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PRODUCT SPECIFICATION

12 & 14 GAUGE SQUARE POST

MATERIAL: Steel posts furnished shall conform to the Standard Specification for Hot-Rolled Carbon Sheet Steel, structural quality, ASTM A1011 (previously A570). Posts shall conform to the Standard Specification for Electric-Resistance-Welded Metallic-Coated Carbon Steel Mechanical Tubing, ASTM designation A787.

FINISH: The square sign post tubing shall be hot-dipped galvanized conforming to ASTM specification A653 designation G90. The weld is zinc-coated after scarfing operation.

SHAPE: The cross section of the post shall be square tubing formed of 12 or 14 gauge steel, carefully formed into size, and induction welded in such a manner that neither weld nor flash shall interfere with telescoping properties.

HOLES: Holes shall be $7/16'' \pm 1/64''$ in diameter on 1'' centers for the entire length of the post. Holes shall be on the center line of each side in true alignment and opposite to each other.

YIELD STRENGTH PROPERTIES: 60,000 PSI minimum

THICKNESS: 12 gauge 0.094 min., 0.105 nominal
14 gauge 0.074 min., 0.083 nominal

TELESCOPING PROPERTIES:

The finished post shall be straight and have a smooth uniform finish. It shall be possible to telescope the post with each consecutive larger or smaller size of square tube, freely and for not less than ten feet of their length without the necessity of matching any particular face to any other face. All holes and end shall be free from burrs.

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TOLERANCES:

<u>Nominal Outside Dimensions</u>	<u>Outside Tolerance on All Sides at Corners</u>
1 ³ / ₄ " x 1 ³ / ₄ "	± 0.010"
2" x 2"	± 0.010"
2 ¹ / ₄ " x 2 ¹ / ₄ "	± 0.010"
2 ¹ / ₂ " x 2 ¹ / ₂ "	± 0.010"

Note: Measurements from outside dimension shall be made at least 2" from end of tube.

Squareness of Sides and Twists:

<u>Nominal Outside Dimensions</u>	<u>Squareness Tolerance</u>	<u>Twist Permissible in 3' length</u>
1 ³ / ₄ " x 1 ³ / ₄ "	± 0.010"	0.062"
2" x 2"	± 0.012"	0.062"
2 ¹ / ₄ " x 2 ¹ / ₄ "	± 0.014"	0.062"
2 ¹ / ₂ " x 2 ¹ / ₂ "	± 0.016"	0.062"

Note: A sample shall be considered to fail if its sides are not 90 degrees to each other within the squareness tolerance listed above.

Corner Radii: Standard outside corner radii shall be 5/32" ± 1/32"

Length: The length of each post shall be as specified and have a permissible length tolerance of ± 1/4"

Straightness: 1/16" in 3 feet

<u>Size</u>	<u>Gauge</u>	<u>Weight Per Foot, Pounds</u>	
		<u>Perforated</u>	<u>Not Perforated</u>
1 ³ / ₄ " x 1 ³ / ₄ "	14	1.65	1.83
1 ³ / ₄ " x 1 ³ / ₄ "	12	2.10	2.22
2" x 2"	14	1.85	2.03
2" x 2"	12	2.35	2.47
2 ¹ / ₄ " x 2 ¹ / ₄ "	12	2.78	2.90
2 ¹ / ₂ " x 2 ¹ / ₂ "	12	3.16	3.28

All specifications are subject to change without notice.