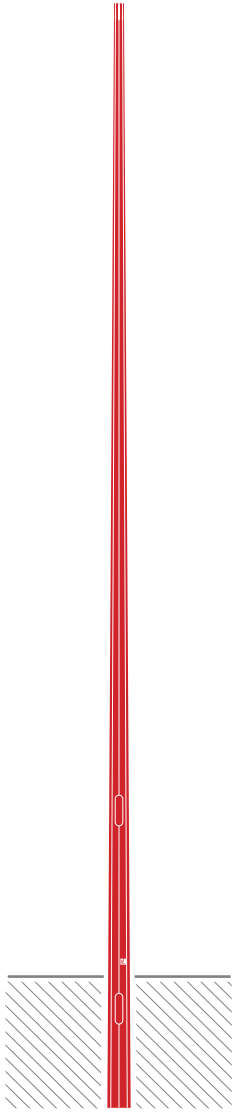
sheet metal roll flattening and cutting . The sheet metal roll is flattened by means of a combined “straightening-flattening” system with edge trimming to reach the due dimensional tolerances. The metal sheet is then cut with a longitudinal shear to obtain two equal trapezoids.

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 fulfilment 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).

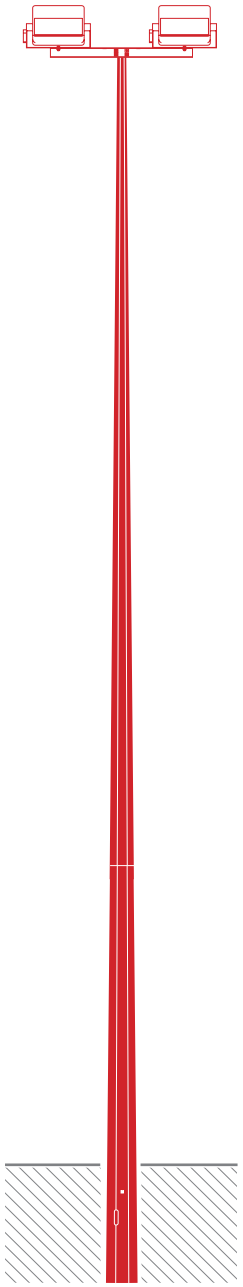
testing . Every stage of processing is constantly controlled by personnel working under the supervision of the Quality Control Department Manager.



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 325JR (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 (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)
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 or contact the nearest agency.

PNI	3500/3	3000	500	3	60x97	21	0,8	-	-	350	750x800	200x500
PNI	4000/3	3500	500	3	60x102	25	1,0	-	-	350	750x800	200x500
PNI	4500/3	4000	500	3	60x107	28	1,1	-	-	350	800x800	250x500
PNI	5500/3	5000	500	3	60x117	37	1,5	-	-	350	850x800	250x500
PNI	6800/3	6000	800	3	60x131	48	2,0	46x186	1800	600	850x1000	300x800
PNI	7800/3	7000	800	3	60x141	58	2,4	46x186	1800	600	900x1000	300x800
PNI	7800/3	7000	800	4	60x141	77	2,4	46x186	1800	600	1000x1000	300x800
PNI	8800/3	8000	800	3	60x151	69	2,9	46x186	1800	600	950x1000	300x800
PNI	8800/4	8000	800	4	60x151	91	2,9	46x186	1800	600	1000x1000	300x800
PNI	9800/3	9000	800	3	60x162	81	3,4	46x186	1800	600	1000x1000	300x800
PNI	9800/4	9000	800	4	60x162	107	3,4	46x186	1800	600	1050x1000	300x800
PNI	10800/3	10000	800	3	60x172	93	3,9	46x186	1800	600	1000x1000	300x800
PNI	10800/4	10000	800	4	60x172	123	3,9	46x186	1800	600	1100x1000	300x800
PNI	11800/4	11000	800	4	60x182	141	4,4	46x186	1800	600	1150x1000	300x800
PNI	12800/4	12000	800	4	60x192	160	5,0	46x186	1800	600	1250x1000	300x800



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 (FE5a10B) on request
* pole composed of two sections to be joined by slip on joint at the foot of the installation.
Standard processing: cable entry slot and earthing.
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 (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)
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 or contact the nearest agency.

ABI 12.0/A	12000	1000	4,0	4,0	108x290	270	8,5	1600x1200	500x1000
ABI 14.0/B*	14000	1000	3,5	3,5	108x298	290	10,0	1500x1200	500x1000
ABI 14.0/C*	14000	1000	3,5	3,5	108x385	350	12,0	1800x1200	600x1000
ABI 16.0/C*	16000	1000	3,5	3,5	108x422	400	14,5	1900x1200	600x1000
ABI 16.0/D*	16000	1500	3,5	4,0	108x460	475	15,0	2100x1200	700x1000
ABI 18.0/C*	18000	1500	3,5	4,0	108X501	565	18,5	2200x1200	800x1500


height outside ground (mm)


underground (mm)


lenght topper (mm)


shelf arm (mm)


evolution arm (mm)


curve ray (mm)


diameter (mm)


tip diameter (mm)
base diameter (mm)


lenght (mm)


n° spotlight


thickness (mm)


thickness blunt on tip (mm)


thickness blunt in base (mm)


maximum pull applicable 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)


quota of location for grounding system
to base pole (mm)


number hook, diameter and lenght


interaxle spacing for hook


dimensions to the plinth monobloc
side x heights (mm)


dimensions of the holein to the plinth of groundwork
for insert of the pole diameter x height (mm)


dimensions of the foundation of a plinth a recess
side x heights (mm)


dimensions of the little pillar of a plinth a recess
side x heights (mm)


total weight(kg)


weight minimal and maximum for the siystem
of movement manual with cable (kg)


weight minimal and maximum for the siystem
of movement manual with manual winch (kg)


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