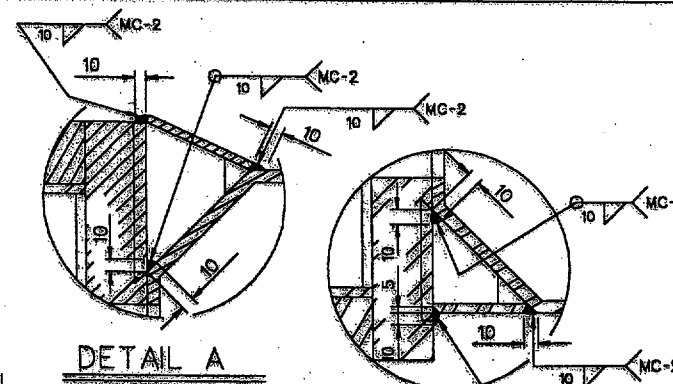


ARM SIZE		A	B	C	D	E	CONN. BOLT DIA
D ₁	#	mm	mm	mm	mm	mm	in.
165	4.55	305	229	229	152	25	1
180	4.55	330	229	254	152	25	1
205	4.55	356	254	279	178	32	1 1/4
230	4.55	406	279	330	203	32	1 1/4
240	4.55	432	305	356	229	32	1 1/4
240	6.07	457	305	381	229	32	1 1/4
255	6.07	457	305	381	229	32	1 1/4
265	6.07	457	330	381	254	38	1 1/2
280	6.07	457	330	381	254	38	1 1/2

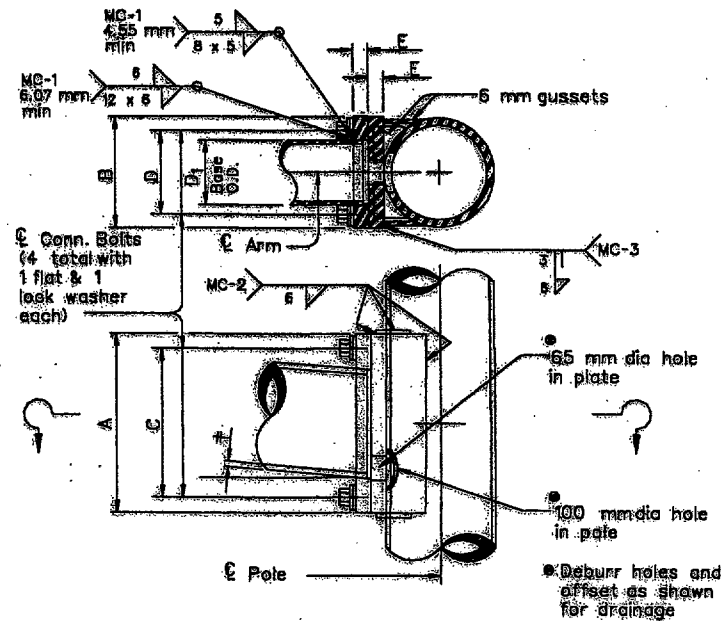
ARM SIZE		A	B	C	D	E	CONN. BOLT DIA
D ₁	#	mm	mm	mm	mm	mm	in.
180	4.55	279	279	203	203	32	1 1/4
190	4.55	279	279	203	203	32	1 1/4
205	4.55	279	279	203	203	32	1 1/4
230	4.55	330	330	254	254	32	1 1/4
255	4.55	330	330	254	254	32	1 1/4
240	6.07	330	330	254	254	32	1 1/4
255	6.07	356	356	279	279	38	1 1/2
260	6.07	356	356	279	279	38	1 1/2
280	6.07	356	356	279	279	38	1 1/2



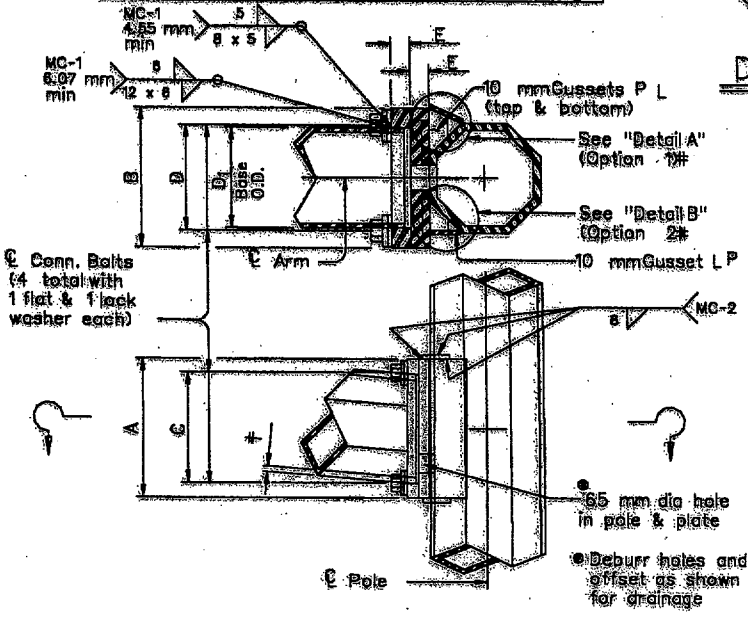
MATERIALS	
Round Shafts or Polygonal Shafts	ASTM A595 GR A, ASTM A570M GR 345, ASTM A607 GR 50, ASTM A572M GR 345 or A36M MOD345
Plates (1)	ASTM A36M OR A572M GR345 OR A595(2) OR A36M MOD345
Connection Bolts	ASTM A325M except where noted
Pin Bolts	ASTM A325M
Pipe	ASTM A53 GR A or B, OR A501
Misc. Hardware	Galvanized steel or stainless steel or as noted

(1) Any of the materials listed for plates may be used where the drawings do not specify a particular Grade designation.

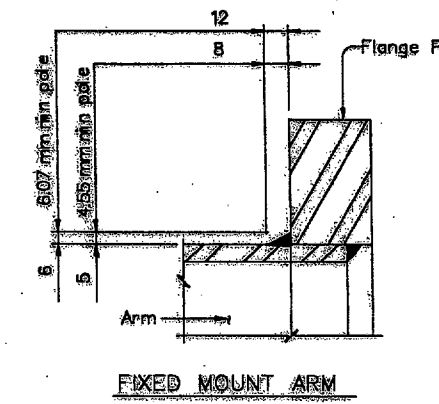
(2) If A 595 materials used, it need not be cold worked to A 595 requirements, but material must have 276 MPa minimum yield prior to fabrication.



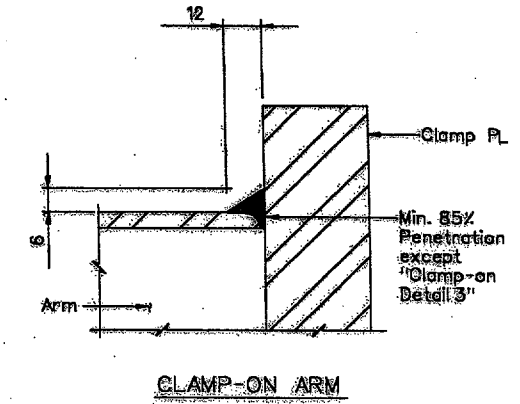
FIXED MOUNT DETAIL 1



FIXED MOUNT DETAIL 2



FIXED MOUNT ARM



CLAMP-ON ARM

ARM BASE WELD DETAILS

ARM SIZE		A	F	CONN. BOLTS		PIN BOLTS	
D ₁	#	mm	mm	No.	Dia.	No.	Dia.
165	4.55	305	203	4	1/4	2	3/8
180	4.55	356	203	4	1/4	2	3/8
205	4.55	356	203	4	1/4	2	3/8
230	4.55	406	254	4	1/4	2	3/8
240	4.55	457	305	4	1/4	3	3/8
240	6.07	457	305	4	1/4	3	3/8
255	6.07	457	305	4	1/4	3	3/8

*1" Dia connection bolts are permissible

ARM SIZE		A	F	T	CONN. BOLTS		PIN BOLTS	
D ₁	#	mm	mm	mm	No.	Dia.	No.	Dia.
180	4.55	305	203	19	4	3/4	2	3/8
190	4.55	356	203	19	4	3/4	2	3/8
205	4.55	356	203	19	4	3/4	2	3/8
230	4.55	406	254	22	4	1	2	3/8
235	4.55	457	254	22	4	1	2	3/8
240	6.07	457	254	25	6	1	3	3/8
255	6.07	457	254	25	6	1	3	3/8

ARM SIZE		A	F	CONN. BOLTS		PIN BOLTS	
D ₁	#	mm	mm	No.	Dia.	No.	Dia.
165	4.55	305	203	4	1/4	2	3/8
180	4.55	356	203	4	1/4	2	3/8
205	4.55	356	203	4	1/4	2	3/8
230	4.55	406	254	4	1/4	2	3/8
240	4.55	457	305	4	1/4	3	3/8
240	6.07	457	305	4	1/4	3	3/8
255	6.07	457	305	4	1/4	3	3/8

GENERAL NOTES:

Clamp-on details are used for the second arm on dual arm assemblies. A Maximum 38 mm 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 25 mm.

Fixed mount details are used for single mast arm assemblies and for the first arm on dual arm assemblies.

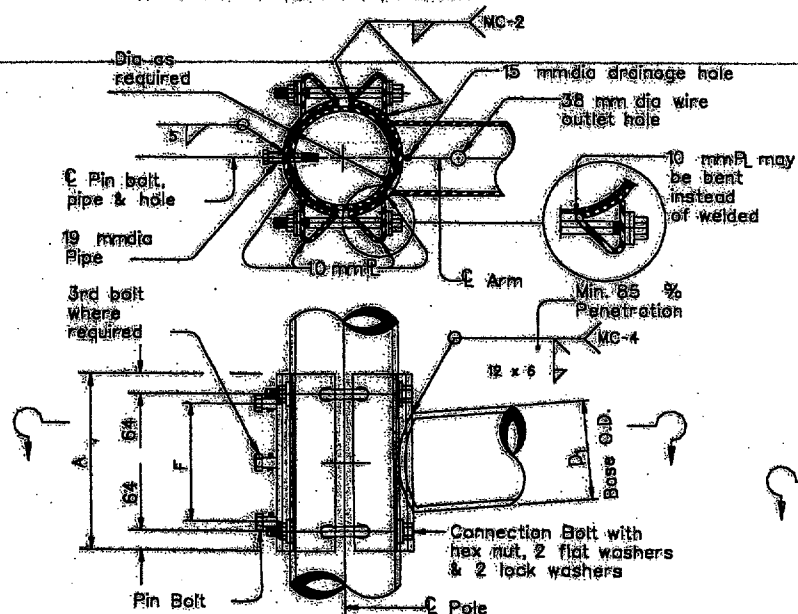
Where duplicate parts occur on a detail, welds shown for one part shall apply to all similar parts on the detail.

Pin bolts are required to prevent rotation of clamp-on arms under design wind forces.

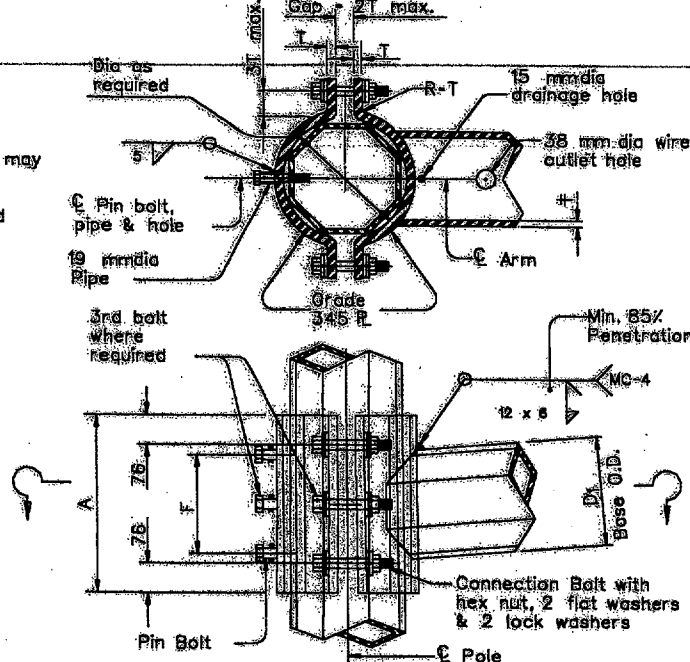
NOTE:

Pin bolts shall be A325M with threads excluded from the shear plane. Pin bolt and 19 mm dia pipe shall have 5 mm holes for a 3 mm dia galvanized cotter pin. Back clamp plate shall be furnished with a 7/8" dia hole for each pin bolt. An 7/8" dia hole for each pin bolt shall be field drilled through the pole after arm orientations have been approved by the Engineer.

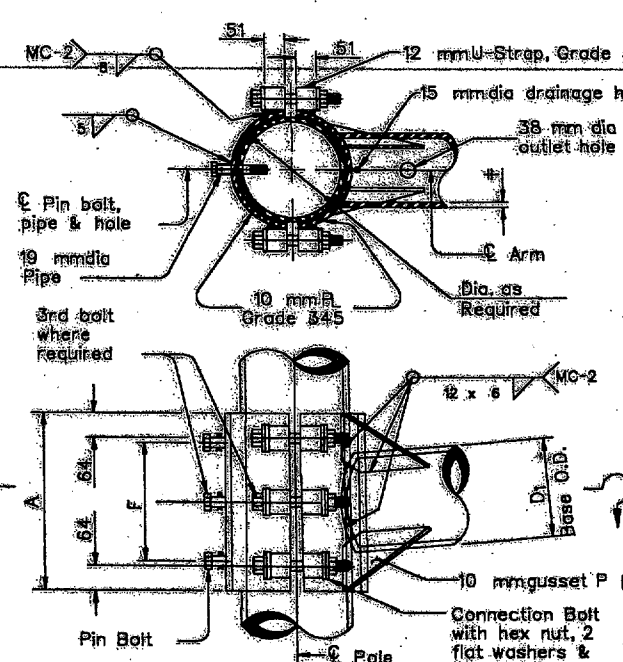
NOTE: All dimensions are in millimeters () mm except as noted.



CLAMP-ON DETAIL 1



CLAMP-ON DETAIL 2



CLAMP-ON DETAIL 3

Texas Department of Transportation
Traffic Operations Division

STANDARD ASSEMBLY
FOR TRAFFIC SIGNAL
SUPPORT STRUCTURES
MAST ARM CONNECTIONS
MA-C-96(M)

REV	DATE	BY	CHK	APP	DESCRIPTION
01	AUGUST, 1995	DAZ	CM	97	(87) 151

Design of this assembly is the responsibility of the Texas Department of Transportation. The user of this assembly shall be responsible for its proper use. The user shall be responsible for any damage or injury resulting from its use.