

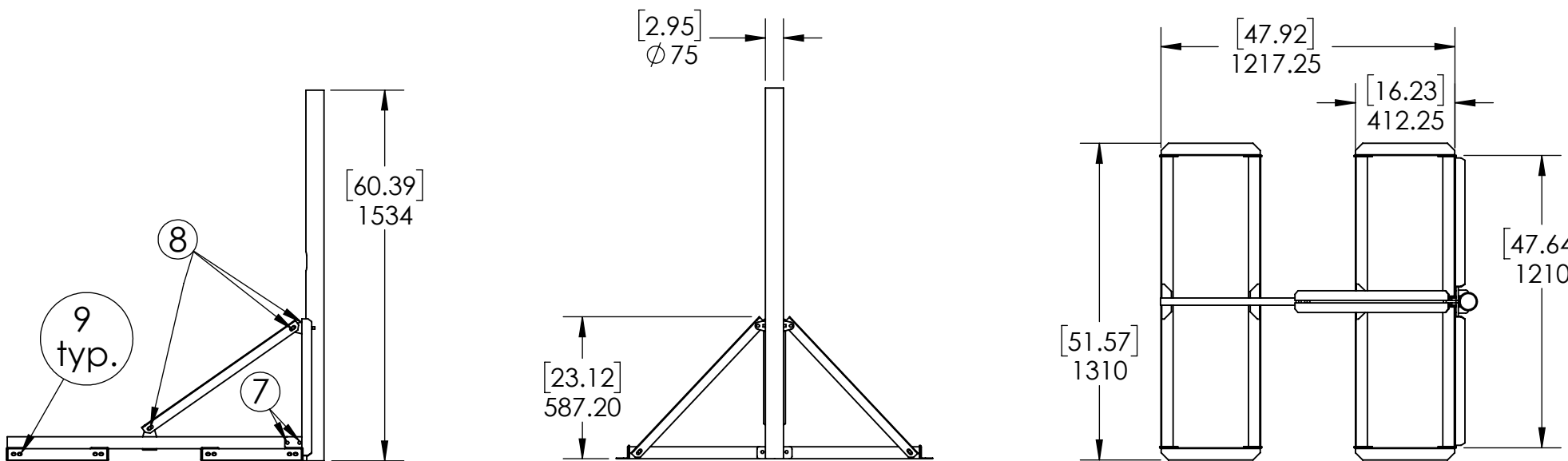
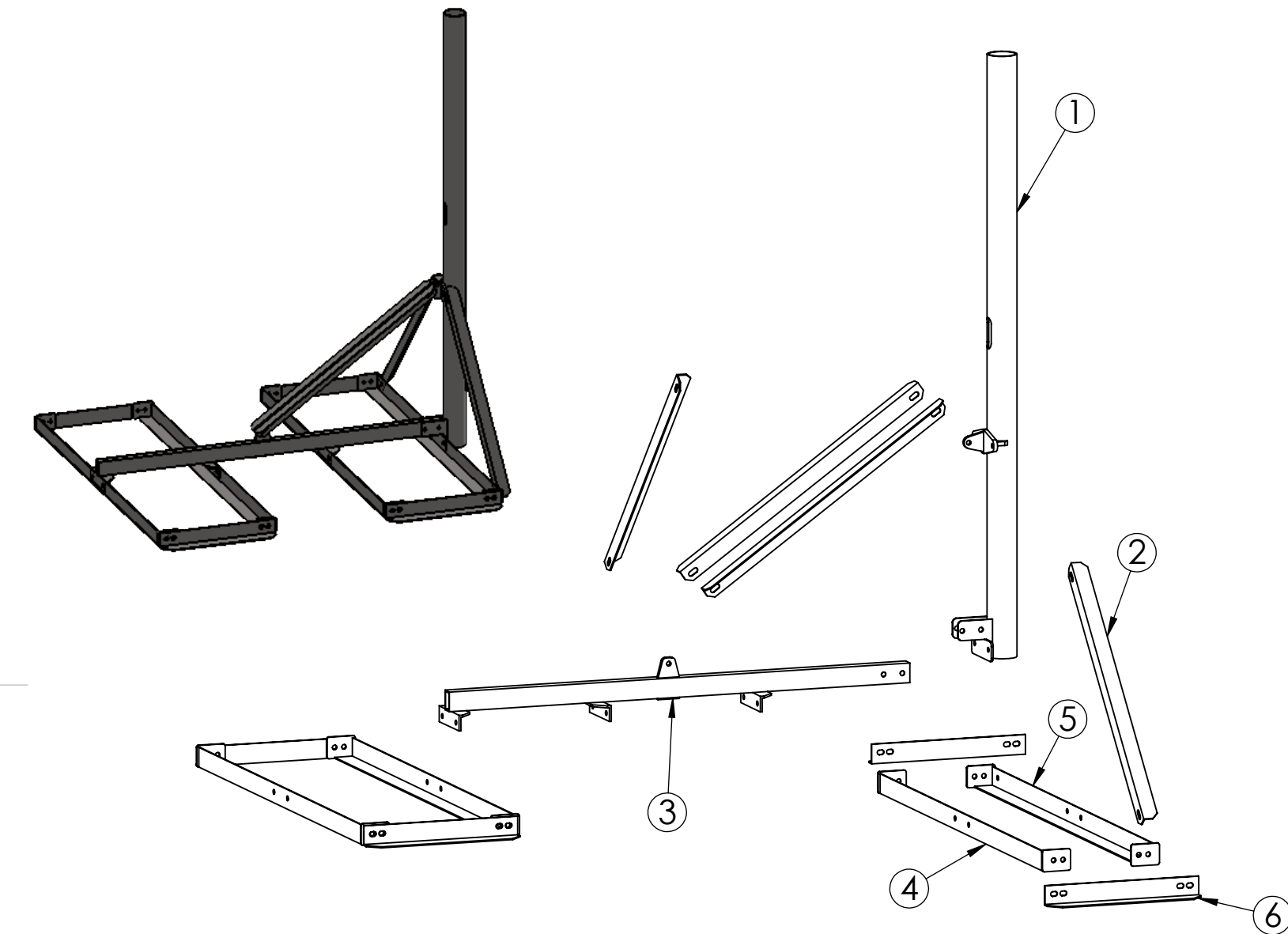
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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	initial release	2/24/18	MGC
B	Added assembly instructions	4/10/18	MGC

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

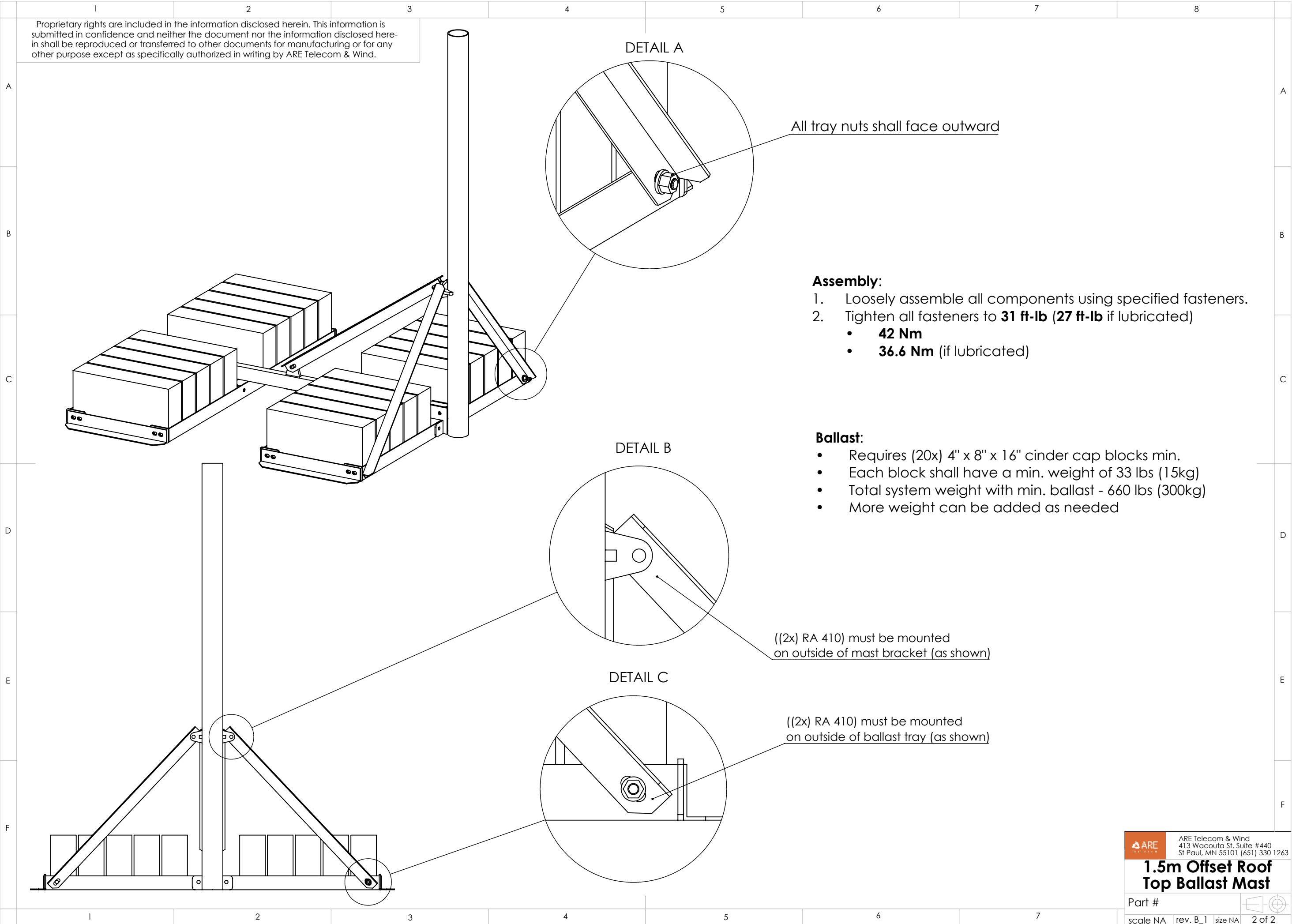
Notes:

- 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	APPROVALS	DATE	ARE Telecom & Wind 1043 Grand Ave., #213 St Paul, MN 55105 (651) 330 1263
	DRAWN MGC	2/24/18	
MATERIAL See Notes	CHECKED		1.5m Offset Roof Top Ballast Mast Details and dimensions not shown on this drawing can be found in CAD file
FINISH See Notes	RESP ENG		
DO NOT SCALE DRAWING	MFG ENG		CAD file : scale NA rev. B.1 size NA 1 of 2
	QUAL ENG		

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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)**

Ballast:

- Requires (20x) 4" x 8" x 16" cinder cap blocks min.
- Each block shall have a min. weight of 33 lbs (15kg)
- Total system weight with min. ballast - 660 lbs (300kg)
- More weight can be added as needed

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

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

ARE Telecom & Wind 413 Wacouta St. Suite #440 St Paul, MN 55101 (651) 330 1263	
<h3>1.5m Offset Roof Top Ballast Mast</h3>	
Part #	
scale NA	rev. B_1 size NA 2 of 2