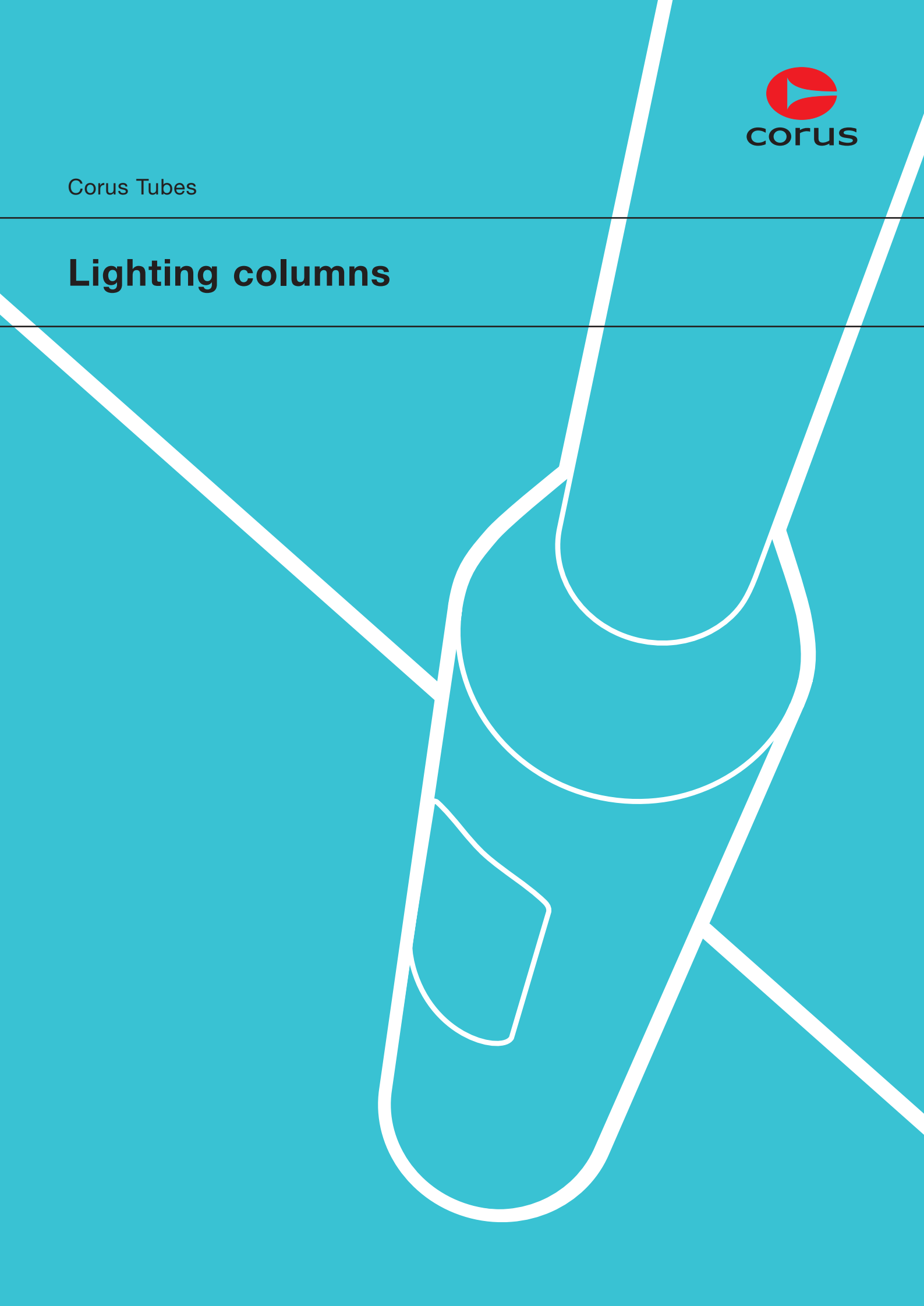


Corus Tubes

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# Lighting columns

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**Corus have been  
producing lighting  
columns for over  
60 years.**

**We are proud of our deserved reputation for  
making the best quality columns on the market.**

## Introduction

**Corus boasts more than 60 years experience in the manufacture of lighting columns. Since March 1992 the manufacturing base has been sited within our tube mills at Corby, Northamptonshire.**

**Corus can point to many notable performances.**

- First company to produce tubular steel lighting columns in the UK.
- First company to protect columns by aluminium metal spray.
- First company to supply the round ended overlap door.
- First lighting column manufacturer to use the integrity of a hot formed 'base to shaft' joint.
- First lighting column manufacturer to be quality assured to BS 5750 part 2.
- First lighting column manufacturer to offer a combination of aluminium metal spray (external) with galvanising (internal).



Although we enjoy all the benefits of being part of a large company the lighting column division comprises of a specialist team with the appropriate skills.

The bedrock of Corus lighting columns is the production of a quality product.

## Quality service

Our Corby based Sales/Technical office offers friendly and efficient service. Its members are experienced in ensuring that your enquiries are dealt with promptly and correctly.

Our Commercial Team includes Designers and Chartered Engineers, backed up by computer based design facilities. We can offer advice on any aspect of the specification from

EN40/BS 5649 to the latest Department of Transport specification.

Our Field Sales Team is available to answer your questions, in person, at your own office.

Our service can also include a team of Structural Engineers, Quality Engineers and Corrosion Prevention Advisors ensuring the highest level of customer

support. We can arrange an inspection service of older or suspect column stock.

We are always seeking to improve our products. Our Company's extensive Technical Research and Development Team and our own on site Inspection Centre means no problem is too big or too small.

## Quality feedstock

### **Our tubular columns are manufactured from either:**

Hot finished circular hollow sections to BS EN 10210 Grades S275J2H or S355J2H or Cold formed circular hollow sections to BS EN 10219 Grades S275J0H OR S355J2H.

### **All tube feedstock is supplied by Corus.**

If as the receiving engineer you require the columns to be certified, we can supply at your option either a Certificate of Compliance or a Test Report both in accordance

with BS EN 10204: 1991 (Metallic products - types of inspection documents).

Control cabin of electric welded stretch reduction mill.



Hot Finished Tube on cooling beds.



Automatic tensile testing of Tube Feedstock.



## Quality Columns to EN40/BS5649

**Our Lighting Columns come with quality built in. They have unique features top to bottom designed to give peace of mind.**

Our hot shrunk joint ensures that the structural integrity of our Lighting Columns is not dependent on welding.

We produce tubular columns from 3 metre to 12 metre mounting heights with a range of shaft and base diameters as set out on pages 6 & 7. Wide bases ensure adequate room for access of the bulkiest gears, whilst our slimline columns provide a

neat solution when integral gear lanterns are used. Our columns come with round ended doors and we offer a flush fitting door featuring a double lock giving additional vandal resistance.

We supply a wide range of bracket arms with a unique bracket to column shaft connection. The top of the shaft is cold reduced to produce a spigot

without welding. The bracket fits over the spigot to prevent any possibility of water ingress. Grub screws tighten into dimples to prevent arm rotation. All bracket arms have a metal cap welded at the top.

Our welders and welding procedures are certified in accordance with BS EN 287 and BS EN 288.

Our hot shrunk joint being formed on the assembly line. The photograph shows a base being pressed inside the column shaft.

After swaging down the top of the column shaft, 4 dimples are stamped to receive bracket arm grub screws for anti rotation.



## Quality protection

**A quality product deserves quality protection.  
Our Securiseal 10 and Securiseal 20 high performance aluminium metal sprayed protections come with guaranteed resistance to corrosion.**

### **Securiseal (Aluminium Spray plus Sealant)**

Columns are firstly protected internally by pouring under pressure a bituminous black solution to coat the whole of the column inside.

After drying, the columns are sent through our shot blasting machine and cleaned to the Swedish specification of SA 2.5.

These columns are immediately carried via conveyors through our automatic aluminium spraying machine which thermally applies a coating of 100 microns (Securiseal 10) or 150 microns (Securiseal 20) of aluminium. This is applied in accordance BS 2569 Part 1 as laid out in BS 5649 Part 4.

The columns are then given additional root protection and sealed externally by the application of a specially formulated resin solution usually corresponding to aircraft grey (BS 381C:693). Other colours can be used upon request.

### **Securigalv Protection**

Being developed as a flagship product with a 30 year guarantee. Galvanised internally to BS EN 1461 and externally grit blasted to SA2.5, Aluminium sprayed to BS EN 22063 (100 or 150 microns) paint sealed and given additional root protection.

Such is our confidence in the ability of such a system to prevent the corrosion of steel, that we will guarantee no further painting need be done to the external surface until its first maintenance is carried out at up to ten years after installation. However as aesthetic appearance is important most engineers have the columns top coated immediately after erection.

### **Hot Dipped Galvanised**

This is carried out in accordance with the requirements of BS EN ISO 1461. After acid pickling to remove any scale or rust, the column is dipped into a bath containing molten zinc maintained at a temperature of about 450°C. Layers of zinc/iron alloy build up towards a surface made up of almost pure zinc. Zinc oxidises at a virtually uniform rate with time, thus its life is principally determined by its thickness and the environment to which it is exposed.

### **Other Protections**

We can offer the latest Highway Agency Specifications and various other paint protections. Root protections include PVC heat shrink sleeves.

Aluminium spraying on automatic equipment.



External Root Protection.



Part of Lighting Columns despatch area.



## Quality ancillaries & specials

Our raise and lower column, offered in galvanised protections, appears like a standard post top. The door, flush fit as standard, can be removed without lowering the column.

Bolt on antique cast iron kits can be supplied to give our standard post tops an olde worlde effect.

We can offer columns with welded flange plates, vented columns and cranked or flattened roots.

Quality enlarged base and parallel traffic sign posts to BS 873: Part 7: 1984.

Enlarged base traffic sign posts are manufactured to the same high standards as our street Lighting Columns and incorporate the unique Corus hot shrunk joint.

Parallel sign posts are available in standard lengths or exact lengths by arrangement.

Available diameters; 60.3, 76.1, 88.9, 114.3, 139.8, 168.3, 193.7 and 219.1.

Finish:- Securiseal finishes can be offered as well as hot dipped galvanised. Caps and base plates to suit are also offered.

Traffic sign posts.



Flush fit doors with twin locks give greater vandal resistance.



Application of sealant to aluminium sprayed columns.



#### 4/5/6 Metre Nominal Height Columns - Post Top/Side Entry

Nominal height (metre)	Column reference	Column type	Shaft Dia.(mm)	Base Dia.(mm)	Planting Depth (mm)	Bracket Type/Ref.
4M-ASH Post top	4PT4A	Small Base	76.1	114.3	800	
	4PT5A	Standard Base	76.1	139.7		
	4PT6A	Large Base	76.1	169.3		
5M-ASH Post top	5PT4A	Small Base	76.1	114.3	800	
	5PT5A	Standard Base	76.1	139.7		
	5PT6A	Large Base	76.1	168.3		
5M- WILLOW SE/TE	4PT5A	Standard Base	76.1	139.7	800	5W (TE) 5W (SE)
5M- Juniper SE/TE	4PT5A	Standard Base	76.1	139.7	800	5J (TE) 5J (SE)
6M-MAPLE Side entry	5S4M	Small Base	76.1	114.3	800	Integral or Detachable Bracket
	5S5M	Standard Base	76.1	139.7		
	5S6M	Large Base	76.1	168.3		
6M-MAPLE Side Entry	6S5M	Standard Base	76.1	139.7	1000	Integral or Detachable Bracket
	6S6M	Large Base	76.1	168.3		
4.7M-Post Top	5PT4L	Small Base	76.1	114.3	800	PLS 1190
5M-LARCH	5PTSL	Standard Base	76.1	139.7		
5M-LARCH Side Entry	5PT6L	Large Base	76.1	168.3		

#### 5,6,8,10 and 12 Metre Nominal Height POPLAR/BIRCH - Single Arm & Single Door

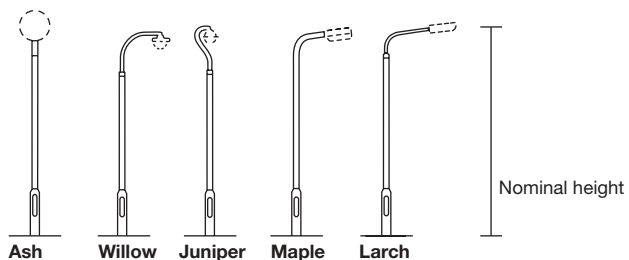
Nominal height (metre)	Column reference	Column type	Shaft Dia.(mm)	Base Dia.(mm)	Planting Depth (mm)	Bracket Type/Ref.
5 metre	5SS (A)	Standard	76.1	139.7	800	PT/SP/SB
6 metre	6SLT(A)	Light	76.1	139.7	1000	PT/SP/SB
	6SO (A)	Quinton	76.1	139.7		
	6SS (A)	Standard	76.1	139.7		
8 metre	8SS (A)	Standard	88.9	168.3	1200	PT/SP/SB
	8SH (A)	Heavy	114.3	168.3		
	8SX (A)	Extra heavy	114.3	193.7		
10 metre	10SQ (A)	Quinton	114.3	168.3	1500	PT/SP/SB
	10SH (A)	Heavy	139.7	168.3		
	10SX (A)	Extra heavy	139.7	193.7		
12 metre	12SLT (A)	Light	139.7	193.7	1700	PT/SP/SB
	12SX (A)	Standard	168.3	193.7		
	12SH (A)	Heavy	168.3	219.1		
	12SX (A)	Extra heavy	168.3	219.1		

#### 6,8,10 and 12 Metre Nominal Height POPLAR/BIRCH - Double Arm & Double Door

Nominal height (metre)	Column reference	Column type	Shaft Dia.(mm)	Base Dia.(mm)	Planting Depth (mm)	Bracket Type/Ref.
6 metre	6DS (A)	Standard	76.1	168.3	1000	PT/DP/DB
8metre	8DS (A)	Standard	88.9	168.3	1200	PT/DP/DB
	8DH (A)	Heavy	114.3	168.3		
	8DX (A)	Extra heavy	114.3	193.7		
10 metre	10DS (A)	Standard	114.3	168.3	1500	PT/DP/DB
	10DH (A)	Heavy	139.7	193.7		
	10DX (A)	Extra heavy	168.3	219.1		
12 metre	12DLT (A)	Light	139.7	193.7	1700	PT/DP/DB
	12DS (A)	Standard	168.3	193.7		
	12DH (A)	Heavy	168.3	219.1		
	12DX (A)	Extra heavy	168.3	219.1		

#### 8,10 and 12 Metre Nominal Height ELM - Double Arm - Single Door

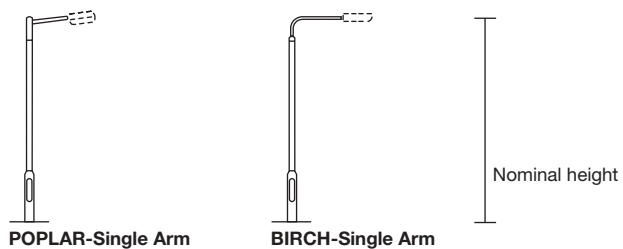
Nominal height (metre)	Column reference	Column type	Shaft Dia.(mm)	Base Dia.(mm)	Planting Depth (mm)	Bracket Type/Ref.
8 metre	8ES (A)	Standard	88.9	168.3	1200	PT/DP
	8EH (A)	Heavy	114.3	168.3		
	8EX (A)	Extra heavy	114.3	193.7		
10 metre	10ES (A)	Standard	114.3	168.3	1500	PT/DP
	10EH (A)	HEAVY	139.7	193.7		
	10EX (A)	Extra heavy	168.3	219.1		
12 metre	12ELT(A)	Light	139.7	193.7	1700	PT/DP
	12ES (A)	Standard	168.3	193.7		
	12EH (A)	Heavy	168.3	219.1		
	12EX (A)	Extra heavy	168.3	219.1		



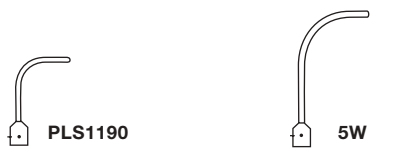
Ash Willow Juniper Maple Larch

**Bracket Types for 5,6,8,10 and 12 Metre Nominal Height Columns**

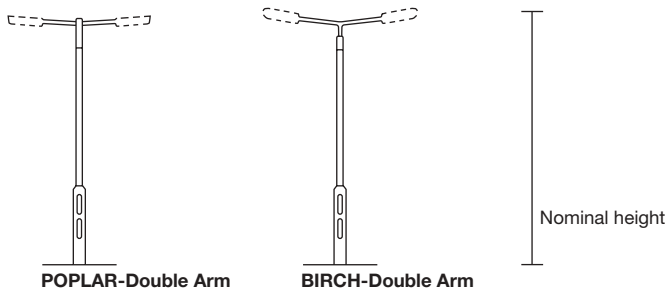
- 5J** Juniper
- DP** Double Arm POPLAR
- SE** Side Entry
- PT** Post Top
- TE** Top Entry
- 5W** Willow
- SB** Single Arm BIRCH
- SP** Single Arm POPLAR
- DB** Double Arm BIRCH



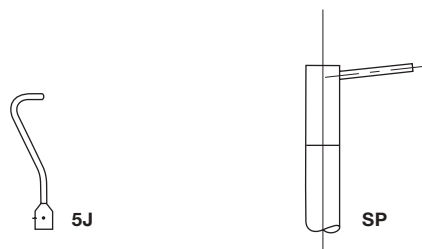
POPLAR-Single Arm BIRCH-Single Arm



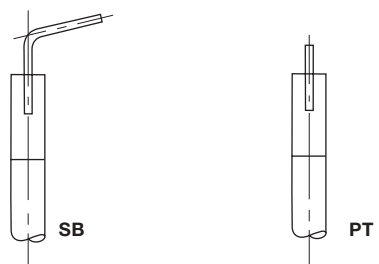
PLS1190 5W



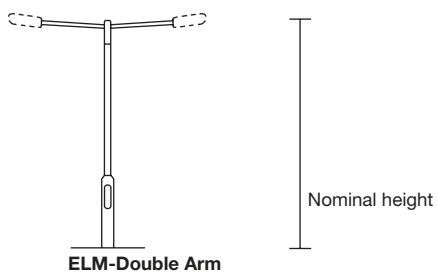
POPLAR-Double Arm BIRCH-Double Arm



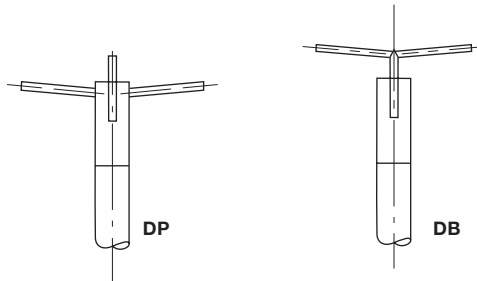
5J SP



SB PT



ELM-Double Arm



DP DB

### Information to be supplied by customer

#### Enquiry/ Order Checklist Lighting Columns to EN40/BS5649

1. Nominal Height - Post Top or with single/double arm bracket.
2. Bracket Projection.
3. (a) Lantern Details manufacturers reference or dimension, weight, wind area.  
(b) Lantern Fixing - spigot outside diameter and length.
4. Location Factor - "K" factor and exposure class (EN40/BS5649: Part 6: Table B1).
5. Planting Depth - unless otherwise specified, standard planting depths will apply.
6. Baseplates - if required.
7. Flange Plates - if required.
8. Corrosion Protection specify finish.
9. Quantity.
10. Any special requirements:  
delivery date/address/sequence.

Supply us with the above information and we will recommend the most suitable column for your requirements.

### Quality Systems

Both the manufacture of the tube feedstock and Lighting Columns are covered by our ISO 9002:1994 Quality Management Systems approval (LRQA Certificate No 840080) Manufacture of Lighting Columns is also approved to LRQA QSS 5020 which gives additional requirements eg: - column design verification, welding, etc.



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Designed by Eikon Ltd

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