



## MULTIPLE SECTION POLES/SLIPJOINTS

### Recommended Field Assembly and Erection Procedures

Upon receipt, at the job site, the pole sections should be carefully examined for match markings or piece marks and arranged horizontally on the ground on blocks in the sequence that they are to be assembled. Assembly is achieved by using either come-alongs or hydraulic jacking devices, typically with a minimum total capacity of 2500 pounds, until the sections are forced together snugly.

The joints should have a minimum overlap of 2" less than  $1 \frac{1}{2}$  times the inside diameter of the butt end of the female tube. Once the correct amount of overlap has been determined, the poles should be marked with crayon at that point and then tape a measured distance (12 inches) beyond that point so that when the pole is assembled, the total minimum amount of overlap can be ascertained. Note: Regardless of the actual slip length achieved, it is important that the joint is as tight as possible with no more than minimal gaps.

Prior to implementing actual assembly, each telescoping joint should be prepared by removing all dirt and foreign material from both the male and female ends and applying a light coat of lubricant on each of these areas to insure ease of joining together. A silicone-based lubricant will minimize the possibility of abnormal stains developing at the slip joint. If other types of lubricants are used, the joints should be carefully cleaned to remove any excess lubricant. Whenever prefinished pole sections are involved, additional care should be exercised during the assembly operation to preclude unnecessary damage to the finished surfaces.

After the slip joints are prepared and the sections are properly aligned, the assembly can commence and continue until all sections are forced together snugly, resulting in a unitized structure. The joints should be lashed securely together to prevent slipping apart during erection. This can be done by using (2) come-alongs. One end of each come-along should be attached to the female tube above the joint at  $180^\circ$  apart and the other ends should be attached in the same manner to the male tube below the joint.

During the erection of the assembled structure, it is not recommended that the lift load be applied directly to any telescoped joint. The joints also are not to be welded nor are they to be drilled and secured with mechanical fasteners. When properly lashed together, there should not be any problem with the joints slipping apart when the pole is erected.



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