

**LOUISIANA
DEPARTMENT OF TRANSPORTATION AND DEVELOPMENT
SPECIFICATIONS**

**DOTD NON- REFLECTIVE SHEETING, SIGN ENAMELS, PAINTS,
SILK SCREEN PASTE AND OVERLAY FILM**

1.) NON-REFLECTIVE SHEETING.

a) General Requirements:

Non-reflective sheeting film shall consist of an extensible, pigmented, weather-resistant plastic film. Face side of film shall be supported and protected by a paper liner which is readily removable after application without the necessity of soaking in water or other solvents. Colors shall be matched visually and be within the limits shown in Table 11 of ASTM D 4956.

b) Adhesive Requirements:

Sheeting shall have a pre-coated pressure sensitive adhesive backing or a tack-free heat-activated adhesive backing, either of which may be applied without additional coats on either sheeting or application surface. Adhesive shall comply with ASTM D 4956, Class 1 (pressure sensitive).

c) Physical Characteristics:

The film shall be readily cut by normal fabricating methods without cracking, checking or flaking. Applied film shall be free from ragged edges, cracks and blisters. The material shall have demonstrated its ability to withstand normal weathering without checking, cracking or excessive color loss.

2.) SIGN ENAMELS AND PAINTS.

a) General Requirements:

These shall be applied in accordance with the sheeting manufacturer's recommendations. Final appearance as well as materials used shall be subject to approval.

3.) SILK SCREEN PASTE.

a) General Requirements:

1. Constituents used in manufacture of silk screen paste shall meet approval of the engineer. Silk screen paste shall be mixed at the factory, well ground to a uniform consistency and smooth texture, and shall be free from water and other foreign matter. It shall dry within 18 hours to a film that does not run, streak, or sag. Paste which has livered, hardened or thickened in the container, or in which pigment has settled out so that it cannot be readily broken up with a paddle to a uniform usable consistency, will be rejected. Paste and thinner shall be used in accordance with the sheeting manufacturer's recommendations.
2. Paste shall have proper pigmentation and consistency for use in silk screen equipment. The material shall produce the desired color and the same retro-reflectivity values as required for reflective sheeting of the same type and color when applied on reflective sheeting background. Paste shall meet the quality and test requirements for appearance, coarse particles, and moisture and water resistance as specified for sign paints.

4.) OVERLAY FILM.

a) General Requirements:

Transparent electronic cuttable overlay film shall produce the desired color and the same reflectivity values as required for reflective sheeting of the same type and color when applied on reflective sheeting background.

5.) PACKING AND MARKING.

Non-Reflective Sheeting and Overlay Film shall be packaged in suitable containers to which it will not adhere during shipment and storage. Each container label shall designate the color, manufacturer's name, batch number and the date of manufacture. Each batch manufactured shall have its own separate number. Application instructions shall be provided with each batch of material. Silk Screen Paste shall also be packaged in a suitable container and shall be identified in the same method as stated above. Application instructions shall also accompany each batch of material.

6.) CERTIFICATION.

The manufacturer shall provide a Certificate of Compliance indicating the material conforms to these requirements with each shipment of material. Certificate will be kept on file by the Department.