

		NUMBER OF EXTRUDED STIFFENERS REQUIRED*												
		PANEL WIDTH												
PANEL HEIGHT	2'	2	2	2	3	3	3	4	4	4	5	5	5	5
	3'	2	2	2	3	3	3	4	4	4	5	5	5	5
	4'	2	2	2	3	3	3	4	4	4	5	5	5	5
	5'	2	2	2	3	4	4	5	5	5	5	5	5	6
	6'			2	3	4	4	5	5	5	5	5	5	6
	7'				4	4	5	5	5	5	5	5	5	6

\* WHERE SIGN PANEL DIMENSIONS FALL BETWEEN 1' INCREMENTS, USE NEXT HIGHER WIDTH AND/OR HEIGHT DIMENSION.

**NOTES:**

FURNISH AND INSTALL AT LEAST ONE SPACER FOR EACH SIGN PANEL WHEN PANELS ARE ATTACHED TO THE LOWER MAST ARM CHORD.

AFFIX SIGNS TO UPPER AND LOWER MAST ARM CHORDS WHEN POSSIBLE.

POSITION BOTTOM OF SIGN PANEL AT LEAST 17' ABOVE ROADWAY.

MOUNT SIGN PANELS PLUMB AND SHIM WITH REQUIRED SPACERS AS SHOWN.

PROVIDE SPACING BETWEEN STIFFENERS OF NO MORE THAN 36".

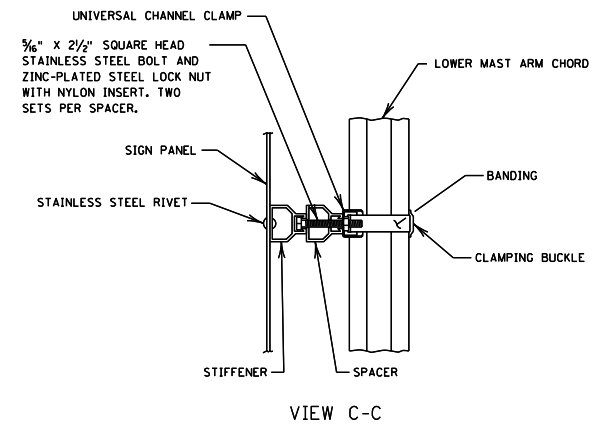
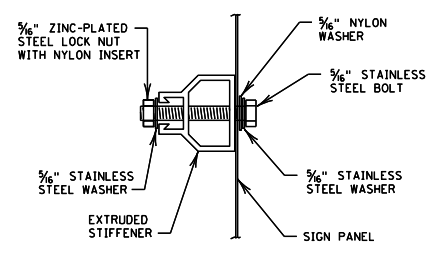
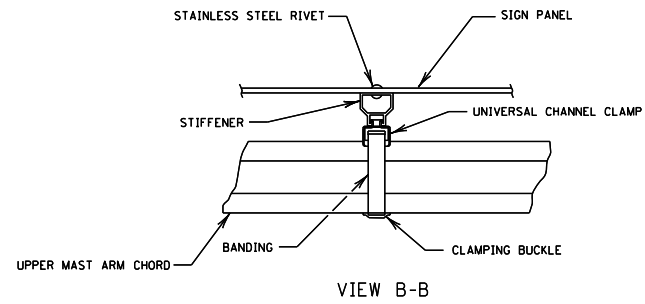
PROVIDE A HORIZONTAL DISTANCE OF NO MORE THAN 12" FROM PANEL EDGE TO STIFFENER.

PROVIDE A VERTICAL DISTANCE OF NO MORE THAN 1" FROM PANEL EDGE TO STIFFENER.

FURNISH AND INSTALL 1/4" STAINLESS STEEL RIVETS 3" FROM THE PANEL EDGE TO ATTACH THE STIFFENERS TO THE SIGN PANELS. FURNISH AND INSTALL 3/16" STAINLESS STEEL RIVETS AT 6" ON CENTER TO ATTACH THE REMAINDER OF THE STIFFENER TO THE SIGN PANEL.

FURNISH TWO TYPE 201 STAINLESS STEEL 3/4" WIDE BY 1/2" THICK STRAPS, EACH WITH CLAMPING BUCKLES AND INSTALL SEPARATELY WITH A SINGLE WRAP AROUND THE MAST ARM CHORD. PLACE THE SECOND BANDING STRAP OVER THE FIRST STRAP AND STAGGER THE CLAMPING BUCKLES SO THE BUCKLES ARE NOT DIRECTLY OVER ONE ANOTHER.

THE "A" DISTANCE IS SHOWN ON THE PLANS. IT IS THE DISTANCE FROM THE END OF THE MAST ARM TO THE EDGE OF EACH SIGN.



① SIGN PANELS TALLER THAN 36" MUST BE BANDED TO THE LOWER MAST ARM CHORD AT A MINIMUM OF ONE LOCATION. SIGN PANEL SHALL BE BANDED TO THE LOWER MAST ARM AT A LOCATION THAT WILL PROVIDE THE CLOSEST TO PLUMB ALIGNMENT FOR THE SIGN PANEL.

REVISION: APRIL 17, 2020  
 APPROVED: OCTOBER 16, 2019  
 Brian Sorenson  
 STATE TRAFFIC ENGINEER

**m** MINNESOTA  
 DEPARTMENT OF TRANSPORTATION  
 Peter A. Harff  
 STATE DESIGN ENGINEER

STANDARD PLAN 5-297.731 1 OF 1  
 APPROVED: 10-16-2019  
 REVISED: 4-17-2020  
 STATE PROJ. NO. (TH ) SHEET NO. OF SHEETS

**SIGN MOUNTING DETAILS FOR SIGNAL MAST ARMS**