

MCWANE POLES

FIELD ASSEMBLY GUIDE

The following are guidelines for field assembly of a two-piece McWane Pole. These field assembly Instructions supersede any prior guidelines. In addition, respective company and equipment guidelines should be followed.

Assembly equipment required includes a McWane Poles jacking kit, two chain hoists, a drill and 11/16" drill bit, and two wrenches. Jacking kits are available for purchase from McWane Poles. Jacking kit contents include four (4) jacking lugs, two (2) 5/8" Grade 5 bolts, four (4) washers, and two (2) 5/8" nuts. Jacking kits are reusable as long as the members are not used improperly or damaged. Additionally, a 5/8" through-bolt, washer, and nut are provided with each two-piece pole to mechanically secure the slip joint and sections after they slipped together.

Assembly Steps:

- Step 1:** Align pole sections, making sure the serial number of the top pole piece (located on the pole top tag) and the serial number of the bottom piece (located on the tag above ground line) match and the pole quadrants are aligned. A "B" line will be marked on the top and bottom piece of the pole at the joint.
- Step 2:** Attach four (4) jacking lugs to pole sections at the jacking hole locations with the 5/8" Grade 5 bolts. **WARNING: Tighten nuts to between 110 and 150 ft-lbs. of torque and verify that jacking lug plates are tight against pole surface.** IF NUT BOTTOMS OUT ON THREADS, DO NOT PROCEED. A SHORTER BOLT IS REQUIRED.
- Step 3:** Connect two chain hoists to jacking lugs.
- Step 4:** Jack pole sections together with two chain hoists simultaneously. Sections should be jacked with a force equal to the anticipated axial load. **WARNING: do not exceed 10,000 pounds of tension force in each of the chain hoists.** Ensure that the minimum overlap is reached and no gap larger than 1/8" remains between adjoining sections. Insertion depth could be greater than specified minimum insertion depth depending on pole class. If more than 20,000 lbs. of combined assembly force is needed for the pole application, please contact your McWane Poles representative.
- Step 5:** Drill through the inserted section at hole locations provided in receiving section. Remove pilot bit from hole saw bit to avoid breaking pilot bit when drilling hole for through-bolt.
- Step 6:** Insert through-bolt through holes in section overlap and tighten nut to between 80 and 100 ft-lbs. of torque.

Helpful Tips:

- Field assembly may affect specified pre-drilled hole measurement on the bottom section of the structure depending on the amount of overlap of sections.



Pictured Above: Four jacking lugs are attached with bolts provided with the McWane jacking kit. Chain hoists are connected to jacking lugs and in position for section assembly. The 17" mark indicates the minimum section insertion amount for the example pole, which along with the B axis will be clearly marked by the factory. The minimum insertion amount will be based upon pole length and section number. The inserting section should be inserted to the minimum overlap mark.