

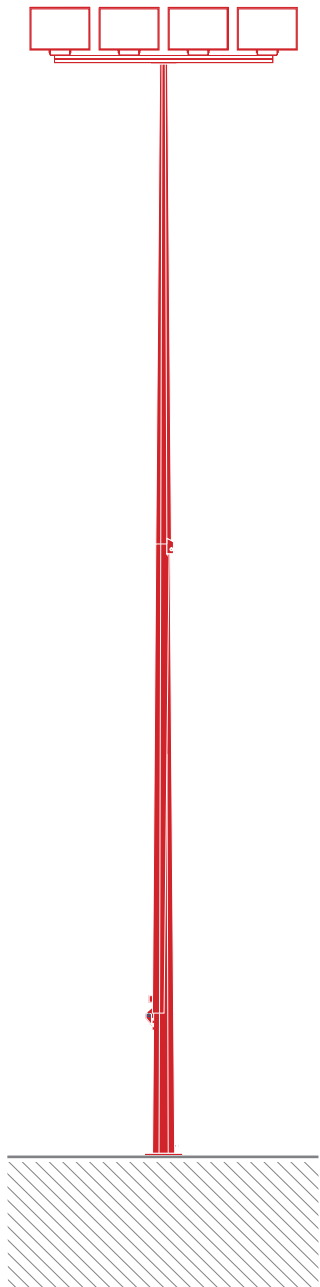
sheet metal roll flattening and cutting . The sheet metal roll is flattened by means of a combined “straightening-flattening” system with edge trimming to reach the due dimensional tolerances. The metal sheet is then cut with a longitudinal shear to obtain two equal trapezoids.

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 (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)

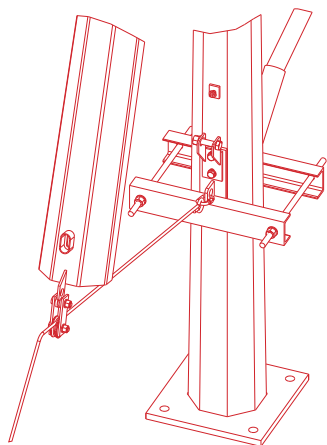
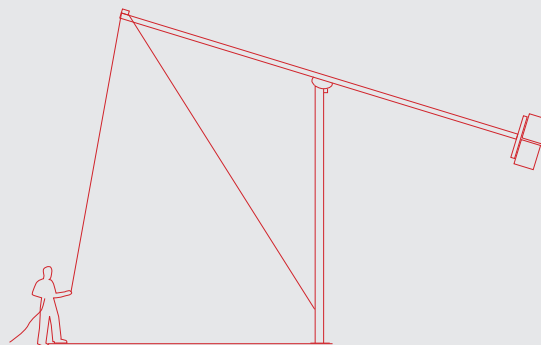
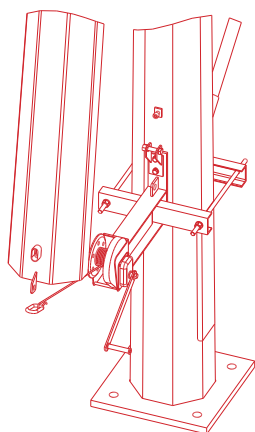
The poles are designed for end-pole configuration.

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. floodlights on one side and the weight of the tiltable element on the other; The operator only needs to control the operation by handling the rope. Poles over 12 m long are supplied in 2 sections, joined using the slip on joint method, by the installation technician. The minimum and maximum weights are provided in the tables.

RB 9-A	9000	4	4	78x178	230	4 M20/600	125	4,5	1300x1200	10/35	10/60	
RB 10-A	10000	4	4	78x220	270	4 M24/800	210	5,5	1500x1200	15/60	15/80	
RB 12-B	12000	5	4	78x250	320	4 M30/1000	430	8	1700x1200	30/65	30/95	
RB 14-A*	14000	4	4	96x300	320	4 M30/1000	500	11	1800x1200	35/65	35/100	
RB 14-B*	14000	5	4	96x300	380	8 M30/1000	531	11	2000x1200	35/65	35/100	
RB 16-A*	16000	5	4	110x310	380	8 M30/1000	641	15	2200x1200	45/75	45/110	
RB 18-A*	18000	5	4	130x340	460	8 M30/1000	836	17	2200x1200	55/90	55/135	

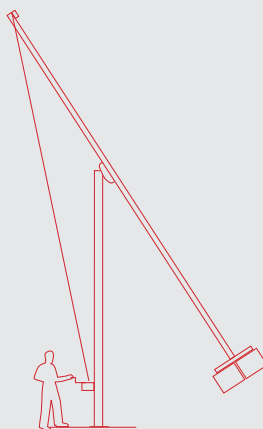
system M**system AM**

M system indirect drive manual movement. The tilting pole, with rope-operated manual drive “M System” consists of:

- stem with octagonal cross-section featuring hinge unit with rotation pin;
- tiltable element welded to the top section;
- locking system on the base of the pole;
- base plate and anchor bolts .
- nylon handling rope;
- floodlight bearing crosspiece (assessed for each case based on the number of installed floodlights).

There is no slot for the terminal block.

This movement, suitable for small loads on the top, makes pole tilting easy and immediate. Rotation occurs by gravity, compensated by the weight of the floodlights on one side and the weight of the tiltable element on the other; The operator only needs to control the operation by handling the rope. Poles over 12 m long are supplied in 2 sections, joined using the slip on joint method, by the installation technician. The minimum and maximum weights are provided in the tables.



AM hoist-operated movement system . To achieve better performance, in terms of weight applicable to the top, the poles can be equipped with the movement system featuring the manual hoist “AM system” with steel rope (a single hoist can move all of the poles installed in the same system). This system, also suitable for heavy loads, offers the possibility of moving the pole, minimising the effort required for tilting.

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