
7.5	.179	14	8	1	2
8.0	.179	14	8	1	2
9.0	.179	16	10	1	2
9.5	.179	18	12	1 1/4	3
9.5	.239	18	12	1 1/4	3
10.0	.239	18	12	1 1/4	3
10.5	.239	18	12	1 1/4	3
11.0	.239	18	12	1 1/4	3
11.5	.239	18	12	1 1/4	3

**GENERAL NOTES:**

Clamp-on details are used for the second arm on dual mast arm assemblies or ILSN arm support. For a clamp-on mast arm, a maximum 1 1/2 inch wide vertical slotted hole may be cut in the front clamp plate to facilitate drainage during galvanizing. The slot shall be centered behind the arm and shall be no longer than the arm diameter minus 1". For an ILSN arm, a 1 1/2 inch diameter hole shall be cut in the front clamp plate for wire access. A matched hole shall be field drilled through the pole to provide wire access after arm is oriented. Deburr both holes.

Where duplicate parts occur on a detail, welds shown for part shall apply to all similar parts on the detail.

Pin bolts are required to prevent rotation of clamp-on arms under design wind forces. Pin bolts shall be ASTM A325 with threads excluded from the shear plane. Pin bolt and 3/4 inch diameter pipe shall have 3/16 inch diameter holes for a 1/8 inch diameter galvanized cotter pin. Back clamp plate shall be furnished with a 3/4 inch diameter hole for each pin bolt. An 1/16 inch diameter hole for each pin bolt shall be field drilled through the pole after arm orientations have been approved by the Engineer.

Texas Department of Transportation  
Traffic Operations Division

**TRAFFIC SIGNAL SUPPORT STRUCTURES  
LONG MAST ARM ASSEMBLY  
(50 TO 65 FT)  
(80 AND 100 MPH WIND ZONE)**

Sheet 4 of 5 LMA(4)-12

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4-20-01 1-12	CONT	SECT	JOB	HIGHWAY
	DIST	COUNTY		SHEET NO.