



# PALI CAMPION srl

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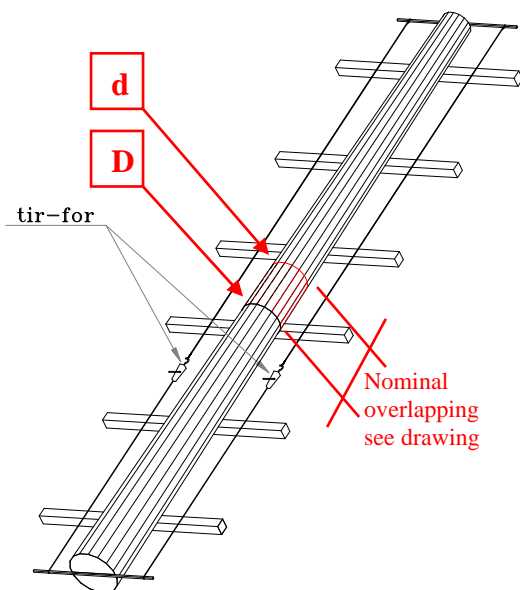
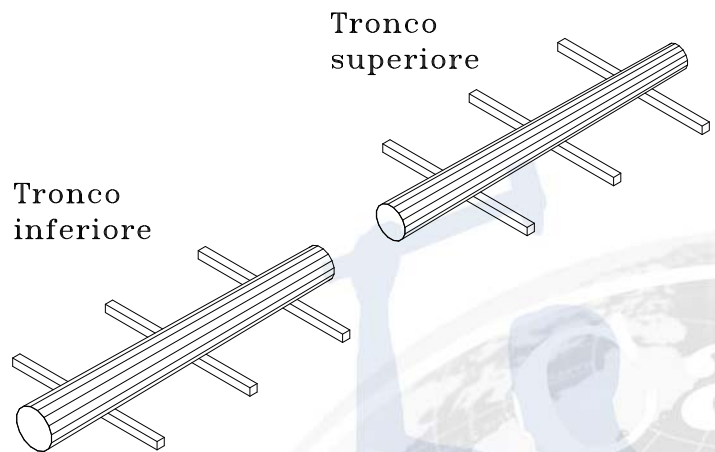


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## INSTRUCTION FOR OVERLAPPING POLYGONAL CROSS SECTION ELEMENTS

**IMPORTANT:** The prescription listed below concern the operation to be done for the overlapping of the polygonal sections. **IN ADDITION TO THE FOLLOWING INSTRUCTION YOU HAVE ALWAYS TO REFER TO THE WORKSHOP DRAWING GIVEN WITH THE ORDER WHICH MAY CONTAIN MORE INFO ACCORDING TH THE SPECIFIC CASE**

Put the masts on wooden edges in such a way that the longitudinal welding line of each shaft coincides with that of the next one. Before proceeding with the assembly You need to be sure that the overlapping areas are free from gravel pebbles or dirt (which may be enter during unloading / handling / storage phases) that can cause problems during the forced overlapping phases.



The assembly of the masts is made by using 2-tir-for (pull and lifting machines) hooking at the end of the section ( as mentioned in the figure) or on the purpose made brackets welded along the shafts, starting, in the case of mast in 3 or more elements, to assemble the base section with the next one and proceeding gradually up to the top section.

The overlapping must be forced up to refusal, but with a strength sufficient bu not bigger than the maximum overlapping force mentioned in the drawings and verification reports. The maximum overalapping force can be calculated approximately with the following simplified formulas.

$$F_{max}(kg) < 43 \times (D-d) \times th. \text{ female section}$$



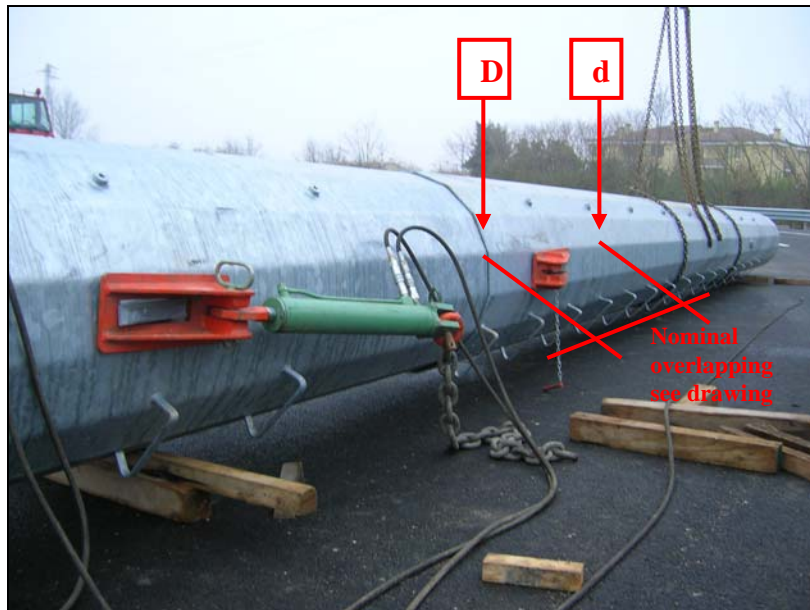
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For masts having big diameters or big thickness the overlapping must be done using hydraulic TIR-FOR welded to the purpose made brackets welded on the shaft itself. Overlapping must be done up to refusal respecting the overlapping length mentioned in the workshop drawings.



The overlapping must be forced up to refusal, but with a strength sufficient but not bigger than the maximum overlapping force mentioned in the drawings and verification reports.

The maximum overlapping force can be calculated approximately with the following simplified formulas.

$$F_{max}(kg) < 43 \times (D-d) \times th. \text{ female section}$$