

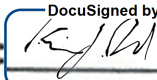
Product IDs 51822 & 11946

Approved for
Maintenance Division

MS Spec. 154-001

Rev. 10/1/26

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By: 
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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.

General Requirements:

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

Material:

Aluminum panels shall comply with ASTM B221, Alloy 6063-T6. Aluminum shall have a chemical conversion coating meeting either ASTM B449 Class II for chromate conversion coatings on aluminum or ASTM B921 Class II for non-hexavalent chromium conversion coatings.

After fabrication and coating application, the finished panel shall have a flatness equal to or less than 0.031 inch per foot of length and 0.004 inch per inch of width.

Detailed Requirements:

The panels shall conform to the dimensions shown in the “**Side View Details**” drawings for each Product ID including “**Detail A**” and “**Detail B**”. Panels shall be supplied in 36’ lengths; panel widths shall be as indicated by the Product ID.

All panels shall come complete with pre-drilled assembly slots beginning 6” from the edge then every 12” as shown in the “**Top View of Assembly Slots**” drawing.

Documentation:

Each shipment shall be supplied with the following documentation to indicate compliance with this specification:

1. Aluminum Material Certification

- Mill Test Report or Mill Test Certificate indicating conformance with ASTM B221 for Aluminum Alloy 6063-T6. At a minimum, the report/certificate shall include:
 - Alloy and Temper
 - Manufacturer/Mill Name
 - Applicable ASTM Specification
 - Chemical Composition
 - Tensile Strength
 - Yield Strength
 - Elongation
 - Heat/Lot/Batch Number and/or Production Identification to establish traceability to the material supplied
 - Date of Testing/Certification

2. Coating Certification

- Coating Test Report or Certification Report from the manufacturer or a qualified testing laboratory demonstrating compliance with ASTM B449, Class II, or ASTM B921, Class II, as applicable. Documentation shall include, at a minimum, the following:
 - Applicable ASTM Specification and Class II Designation
 - Coating Material/Process Application
 - Material Tested
 - Test Methods and Results
 - Coating Lot/Batch Number and/or Production Identification to establish traceability to the material supplied
 - Date of Testing/Certification
 - Manufacturer/Testing Laboratory

All certificates and test results supplied will be kept on file by the Department.

Packaging:

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.

Delivery:

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

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Acceptance:

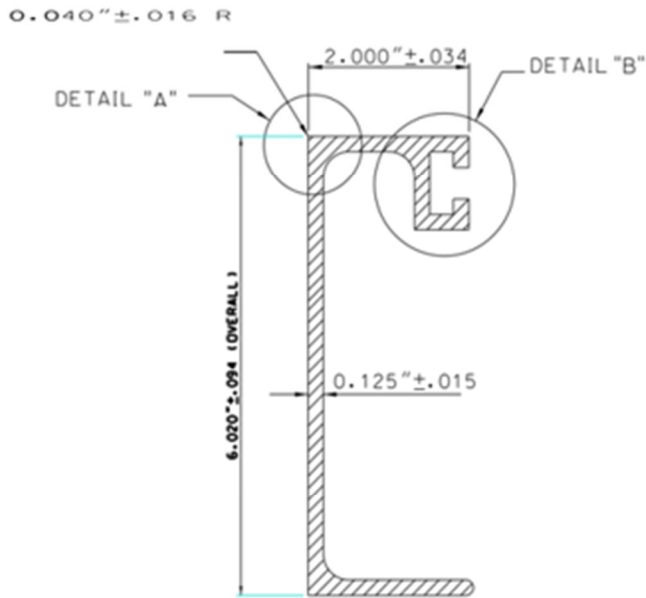
Prior to acceptance, each shipment shall be inspected by DOTD to review adherence to the specifications. Any material that fails to conform to any part of this specification shall be rejected. Rejected material must be removed at no cost to the Department.

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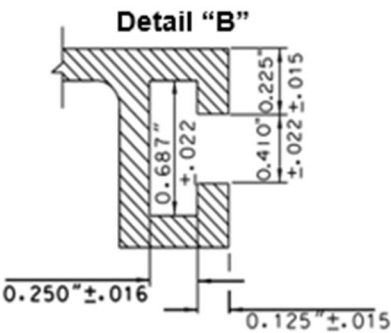
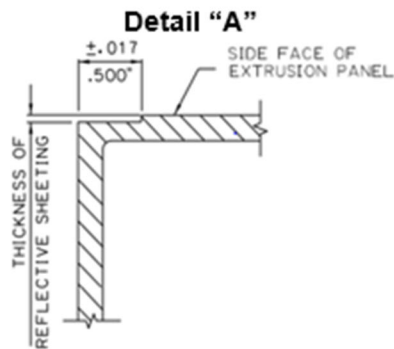
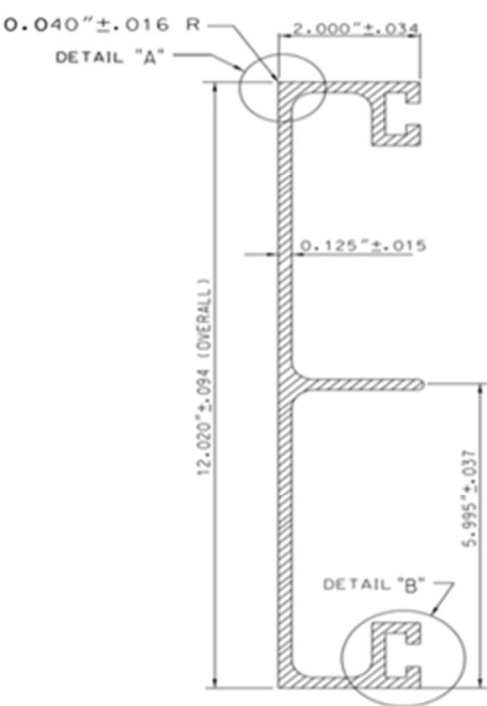
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Side View Details

Product ID 51822 - 6" Panel



Product ID 11946 - 12" Panel



Top View of Assembly Slots

