

By: 

**LOUISIANA
DEPARTMENT OF TRANSPORTATION AND DEVELOPMENT
SPECIFICATIONS**

**NON-REFLECTIVE SHEETING, ELECTRONIC CUTTABLE OVERLAY FILM, SILK
SCREEN PASTE AND THINNER**

DESCRIPTION:

This specification covers the minimum requirements for non-reflective sheeting, electronic cuttable overlay film, silk screen pastes (inks) and paste thinner that will be used in the fabrication of traffic control signs.

NON-REFLECTIVE SHEETING FILM

Product ID 12096 – 12104, 50761, & 50762

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.

ADHESIVE:

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

PHYSICAL CHARACTERISTICS:

When cut by normal fabricating methods, film shall not crack, check or flake. Film must be able to withstand normal weathering without cracking, checking or having excessive color loss.

**ELECTRONIC CUTTABLE OVERLAY FILM
(EC FILM)**

Product ID 52930 - 52939

REQUIREMENTS:

Electronic cuttable overlay film (EC film) shall be transparent with a transparent pressure-sensitive adhesive. Adhesive shall comply with ASTM D 4956, Class 1 (pressure sensitive). For application purposes, the overlay film must be of the same brand and compatible with the retroreflective

sheeting. The overlay film, after application, must not alter the retroreflectivity values of the sheeting.

SILK SCREEN PASTES AND THINNERS

Product ID 12222 - 12228

REQUIREMENTS:

Pastes (inks) shall have proper pigmentation and consistency for use in silk screen equipment. They must be mixed at the factory, well ground to a uniform consistency with a smooth texture, and must be free from water and other foreign matter.

Pastes shall dry, within eighteen (18) hours of application, to a film that does not run, streak, or sag. For application purposes, the pastes must be of the same brand and compatible with the retroreflective sheeting. The material, after application, shall not alter the retroreflectivity values of the sheeting.

DOCUMENTATION:

Application instructions shall be provided with each batch of material.

CERTIFICATION:

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

PACKING AND MARKING:

Non-reflective Sheeting and Overlay Film shall be supplied on rolls. Each roll shall be individually packaged in containers. Containers must prevent the material from adhering to it during shipment and storage.

Each container shall be labeled with the following information:

- Manufacturer's Material/Product No.
- Sheeting and/or Overlay Film Color
- Size of the Roll
- Manufacturer's Name
- Batch Number
 - Each batch shall have its own identification number.
- Date of Manufacture

Silk Screen Pastes and Thinners shall be packaged in gallon size containers that will prevent corrosion and leakage.

Each container shall be labeled with the following information:

- Manufacturer's Material/Product No./Description
- Paste (Ink) Color (as applicable)
- Manufacturer's Name
- Batch Number
 - Each batch shall have its own identification number.
- Date of Manufacture