

**LOUISIANA
DEPARTMENT OF TRANSPORTATION AND DEVELOPMENT
SPECIFICATIONS**

EXTRUDED SIGN PANELS

Product ID No. 51822 – Size 6”

Product ID No. 11946 – Size 12”

DESCRIPTION:

This specification covers extruded aluminum panels used for the fabrication of signs.

REQUIREMENTS:

Aluminum panels shall comply with ASTM B221, Alloy 6063-T6. Aluminum shall have a chromate conversion coating meeting ASTM B449 or ASTM B921 Class I or II. After fabrication, the sheet shall have a flatness equal to or less than 0.031 inch per foot of length and 0.004 inch per inch of width.

The panels shall conform to the dimensions shown in the “Side View Detail” for the respective Product IDs, “Detail A,” and “Detail B” drawings. Panel width shall be as indicated by the Product ID; panels shall be supplied in either 24’ or 36’ lengths. Panels shall come complete with pre-drilled assembly slots beginning at 6” from the edge then every 12” as shown in the “Top View” drawing.

Panels must be free from grease, dirt or loose phosphate coating and all burrs shall be removed from the edges.

CERTIFICATION:

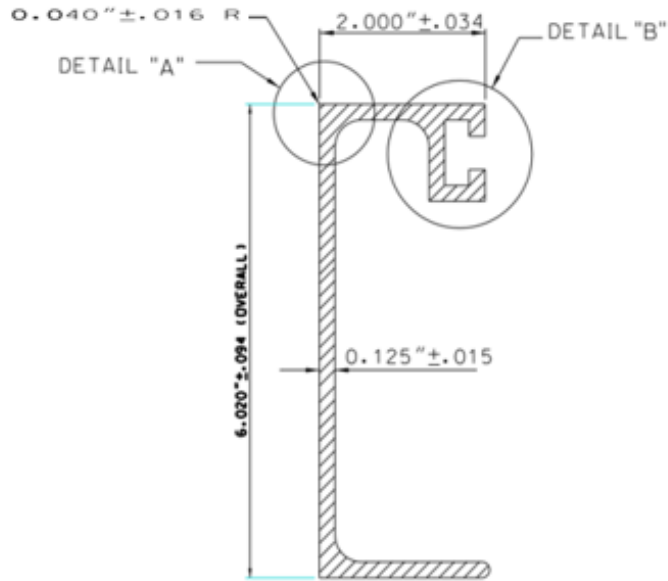
A Certificate of Compliance stating the material supplied conforms to the requirements of this specification must be supplied with each shipment. Certificate will be kept on file by the Department.

PACKAGING AND DELIVERY:

All aluminum panels shall be packaged back to back and face to face. Stacks of panels shall be securely banded with a minimum of four (4) bands spaced at regular intervals along their length. Bands shall be non-steel or coated to prevent corrosion. Packaged stack of panels should not exceed 2000 pounds.

Deliveries to be made by open bed truck for ease of forklift unloading. Panels shall be tarped during shipment.

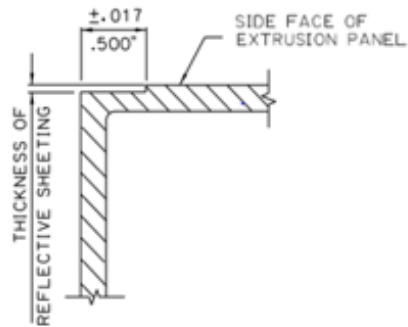
6" PANEL
Product ID 51822
SIDE VIEW DETAIL



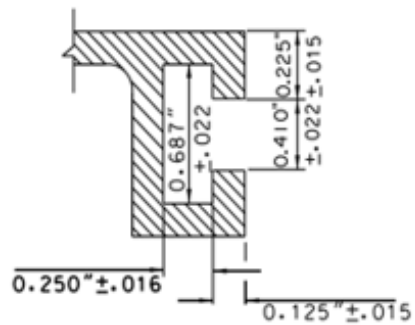
12" PANEL
Product ID 11946
SIDE VIEW DETAIL



DETAIL "A"



DETAIL "B"



6" & 12" PANEL
TOP VIEW

