

Evaluation Table

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

606, 607, 608 Signing

608 Sign Panels (Flat Sheet Aluminum)(with Direct-Applied, Electronic-Cut, or Screen-Printed 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	608-2.03	Panels shall be fabricated from 0.125-inch thick 5052-H36, or 5052-H38 Aluminum Alloy conforming to the requirements of ASTM B209.		
Sheeting Prep and Application	608-2.03	Panel facing shall be prepared and covered with retroreflective sheeting in accordance with the recommendations of the sheeting manufacturer.		
Etching	608-2.03	All surfaces not covered shall be etched to reduce glare from reflected sunlight.		
Splicing	608-2.03	Splicing of retroreflective sheeting shall not be allowed on sign panels having a minimum dimension up to and including 4 feet.		
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)		

Last Modified: 10/17/2023

Material Property	Specification/ Test Method	Requirement	Results	Pass/ Fail
Messages	608PANEL, Section 608-2.03	Messages shall be reflectorized white or, if called for on the plans, opaque black, and shall be produced by either screen printing, direct-applying, or electronic cutting, as specified under Subsections 608-2.09 of the specifications.		
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.		

Material Property	Specification/ Test Method	Requirement	Results	Pass/ Fail
Warning, Marker, and Regulatory Sign Panels: Fabrication	608-2.04	Panels shall be fabricated in one piece from 0.125-inch thick 5052-H36, 5052-H38, or 6061-T6 Aluminum Alloy conforming to the requirements of ASTM B209.		
Warning, Marker, and Regulatory Sign Panels: Warning Signs	608-2.04	Warning signs shall be reflectorized with fluorescent yellow retroreflective sheeting.		
Warning, Marker, and Regulatory Sign Panels: Regulatory Signs	608-2.04	Regulatory signs shall be reflectorized with white retroreflective sheeting.		
Warning, Marker, and Regulatory Sign Panels: Reflectorized Red Signs	608-2.04	Reflectorized red signs shall be reflectorized with white retroreflective sheeting. The red color shall be produced by screen printing.		
Warning, Marker, and Regulatory Sign Panels: Regulatory Signs with Reflectorized Red Circles and Slashes	608-2.04	Regulatory signs with reflectorized red circles and slashes shall be reflectorized with white retroreflective sheeting. The red color shall be produced by screen printing.		
Warning, Marker, and Regulatory Sign Panels: Interstate Route Markers	608-2.04	Interstate route markers shall be cut to shape. The colors and legend shall be as shown on the plans and shall be reflectorized with white retroreflective sheeting. The Interstate route colors shall be screen-printed. The numerals may be screen-printed, electronic-cut, or direct-applied characters.		
Warning, Marker, and Regulatory Sign Panels: United States, State Route, and Cardinal Direction Markers	608-2.04	United States, State Route, and Cardinal Direction markers shall be reflectorized with white retroreflective sheeting unless otherwise shown on the plans.		
Route Shields, Type	608PANEL, Section 608-2.05	Route shields may be demountable or direct-applied.		

Material Property	Specification/ Test Method	Requirement	Results	Pass/ Fail
Route Shields, Demountable	608-2.05	Demountable route shields shall be cut to shape and shall consist of 0.063-inch thick, 5052-H36, or 5052-H38 Aluminum Alloy conforming to the requirements of ASTM B209. The aluminum shall be degreased and etched in accordance with the recommendations of the sheeting manufacturer. Retroreflective sheeting shall be white. Route shields shall be attached to the sign panel with self-plugging aluminum blind rivets.		
Exit Only Panels, Type	608PANEL, Section 608-2.06	EXIT ONLY panels may be demountable or direct-applied.		
Exit Only Panels, Demountable, Rivets	608-2.06	Demountable EXIT ONLY panels shall be attached to the sign panel with self-plugging aluminum blind rivets.		
Exit Only Panels, Demountable, Fabrication	608-2.06	Demountable EXIT ONLY panels shall be fabricated from 0.063-inch thick, 5052-H36 or 5052-H38 Aluminum Alloy conforming to the requirements of ASTM B209 with fluorescent yellow retroreflective sheeting adhered to the face side.		
Exit Only Panels, Demountable, Prep and Etching	608-2.06	The aluminum shall be degreased and etched in accordance with the recommendations of the sheeting manufacturer.		