Spec Notes & Best Practices

March 2016

00930 & 00962
Direct Tension Indicator and Turn-of-Nut Tightening for Luminaires and Traffic Signal Supports

8 Bolt Mast Arm Connections

- **TM 650** – References Mast Arms and Luminaire Arms
- **TM 652** – 8 Bolt Arm Connection Details and Arm Connection Notes: See General Notes on TM651
- **TM 651** – Note 22: Tighten 8 Bolt Arm Connection bolts in accordance with 930.40(d)

*930.40(d)(2)(a) Direct Tension Indicator (DTI) Tightening*

After attaining a snug-tight condition, tighten all fasteners in the connection by progressing systematically from the most rigid part of the connection to the free edges until all of the spaces between the direct tension indicator protrusions refuse entry to a 0.005-inch feeler.

*00930.49(e-2) – Bolt Inspection*

Upon completion of bolted joint, inspect a minimum of 10 percent but not less than 2 bolts in each joint. (Check gaps with .005" feeler gauge.)

**General**

Direct Tension Indicator (DTI) Washers have protrusions that, when compressed, indicate adequate tensioning.

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**Bolt Tightening with Cheater Bar**

(May be difficult to achieve proper tensioning)

**Bolt Tightening with Multiplier**

(Best practice for achieving proper tensioning)

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**DTI – Key Inspection Points**

- Ensure washer orientation is correct (protrusions facing hardened washer)
- Insert feeler gauge in each space between protrusions
- Insert the feeler gauge pointed towards the center of the bolt
- Inspect from the bucket truck (fall protection required)

**Click here to see it on YouTube!**

*updated for projects bid on/after 12/1/2016*
4 Bolt Luminaire Arm Connections & Anchor Rods (Turn-of-Nut)

**TM 652** – 4 Bolt Arm Connection Details and Arm Connection Notes: See General notes on TM 651

**TM 650** – See details on TM 629

**TM 629** – Tighten Anchor Bolts and Arm Connection bolts in accordance with 962.46(j)(2)

**TM 651** – Note 21: Tighten 4 Bolt Arm Connection bolts and anchor rods in accordance with 962.46(j)(2)

**962.46(j)(2)(a) Anchor Rods for Signal Supports**
Rotate each top nut past snug as shown in (d).

**962.46(j)(2)(c) High-Strength Bolts in Luminaire Arm-to-Pole**
Install high-strength 4-bolt connections....Rotate each top nut past snug tight as indicated in (d).

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**962.46(j)(2)(d) – Final Tightening**

<table>
<thead>
<tr>
<th>Connection Type</th>
<th>Rotation Past Snug Tight</th>
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</thead>
<tbody>
<tr>
<td>ASTM A307 Anchor Rods</td>
<td>30° (1/12 turn)</td>
</tr>
<tr>
<td>ASTM A449 Anchor Rods</td>
<td>60° (1/6 turn)</td>
</tr>
<tr>
<td>ASTM F1554 GR. 55 Anchor Rods</td>
<td>60° (1/6 turn)</td>
</tr>
<tr>
<td>ASTM A325 4 Bolt Connection</td>
<td>60° (1/6 turn)</td>
</tr>
</tbody>
</table>

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00962.46(j)(2) – “Snug Tight” is the tightness that exists when all plies of the joint are in firm contact, and can be obtained by the full effort of a worker on the end of a 12-inch long wrench.

**Turn-of-Nut Key Inspection Points**

- Luminaire connections must be observed/inspected at ground level, prior to erecting pole
- Inspect leveling nuts and washers to ensure full contact with base plate prior to installation of top nut
- Be on-site for inspection

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**Sampling of High Strength Bolts, Nuts, and Washers (NTMAG Section 00930 & 00962.10)**
Check to see if ODOT Materials Lab (971-673-7002) has sampled and tested the bolts, nuts, and washers to be used. If not previously tested, sample in the field for each lot to be used on the Project. Submit samples to the ODOT materials laboratory for testing. Do not use high strength bolts, nuts, and washers without passing laboratory report and proper quality documents.

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