

**700 OVERHEAD SIGN STRUCTURES.**  
**(REV 6-27-06) (FA 7-12-06) (1-07)**

SUBARTICLE 700-2.4 (Pages 725 and 726) is expanded by the following new Subarticle:

**700-2.4.3 Installation:** Install high strength ASTM A325 bolt, nut and washer assemblies for Span Sign Structure alternate splice connections in accordance with Section 460. Install nuts on anchor rod in accordance with 649-5. Install all other bolt (ASTM A307 or substitute ASTM A325), nut and washer assemblies in accordance with the following: Use bolt, nut and washer assemblies that are free of rust and corrosion. Tighten nuts, as necessary, to bring the faying surfaces of the assembly into full contact from the interior of the connection outwards in a symmetrical pattern. After bringing the faying surfaces of the assembly into full contact, tighten nuts to achieve the minimum torque as specified in Table A. Within 24 hours after final tightening, the Engineer will witness a check of the minimum torque using a calibrated torque wrench for no less than 3 bolts and a minimum of 10% of the fastener assemblies for each connection.

Bolt Diameter (in.)	Minimum Torque (ft.-lbs.)
3/8	15
1/2	37
5/8	74
3/4	120
7/8	190
1	275
1 1/8	375
1 1/4	525