

**sheet metal roll flattening and cutting** . The sheet metal roll is flattened by means of a combined “straightening-flattening” system with edge trimming to reach the due dimensional tolerances. The metal sheet is then cut with a longitudinal shear to obtain two equal trapezoids.

**truncated cone forming** . The trapezoid goes through truncated cone forming using folding presses equipped with automatic numerical control manipulators.

**welding** . The flaps of the truncated cone are joined longitudinally through automatic and manual welding processes. Welding is carried out in compliance with specific working practices (WPS) compliant with UNI EN ISO 15609-2 standards and by adopting certified procedures (WPAR) compliant with UNI EN ISO16614-15614-1 standards. All welding personnel is certified with a license, in accordance with standards UNI EN 1418 and 287-1 and are supported and controlled by supervision with international qualifications (International Welding Engineer). To this regard, welding is subject to visual testing (VT) conducted by qualified personnel in fulfillment of UNI EN 473.

**finish** . When the welding stage is completed, the pole goes through specific processing on the base (for ex. drilling) and on the end (for ex. calibration).

**testing** . Every stage of processing is constantly controlled by personnel working under the supervision of the Quality Control Department Manager.

Processing tolerances comply with standard UNI EN 40-2.

10 mm/m taper, tapers of 12 - 14 - 17 mm/m are possible on request.

The poles are manufactured with steel sheet S235JR (FE360B) with mechanical specifications according to standard UNI EN10025.

They can be manufactured with steel sheet S325JR (FE510B) on request.

The internal and external surface protection is achieved through a hot galvanising process, by dipping in molten zinc, and previous pickling to eliminate all debris and impurity.

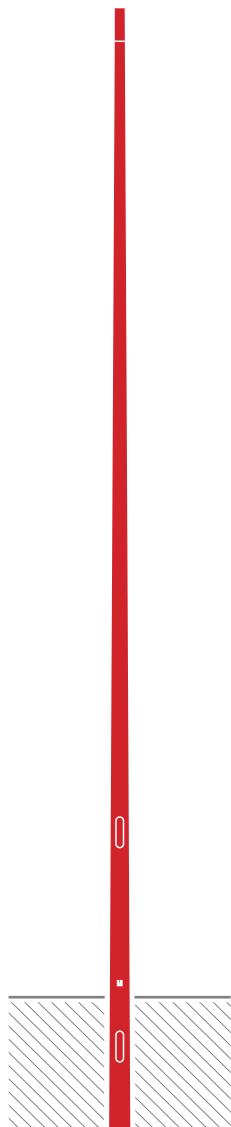
The galvanising process is conducted in compliance with standard UNI EN ISO 1461 or, on request, standard CEI 7-6 file no. 239.

For insertion in the urban field of application or when it is necessary to reinforce protection against the effects of the elements, the pole may go through a painting cycle.

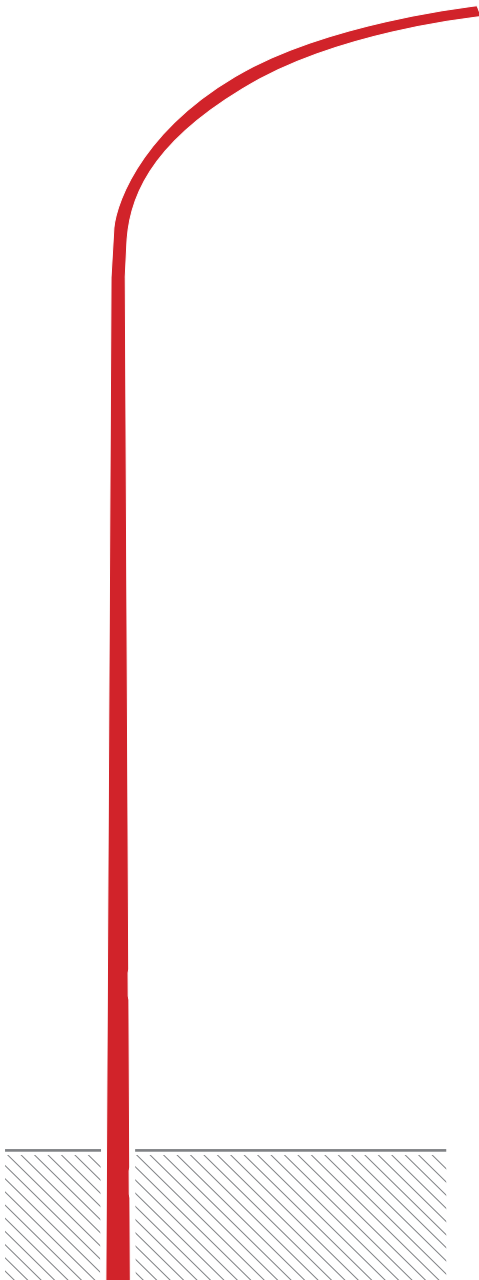
*The poles are designed for end-pole configuration.*

*For diversified illuminating engineering needs, they may be equipped with outreaches or crossbeams.*

*To check the adequacy of the poles, in compliance with standard UNI EN 40/5, in the various configurations refer to "Capacity Tables" in our general online catalogue [www.tecnopali.it](http://www.tecnopali.it) or contact the nearest agency.*



		↑	↓	⊙	△	□	□	□	□	□	□	□	○
CDI 3500/3	3.000	500	3	60x95	21	0,85	38x132	1500	350	750x700	200x500		
CDI 4000/3	3.500	500	3	60x100	25	1,00	38x132	1500	350	800x700	200x500		
CDI 4500/3	4.000	500	3	60x105	28	1,17	38x132	1500	350	800x700	250x500		
CDI 5000/3	4.500	500	3	60x110	32	1,33	38x132	1500	350	850x700	250x500		
CDI 5500/3	5.000	500	3	60x115	37	1,51	38x132	1500	350	850x700	250x500		
CDI 6800/3	6.000	800	3	60x128	48	2,01	46x186	1800	600	850x1000	300x800		
CDI 6800/4	6.000	800	4	60x128	63	2,01	46x186	1800	600	950x1000	300x800		
CDI 7800/3	7.000	800	3	60x138	58	2,42	46x186	1800	600	900x1000	300x800		
CDI 7800/4	7.000	800	4	60x138	77	2,42	46x186	1800	600	1000x1000	300x800		
CDI 8800/3	8.000	800	3	60x148	69	2,87	46x186	1800	600	950x1000	300x800		
CDI 8800/4	8.000	800	4	60x148	91	2,87	46x186	1800	600	1050x1000	300x800		
CDI 9300/3	8.500	800	3	60x153	75	3,11	46x186	1800	600	950x1000	300x800		
CDI 9300/4	8.500	800	4	60x153	99	3,11	46x186	1800	600	1050x1000	300x800		
CDI 9800/3	9.000	800	3	60x158	81	3,35	46x186	1800	600	1000x1000	300x800		
CDI 9800/4	9.000	800	4	60x158	107	3,35	46x186	1800	600	1100x1000	300x800		
CDI 10300/3	9.500	800	3	60x163	87	3,61	46x186	1800	600	1000x1000	300x800		
CDI 10300/4	9.500	800	4	60x163	114	3,61	46x186	1800	600	1100x1000	300x800		
CDI 10800/3	10.000	800	3	60x168	93	3,87	46x186	1800	600	1050x1000	350x800		
CDI 10800/4	10.000	800	4	60x168	123	3,87	46x186	1800	600	1100x1000	350x800		
CDI 11300/3	10.500	800	3	60x173	100	4,13	46x186	1800	600	1050x1000	350x800		
CDI 11300/4	10.500	800	4	60x173	132	4,13	46x186	1800	600	1150x1000	350x800		
CDI 11800/3	11.000	800	3	60x178	106	4,41	46x186	1800	600	1050x1000	350x800		
CDI 11800/4	11.000	800	4	60x178	141	4,41	46x186	1800	600	1150x1000	350x800		
CDI 12300/3	11.500	800	3	60x183	113	4,69	46x186	1800	600	1100x1000	350x800		
CDI 12300/4	11.500	800	4	60x183	150	4,69	46x186	1800	600	1200x1000	350x800		
CDI 12800/4	12.000	800	4	60x188	160	4,98	46x186	1800	600	1200x1000	350x800		



Processing tolerances comply with standard UNI EN 40-2.

10 mm/m taper, tapers of 12 - 14 - 17 mm/m are possible on request.

The poles are manufactured with steel sheet S235JR (FE360B) with mechanical specifications according to standard UNI EN10025.

They can be manufactured with steel sheet S325JR (FE510B) on request.

The internal and external surface protection is achieved through a hot galvanising process, by dipping in molten zinc, and previous pickling to eliminate all debris and impurity.

The galvanising process is conducted in compliance with standard UNI EN ISO 1461 or, on request, standard CEI 7-6 file no. 239.

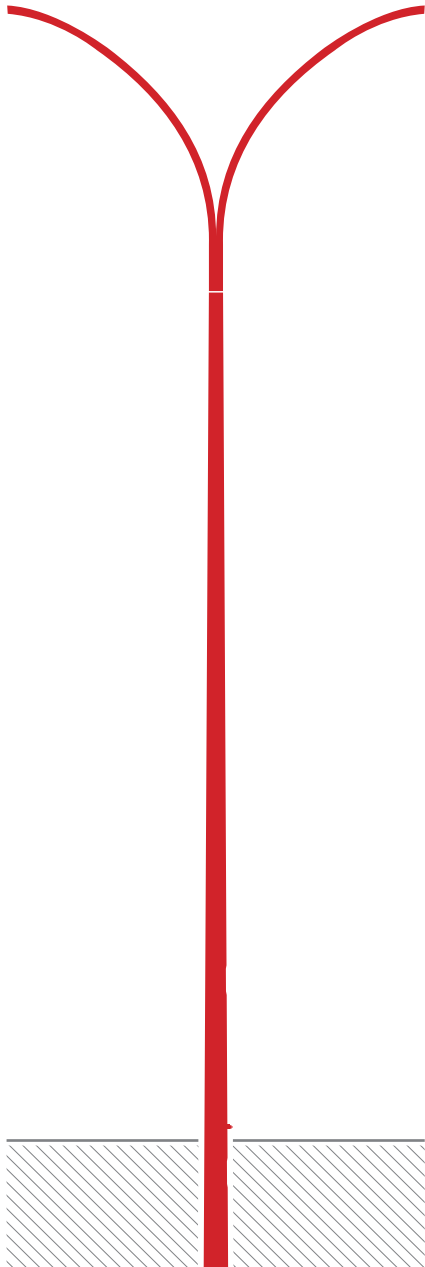
For insertion in the urban field of application or when it is necessary to reinforce protection against the effects of the elements, the pole may go through a painting cycle.

*The poles are designed for end-pole configuration.*

*For diversified illuminating engineering needs, they may be equipped with outreaches or crossbeams.*

*To check the adequacy of the poles, in compliance with standard UNI EN 40/5, in the various configurations refer to "Capacity Tables" in our general online catalogue [www.tecnopali.it](http://www.tecnopali.it) or contact the nearest agency.*

casilina	7000	1750	800	3	60x148	69	2,8	46x186	1800	600	950x1000	300x800
flaminia	7200	2250	800	3	60x153	75	3,1	46x186	1800	600	950x1000	300x800
abruzzo	7800	1200	800	3	60x153	75	3,1	46x186	1800	600	950x1000	300x800
umbria	8000	1200	800	3	60x163	87	3,6	46x186	1800	600	1000x1000	300x800
marche	9600	1500	800	3	60x173	100	4,1	46x186	1800	600	1050x1000	350x800
calabria	8000	2500	800	3	60x163	87	3,6	46x186	1800	600	1000x1000	300x800
basilicata	8000	2500	800	4	60x163	114	3,6	46x186	1800	600	1100x1000	300x800
domiziana	9000	2500	800	3	60x173	100	4,1	46x186	1800	600	1050x1000	350x800
ostienze	9000	2500	800	4	60x173	132	4,1	46x186	1800	600	1150x1000	350x800
prenestina	10000	2500	800	4	60x183	150	4,6	46x186	1800	600	1200x1000	350x800



Processing tolerances comply with standard UNI EN 40-2.

10 mm/m taper, tapers of 12 - 14 - 17 mm/m are possible on request

The poles are manufactured with steel sheet S235JR (FE360B) with mechanical specifications according to standard UNI EN10025

They can be manufactured with steel sheet 325JR (FE510B) on request

The double conic outreach is always supplied un-assembled and set-up for coupling at the foot of the installation with stop ring and locking grub screws.

The internal and external surface protection is achieved through a hot galvanising process, by dipping in molten zinc, and previous pickling to eliminate all debris and impurity.













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For insertion in the urban field of application or when it is necessary to reinforce protection against the effects of the elements, the pole may go through a painting cycle (see page xxx)

*The poles are designed for end-pole configuration.*

*For diversified illuminating engineering needs, they may be equipped with outreaches or crossbeams (see page xxx)*

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liniate	8000	2500	800	3	60x163	108	4,5	46x186	1800	600	1000x1000	300x800
vesuvio	8000	2500	800	4	60x163	142	4,5	46x186	1800	600	1100x1000	300x800
capodichino	9000	2500	800	3	60x173	121	5,2	46x186	1800	600	1050x1000	350x800
stromboli	9000	2500	800	4	60x173	160	5,2	46x186	1800	600	1150x1000	350x800
etna	10000	2500	800	4	60x183	177	5,6	46x186	1800	600	1200x1000	350x800

	height outside ground (mm)		quota of location for grounding system to base pole (mm)
	underground (mm)		number hook, diameter and lenght
	lenght topper (mm)		interaxle spacing for hook
	shelf arm (mm)		dimensions to the plinth monobloc side x heights (mm)
	evolution arm (mm)		dimensions of the holein to the plinth of groundwork for insert of the pole diameter x height (mm)
	curve ray (mm)		dimensions of the foundation of a plinth a recess side x heights (mm)
	diameter (mm)		dimensions of the little pillar of a plinth a recess side x heights (mm)
	tip diameter (mm) base diameter (mm)		total weight(kg)
	lenght (mm)		weight minimal and maximum for the siystem of movement manual with cable (kg)
	n° spotlight		weight minimal and maximum for the siystem of movement manual with manual winch (kg)
	thickness (mm)		
	thickness blunt on tip (mm)		
	thickness blunt in base (mm)		
	maximum pull applicabile on top (mm)		
	dimensions maximum of flag for velocity of wind to 100km/h; side for height (mxm)		
	dimensions slot cable entry slot (mmxmm)		
	quota of location for slot clips to pole base (mm)		
	quota of location cable entry slot to pole base (mm)		
			movement: M: semi integrated manual S: semi integrated electric P: portable electric I: integrated C: wheeled
			surface for paint (m2)
			calculation adapt to the norm EN40 certification CE
			calculation adapt to the D.M. 17/01/2018
			number of arms
			ray of incline