

**ATTACHMENT B – SPECIFICATIONS**  
**RFx 3000006126 – ALUMINUM FOR DOC/PE**

**GENERAL SPECIFICATIONS:**

- A. Coils of aluminum substrate shall be wound to a nominal weight of 2,000 lbs. The coils shall have 18” to 20” inside diameter cores with an O.D. of 48” to 58” and shall be packaged on individual skids with a total weight of not more than 2,000 lbs. Not more than 10% undersized in weight will be accepted.
- B. Coils shall be packaged on a pallet. They shall be packaged and wrapped with reinforced waterproof paper (no tar paper) sufficiently to insure protection against environmental hazards. Pallets should allow 4” clearance for pallet truck and have 4” x 4” parallel runners at 28”. Pallet coils may be double stacked for shipping and storage.
- C. Each coil shall be securely banded around and through the eye of the coil to prevent telescoping.
- D. Coils shall be free from edge damage caused by cable marks, forklifts, dull cutting dies, rough separator discs, or other causes that result in rough, wavy, or damaged edges. Coils shall be coiled straight and fairly tight with no more than 1/16” interweave.
- E. Printed on a tag attached to each or on a tape used to tie the coil, shall be the name of the producer that performed final processing or finishing operation prior to making the product along with the applicable lot number and net weight of the coil.

Conversion coated aluminum for multi-year motor vehicle license plates:

Purpose & Scope:

It is the purpose of these specifications to define a conversion coated aluminum substrate material suitable in the manufacture of reflectorized multi-year motor vehicle license plates.

A. Alloy Temper	8112-H111, 7069-H111, or 3105-H21
B. Thickness	.027 (+/- .0015”)
C. Width (standard size)	12-1/8” + 1/32” – 0
D. Ultimate Strength	17.000 to 23.000 KSI
E. Minimum Yield Strength	11.500 KSI
F. Elongation of 2” Standard Specimen	Minimum 16% (20% nominal)

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- G. Quality To withstand embossing with all-steel dies  
At 3/32” height without breaking, cutting or  
Appreciable plate warping.
- H. Front surface finish and backside  
Preparation Coating: sheeting to be treated with a light,  
tightly adherent, chromate conversion  
coating or chrome free coating.  
\*Approved & certified by state’s sheeting  
Supplier\* (see below)  
Applied in accordance with ASTM B-449  
for chromate conversation coating or Betz  
Dearborn Permatreat 1021 B for  
chrome-free conversion, and free of any  
powdery residue, oil, or other foreign  
material that may affect adhesion or  
reflective sheeting. Chromate coating  
weight shall be 10 to 35 mg/sq ft.  
Chrome-free conversion coating weight will  
be 8 to 12 mg/sq ft with a median of 10  
mg/sq ft. as optimum.

Estimated shelf on all above: 6 months

\*If bidding aluminum with a chrome-free conversion coating, the successful bidder must supply a letter from 3M (the current sheeting supplier), stating that their aluminum will work with 3M’s sheeting.

If bidding aluminum with a chromate conversion coating, then no further documentation will be required.

Vendor is to state coating type:

\_\_\_\_\_ Chrome-Free Conversion Coating  
\_\_\_\_\_ Chromate Conversion Coating

**SHIPPING:**

- A. Shipment must arrive by open flatbed trailer for side off-loading by fork truck.
- B. Buyer to unload at destination.

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C. Buyer to be notified at least 24 hours prior to arrival of shipments. Deliveries accepted Monday through Friday 8:00 a.m. to 2:00 p.m. except holidays. Contact Prison Enterprises Tag Plant at (225) 655-4411.

**PACKAGING:**

Packing slip/invoice must accompany each shipment. Items are to be packed so as not to be damaged in any way. Agency will not accept damaged material.

**PACKAGE MARKINGS:** Packages must be marked with the brand and number of the product and such other information as sizes, types, quantity, use instruction, etc. which helps the end user in using the product correctly.

The purchasing agency reserves the right to inspect and test the delivered merchandise for compliance with the bid specifications. If merchandise fails to meet the specifications, the cost of test and inspection will be paid by the contractor. If the merchandise is in compliance, cost of all tests will be paid by the using agency.