

**LOUISIANA  
DEPARTMENT OF TRANSPORTATION AND DEVELOPMENT  
SPECIFICATIONS**

**EXTRUDED SIGN PANELS**

**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 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 Figure 1. The panel length shall be  $24' \pm 1/16"$ . The panels shall be free from grease, dirt or loose phosphate coating. All burrs shall be removed from the edges.

**MATERIAL CERTIFICATION:** The low vendor may be required to provide certification from an independent test laboratory that all materials meet the requirements of this specification. The successful vendor shall provide certification with each shipment. Certification will be kept on file by the Department.

**PACKAGING AND DELIVERY:**

All aluminum panels shall be packaged back to back and face to face. A layer of styrofoam shall protect panel faces. Stacks of panels to be securely banded with a minimum of four (4) bands spaced at regular intervals along their length. 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.

