



#### METAL AND METAL TREATMENT

- A. METAL - SIGN BACKING SHALL BE FLAT, UNPAINTED ALUMINUM IN 61S-T6 ALLOY, SIGNS ARE DESIGNED FOR OVERLAY AND SHALL HAVE A MINIMUM GAUGE OF .080.
- B. METAL TREATMENT
  1. DEGREASING- REQUIRED ON ALUMINUM SHEETING AND EXTRUSIONS:
    - A. VAPOR DEGREASING BY TOTAL IMMERSION OF THE SIGN IN A SATURATED VAPOR OF TRICHLOROETHYLENE OR PERCHLOROETHYLENE. TRADEMARK PRINTING SHOULD BE REMOVED WITH LACQUER THINNER OR CONTROLLED ALKALINE CLEANING SYSTEM.
    - B. ALKALINE DEGREASING- SIGNS SHALL BE EMMERSED IN A TANK CONTAINING ALKALINE SOLUTIONS, CONTROLLED AND TITRATED TO THE SOLUTION MANUFACTURER'S SPECIFICATION. IMMERSE TIME SHALL DEPEND UPON THE AMOUNT OF SOIL PRESENT AND THE GAUGE OF THE METAL.
  2. ETCHING- REQUIRED ONLY ON ALUMINUM SHEETING:
    - A. ACID ETCH- ETCH WILL IN A 6-8% PHOSPHORIC ACID SOLUTION AT 100°F AND RINSE THOROUGHLY WITH RUNNING COLD WATER. (MAY BE FOLLOWED BY HOT WATER TANK RINSE.)
  3. DRYING- DRY PANELS BY USE OF A FORCED HOT AIR DRIER.

RAMSEY COUNTY HIGHWAY DEPARTMENT  
TRAFFIC DIVISION

#### STREET SIGN BLANKS & SPECIFICATIONS

PREPARED BY: PLK

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