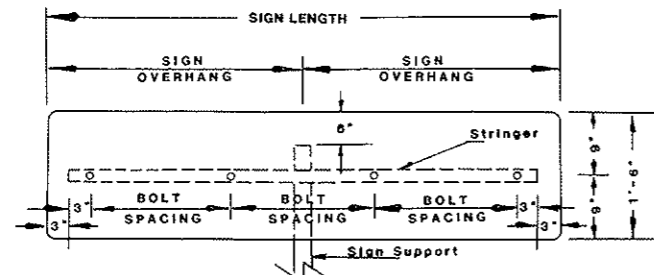
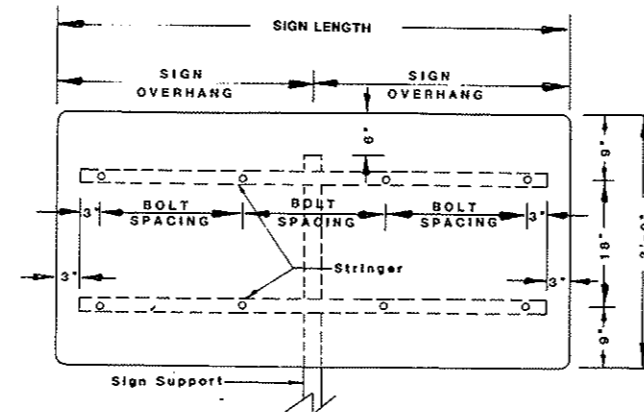


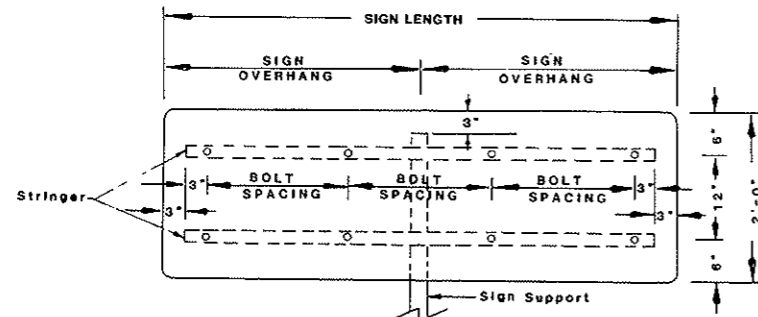
SIGN PUNCHING, STRINGER, AND SUPPORT LOCATION DETAILS FOR VARIABLE LENGTH SIGNS



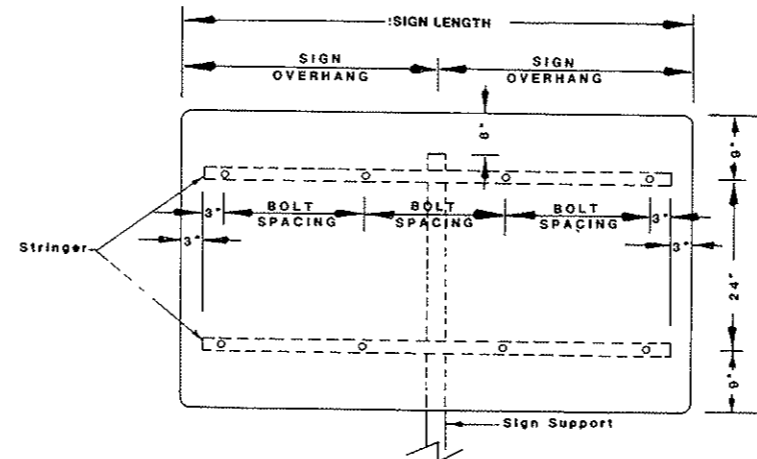
VARIES X 1'-6"



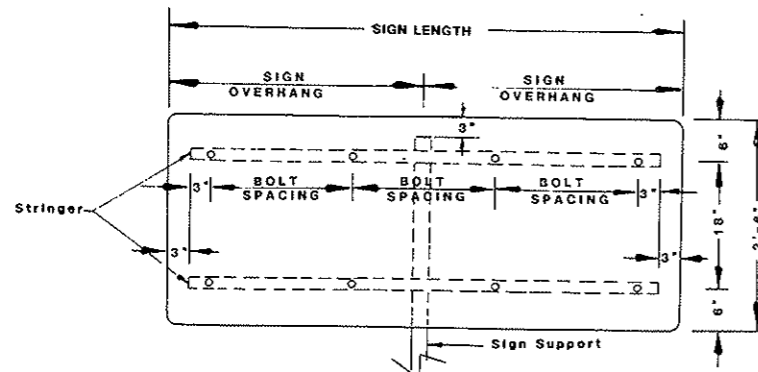
VARIES X 3'-0"



VARIES X 2'-0"



VARIES X 3'-6"



VARIES X 2'-6"

Sign Length	1 POST, 2 POSTS, 3 POSTS, 4 POSTS, & INFORMATION										1 POST Sign Overhang
	ASSEMBLY NUMBERS										
	1'-6" High	2'-0" High	2'-6" High	3'-0" High	3'-6" High	4'-0" High	4'-6" High	5'-0" High	5'-6" High	Bolt Spacing	
4'-0"	81	107	140	173	206	239	272	306	338	18"	2'-0"
4'-6"	82	108	141	174	207	240	273	306	339	21"	2'-3"
5'-0"	83	109	142	175	208	241	274	307	340	24"	2'-6"
5'-6"	84	110	143	176	209	242	275	308	341	28"	2'-9"
6'-0"	85	111	144	177	210	243	276	309	342	20"	3'-0"
6'-6"	86	112	145	178	211	244	277	310	343	22"	3'-3"
7'-0"	87	113	146	179	212	245	278	311	344	24"	3'-6"
7'-6"	88	114	147	180	213	246	279	312	345	2-20" & 2-19"	3'-9"
8'-0"	89	115	148	181	214	247	280	313	346	21"	4'-0"
8'-6"	90	116	149	182	215	248	281	314	347	2-22" & 2-23"	4'-3"
9'-0"	91	117	150	183	216	249	282	315	348	24"	4'-6"
9'-6"	92	118	151	184	217	250	283	316	349	4-20" & 1-22"	4'-9"
10'-0"	93	119	152	185	218	251	284	317	350	2-21" & 3-23"	5'-0"
10'-6"	94	120	153	186	219	252	285	318	351	4-23" & 1-22"	5'-3"
11'-0"	95	121	154	187	220	253	286	319	352	24"	5'-6"
11'-6"	96	122	155	188	221	254	287	320	353	21"	5'-9"
12'-0"	97	123	156	189	222	255	288	321	354	22"	6'-0"
12'-6"	98	124	157	190	223	256	289	322	355	23"	
13'-0"	99	125	158	191	224	257	290	323	356	24"	
13'-6"	100	126	159	192	225	258	291	324	357	3-22" & 4-21"	
14'-0"	101	127	160	193	226	259	292	325	358	2-23" & 6-22"	
14'-6"	102	128	161	194	227	260	293	326	359	0-23" & 1-24"	
15'-0"	103	129	162	195	228	261	294	327	360	24"	
15'-6"	104	130	163	196	229	262	295	328	361	0-22" & 2-21"	
16'-0"	105	131	164	197	230	263	296	329	362	4-23" & 4-22"	
16'-6"	106	132	165	198	231	264	297	330	363	0-23" & 2-24"	
17'-0"		133	166	199	232	265	298	331	364	24"	
17'-6"		134	167	200	233	266	299	332	365	22"	
18'-0"		135	168	201	234	267	300	333	366	0-23" & 3-22"	
18'-6"		136	169	202	235	268	301	334	367	0-23" & 3-24"	
19'-0"		137	170	203	236	269	302	335	368	24"	
19'-6"		138	171	204	237	270	303	336	369	0-22" & 2-23"	
20'-0"		139	172	205	238	271	304	337	370	0-23" & 2-22"	

NOTE:

The single stringer and single post sign shall have stringers attached to the post using the special stringer angle shown std. D-754-24 for Perforated Tube post & stringers or using the stringer attachment plate shown on std. D-754-25 for Flange Channel post and stringers.

NOTE:

Material:

Sign Backing: The sign backing material thickness shall be as follows:

Aluminum: Aluminum Alloy 6061-T6 and 5052-H38 shall have the following minimum thickness: All signs shall be 0.100 inch.

Stringers:

Flange Channel: All stringers shall be flange channel 1.12x per foot and of length shown.  
 Square Tube, Perforated: All stringers shall be square tube, perforated 1 1/2"x 1/2" and of the length shown.

Holes:

Flange Channel: All holes shall be punched round for 3/8" diameter bolts.  
 Square Tube, Perforated: All holes shall be punched round for 3/8" diameter bolts.

General:

See plans for sign numbers to be used at each location.  
 See Std. D-754-24 for square tube, perforated mounting details.  
 See Std. D-754-25 for flange channel mounting details.

10-1-86		NORTH DAKOTA DEPARTMENT OF TRANSPORTATION
REVISIONS		
DATE	CHANGE	APPROVED: <i>David K. Wilson</i> DESIGN ENGINEER
5-1-92 6-3-93	GENERAL REVISIONS BOLT SPACING	