



1" WIDE INDENTATIONS SHALL BE FORMED BY DISPLACEMENT OF METAL IN A SPIRAL PATTERN, 90° OUT OF PHASE WITH ADJACENT DEFORMATION.

SPECIFICATIONS: ASTM F1554-99 GR55 &/or  
AASHTO M314-95 GR55  
(QUENCHED & TEMPERED ALLOY)

ROUND BAR: CARBON EQUIVALENT-.45% MAX.  
YIELD STRENGTH-55 KSI MIN  
TENSILE STRENGTH-75 TO 95 KSI  
ELONGATION-8"-18% MIN.  
REDUCTION AREA- 30% MIN. (1/2" TO 2")  
REDUCTION AREA- 22% MIN. (>2" TO 2 1/2")  
REDUCTION AREA- 20% MIN. (>2 1/2" TO 3")

GALVANIZE: ASTM-A153, CLASS C

NUTS: ASTM A563-GR DH, ANSI B18.2.2

THREADS: UNIFIED NATIONAL COARSE  
ANSI B1.1 CLASS 2A  
THREADS ARE ROLLED OR CUT.

WASHERS: ASTM F-436

				SPIRAL SWEDGE BOLT GR 55		
				REVISION: A	P.O. COMPANY:	DRAWN BY: JEP
				DATE:	P.O. NUMBER:	CHECKED BY: AJS
				CONTRACTOR:		
				J. H. Botts LLC		
				DWG. NO.		
A	FOR RELEASE					
REV #	DESCRIPTION	DATE	BY			
	REVISIONS					