

Evaluation Table

PEP ID:	XXXXX
Manufacturer:	Name of Manufacturer
Product Name:	Name of Product

606, 607, 608 Signing

608 Sign Panels (Extruded Aluminum)(with Direct-Applied Characters)

ADOT Standard Specification: 608

ADOT Stored Specification: 608PANEL

ADOT Standard Drawing: S series drawings, as applicable

Responsible Section: Traffic Group

Material Property	Specification/ Test Method	Requirement	Results	Pass/ Fail
Sheeting Warranty	608-2.01	Signs shall be fabricated in accordance with the recommendations established by the manufacturer of the sign sheeting. All processes and materials used to make a sign shall in no way impact the performance, uniform appearance (day and night), or durability of the sheeting, or invalidate the sign sheeting manufacturers' warranty.		
Background / Legend	608-2.01	All sheeting used for background and legend shall be from the same manufacturer.		
Letter Orientation	608-2.01	All text and numerals shall all be installed at the same orientation: either zero degrees or 90 degrees.		
Fabrication	608-2.02	Panels shall be fabricated from 12-inch wide aluminum extrusions formed from Aluminum Alloy 6063-T6 conforming to the requirements of ASTM B221.		
Panel Surfaces, preparation	608-2.02	Panel surfaces to be covered with retroreflective sheeting shall be prepared in accordance with the recommendations of the sheeting manufacturer.		
Panel Surfaces, etching	608-2.02	Panel surfaces not covered with sheeting shall be etched in accordance with the recommendations of the extrusion manufacturer to reduce glare from reflected sunlight.		

Material Property	Specification/ Test Method	Requirement	Results	Pass/ Fail
Panel, preparation	608-2.02	After all fabrication has been completed, including the cutting and punching of holes, except holes for demountable letters, numerals, symbols, and borders, the aluminum extrusions shall be degreased and the retroreflective sheeting shall be applied.		
Length Tolerance	608-2.02	Aluminum extrusions shall be flat with 1/4 inch of tolerance allowed in an 8-foot length, with proportionally greater tolerances permitted on lengths greater than 8 feet.		
Flatness Tolerance	608-2.02	Flatness tolerance across the face of each extrusion shall be 0.5 percent of the width.		
Assembly	608-2.02	Aluminum extrusions shall be bolted together on 12-inch centers with a maximum allowable gap of 1/32 inch between extrusions.		
Side Trim Molding	608-2.02	Each completed sign panel shall be provided with a side trim molding fabricated from extruded Aluminum Alloy 6063-T6 conforming to the requirements of ASTM B221.		
Side Trim Molding	608-2.02	The trim molding shall be fastened to each individual 12-inch aluminum extrusion with two 5/32-inch diameter self-plugging aluminum blind rivets, 2-1/2 inches from either edge.		
Side Trim Molding	608-2.02	The exposed surface of the side trim molding shall be treated by etching as recommended by the manufacturer to reduce glare from reflected sunlight.		
Hardware	608-2.02	Each completed sign panel shall be shipped with sufficient bolt clamps placed to install the panel on the sign posts as shown in the plans.		
Retroreflective sheeting, sign-making inks, and opaque films	608-2.07	Retroreflective sheeting, sign-making inks, and opaque films shall conform to the requirements of Section 1007 of the specifications. (attach corresponding 1007 evaluation table)		
Letters, Numerals, Symbols & Borders	608PANEL, Section 608-2.02	The letters, numerals, symbols, borders, and other features of the sign message shall be direct-applied, or demountable, and shall conform to the requirements of Subsection 608-2.08 or Subsection 608-2.09 of the specifications. (see below for Section 608-2.09 requirements, Screen-Printed, Direct-Applied, and Electronic-Cut Characters:)		

Complete below, as applicable				
Screen-Printed Characters	608-2.09	Screen-printed letters, numerals, arrows, symbols, and borders, shall be applied on the retroreflective sheeting background of the sign by direct or reverse screen process. Messages and borders of a color darker than the background shall be applied to the retroreflective sheeting by direct process. Messages and borders of a color lighter than the sign background shall be produced by the reverse screen process.		
Screen-Printed Characters	608-2.09	The screening shall be performed in a manner that results in a uniform color and tone, with sharply defined edges of legends and borders and without blemishes on the sign background that will affect intended use.		
Screen-Printed Characters	608-2.09	Signs, after screening, shall be air dried or baked in accordance with the manufacturer's recommendations to provide a smooth hard finish.		
Direct-Applied Characters	608-2.09	Direct-applied letters, numerals, symbols, borders, and other features of the sign message shall be cut from black opaque or retroreflective sheeting of the color specified and applied to the retroreflective sheeting of the sign background in accordance with the instructions of the manufacturer of the retroreflective sheeting.		
Direct-Applied Characters	608-2.09	Direct-applied legend may be moved vertically 1/2 inch to avoid placing only a small amount of material over the adjacent extruded panel.		
Direct-Applied Characters	608-2.09	The bottom of all characters for a line of legend shall line up within 1/8 of an inch.		
Electronic-Cut Characters	608-2.09	Electronic-cut characters shall be cut from translucent acrylic sheeting using computerized automated cutting processes.		