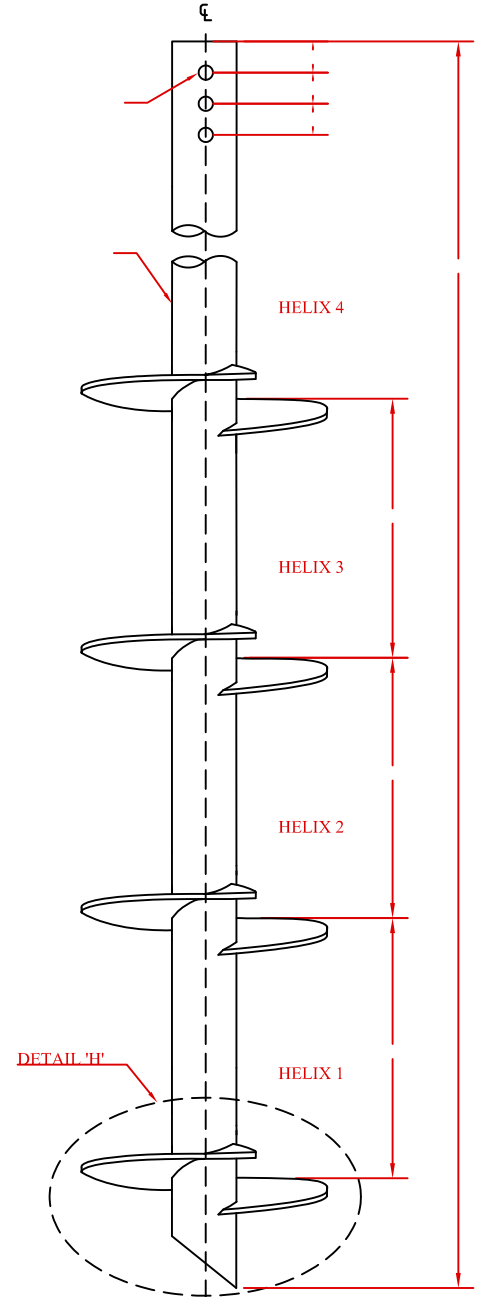
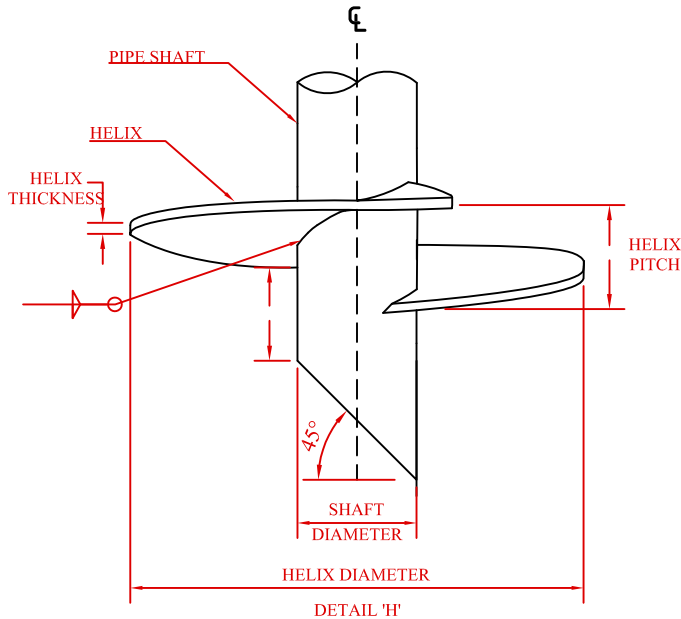


PILE SPECIFICATIONS

1. PILE HELIX TO BE OF TRUE PITCH.
2. ALL PIPE AND PLATE MATERIAL TO BE NEW MATERIAL.
3. PIPE MATERIAL SHALL CONFORM TO ASTM A252 GRADE 2 OR 3 OR EQUIVALENT.
4. HELIX PLATE MATERIAL SHALL CONFORM TO CSA-G40.21, GRADE 300W MATERIAL.
5. HELIXES SHALL BE WELDED TO THE PIPE SECTION USING A CONTINUOUS FILLET WELD ON BOTH SIDES OF THE HELIX PIPE CONNECTION.
6. WELDING ELECTRODES SHALL CONFORM TO CSA W48.1
7. ALL WELDING TO MEET CWB W47.1 REQUIREMENTS.
8. PILE SPLICES, IF REQUIRED, SHALL BE FULL PENETRATION WELDS AND CONFORM TO CSA W59.
9. DRIVE HOLE(S) CAN BE ROTATED BUT ALL HOLES SHALL BE IN A CONTINUOUS LINE IN RELATION TO THE CIRCUMFERANCE OF THE PILE SHAFT.

PILE TOLERANCES

DIMENSION	TOLERANCE
PILE LENGTH	(+/-) 2% UNLESS SPECIFIED IN WORK ORDER
WALL THICKNESS	(+)5% /-12.5%
PILE O.D.	(+/-) 1%
PILE CUT 45 DEGREES	(+/-) 5 degree
HOLE DISTANCE FROM TOP	(+) 0/ -1/4"
HOLE DISTANCE FROM EACH OTHER	(+/-) 1/8"
HOLE DIAMETER	(+) 1/2" / -0
PILE TOP END	SQUARE; DEVIATION $\frac{1}{16}$ " FOR PIPE O.D. 0-12" & $\frac{1}{8}$ " FOR PIPE O.D. >12"
HELIX SPACING	+2.5% & -5%
HELIX THICKNESS	(+/-) 1/16"
HELIX DIAMETER	(+/-) 3/4"
HELIX PITCH	(+/-) $\frac{1}{4}$ " FOR THE SAME SIZE OF HELIX
DISTANCE FROM TOP OF PILE CUT TO BOTTOM OF FIRST HELIX	6" (+/-) 3/4" BUT FOR 2 $\frac{7}{8}$ " & 3 $\frac{1}{2}$ " SHAFT IT SHOULD BE 4" (+/-) 3/4"
WELD SIZE MIINIMUM	3/8" & 1/2" – 6mm (1/4") 1 PASS; 3/4" & 1" – 9.5mm (3/8") 3 PASSES UNLESS SPECIFIED IN WO OR DRAWING



25420 114 Avenue
Acheson, AB T7X 6M4

INSTALLER:

DWG TITLE:

PROJECT REF:

DWG NO:

REV	DATE	DESCRIPTION	DESIGNED	DRAWN	CHECKED	APPROVED

SCALE:

SIZE:

SHEET:

OF