



SPECIFICATION FOR ALUMINUM SIGN BLANKS

October 10, 2025

1. DESCRIPTION

This specification covers the requirements and processing of flat sheet aluminum sign blanks to which a chemical conversion treatment coating has been applied. Size, shape, thickness, and weight shall be in accordance with the attached drawings.

2. MATERIALS

2.1 Aluminum. Blanks shall conform to ASTM-B209; Alloy 5052-H38 or 6061-T6. The manufacturer shall on the bid document indicate the specific ASTM Aluminum Alloy on which the bid is based and from which the aluminum sign blanks will be fabricated and furnished. Failure to select one or more of the Aluminum Alloys specified above and to indicate the selected alloy(s) on the bid document shall be cause for rejection of the vendor's bid.

2.2 Chemical Conversion Coating. The chemical conversion coating to be employed in the preparation of aluminum sign blanks shall conform to ASTM B 921 or ASTM B 449, and the coating material shall be included on the QPL-81706-15 Amendment 3 list or subsequent editions thereto. The chemical conversion treatment shall be completed after the blanks have been fabricated, including the punching of all holes.

3. FABRICATION

3.1 General. Blanks shall be a continuous section of the length, width and thickness, with required mounting holes as shown on the drawings. They shall conform to commercial tolerances with regard to length, width, thickness, flatness, hole spacing, hole diameter, corners and corner radii in accordance to ANSI-H35-2 (Tables 2.1, 3.1, 3.2, 3.3, 7.1, and 7.6 through 7.14). Blanks shall be free of buckles, dents and burrs prior to the application of the chemical conversion treatment. All shearing shall be from the same side of the blanks, the sheared side shall be placed and packaged face up.

3.2 Warp. When the aluminum sign blank is resting on a flat, level surface with either side down, all parts of the underside of the sign blank shall be within 1/4-inch of the flat surface without any external pressure.

4. CHEMICAL CONVERSION TREATMENT

Aluminum sign blanks must be conversion coated to comply with the requirements ASTM B 921 or ASTM B 449.

5. INSPECTION

5.1 During Fabrication. The contractor shall provide sufficient testing and quality control throughout fabrication to ensure an acceptable product. The Engineer or the Engineer's accredited representative shall have access to all parts of the mill and shop during the manufacture and fabrication of the sign blanks.

5.2 After Receipt. Once the material has been received, it may be subject to random testing to ensure compliance with all requirements. If any test samples do not conform to the requirements of this specification, the entire order may be returned at vendor expense.

6. PACKAGING

Packaging shall consist of the following:

(a) Blanks shall be furnished on skids, packed or crated to protect against damage, according to blank size. Skids shall have 4"x 4" runners, with not less than 19 inches between runners. Blanks over 10, 12, and 16 ft. in length packaged together on the same skid shall have 4"x 4" runners between each vertical size. Steel banding shall be used for binding the blanks.

(b) Total weight of the loaded skid shall not exceed 2,000 pounds. In addition, the maximum number of blanks on a pallet shall be as follows, based on the longest dimension of the blank:

<u>Long Dimension</u>	<u>No. on Pallet*</u>
30" or less	250
36"	150
48"	100
60"	50

*One pallet for any type of blank may have less than this quantity to account for orders other than a multiple of this quantity.

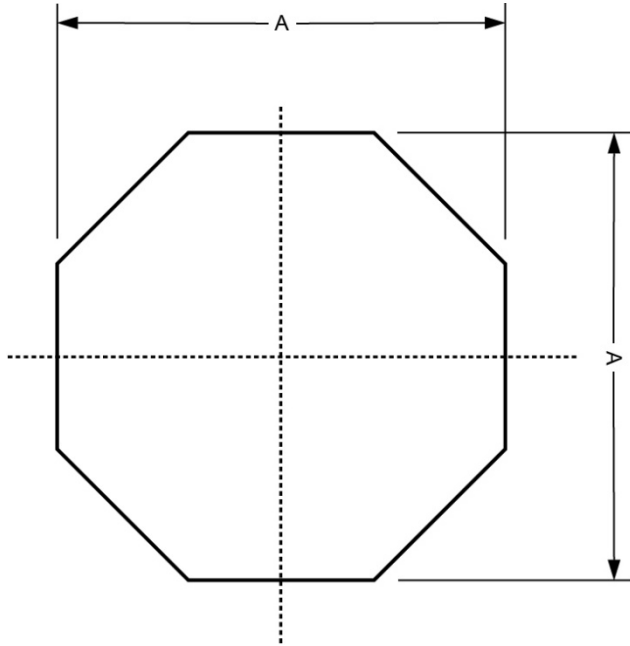
(c) All delivery trucks shall be of the open body type. Skid runners shall be perpendicular to the edge of the truck, in order that the skids may be unloaded from the side with a forklift. Blanks with a dimension of 120 inches or greater may be stacked with spacer blocks in lieu of pallets.

(d) Packaging and separating materials shall be free of wax, ink, grease or any other substance which would damage the blank or conversion coating.

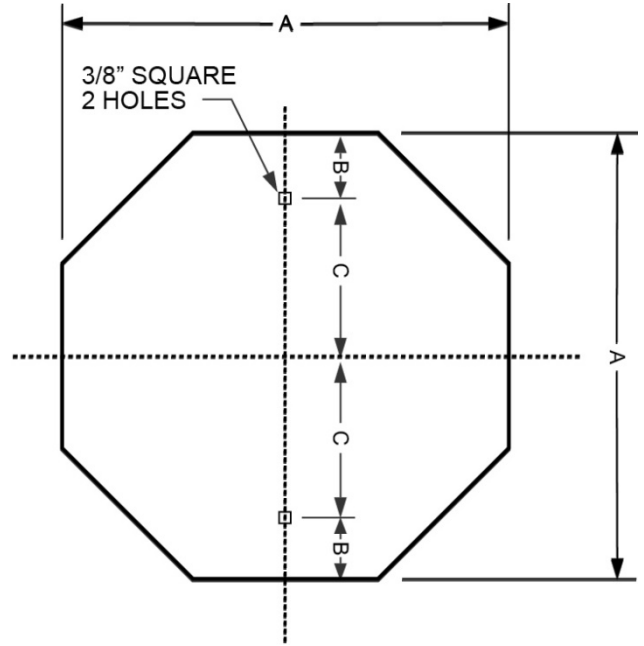
(e) Packaged blanks shall be properly identified on all four edges of the carton or crate by: (1) blank standard number; and (2) number of units contained therein.

(f) All blanks shall be "stagger-stacked" in groups of 10 blanks for inventory purposes. (The groups should be offset about one-half to one inch from each other with odd groups aligned above each other and even groups above each other.)

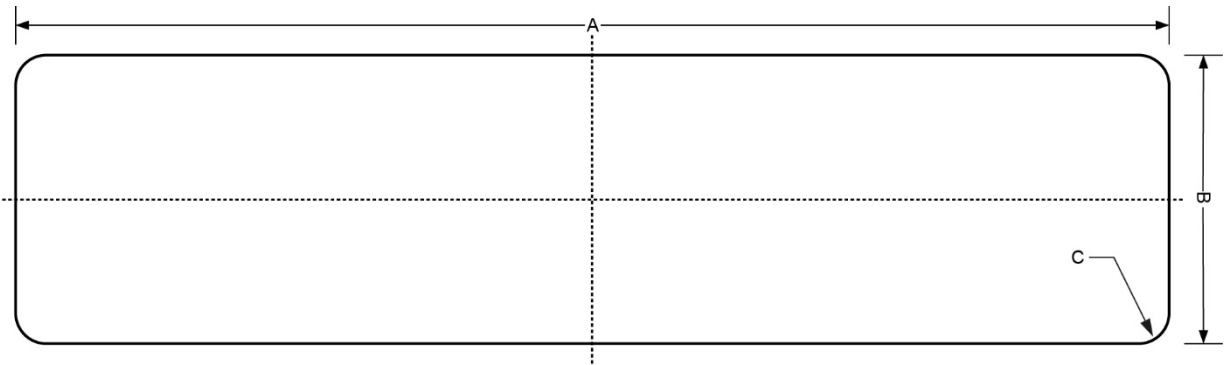
PCI – Specifications for Sign Blanks



BLANK STD	A	THICK.
330534	24	.080
330542	30	.080

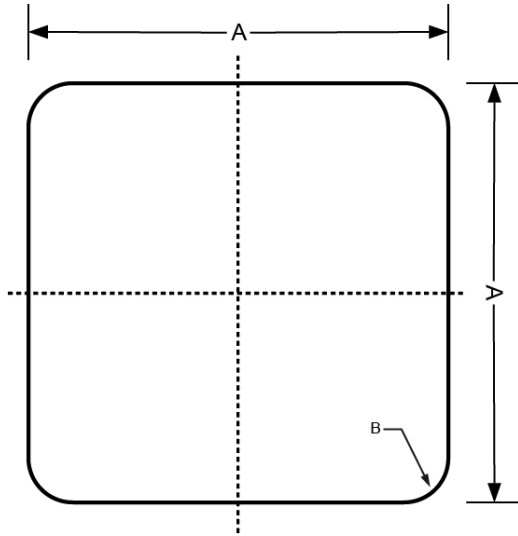


BLANK STD.	A	B	C	THICK.
330535	24	3	9	.080
330543	30	3	12	.080

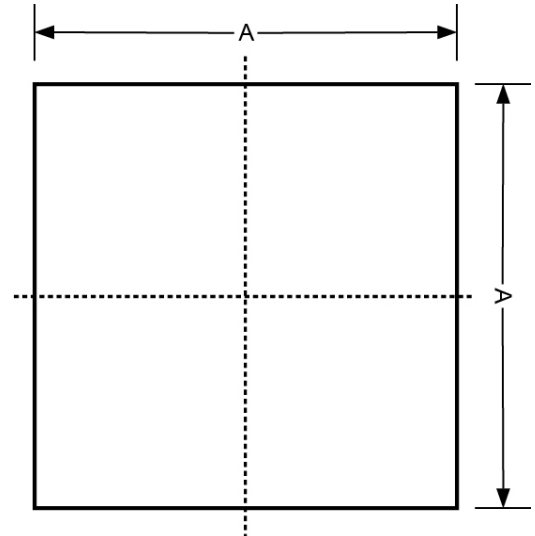


BLANK STD.	A	B	C	THICK.
330525	24	6	1.5	.063

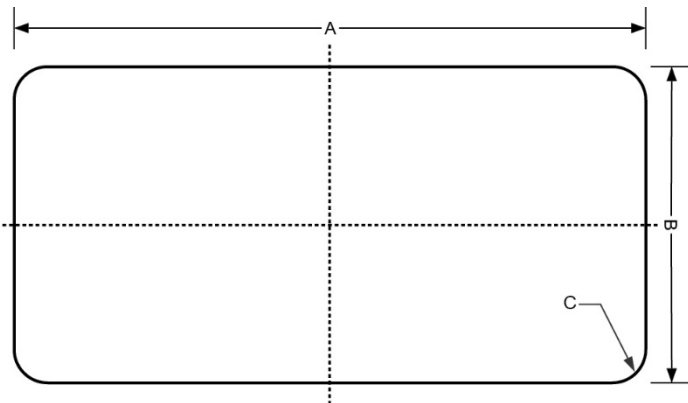
PCI – Specifications for Sign Blanks



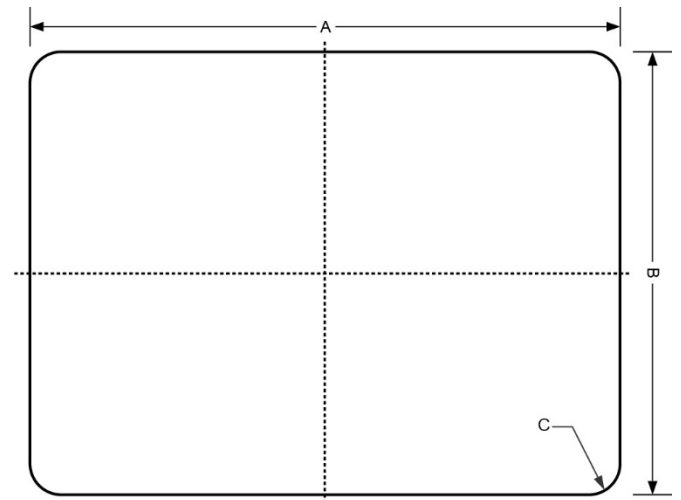
BLANK STD.	A	B	THICK.
348018	24	1.5	.063
330529	12	1	.080
330540	24	1.5	.080
330546	30	1.5	.080
330551	36	1.5	.080
330555	48	1.5	.080



BLANK STD.	A	THICK.
330556	48	.080

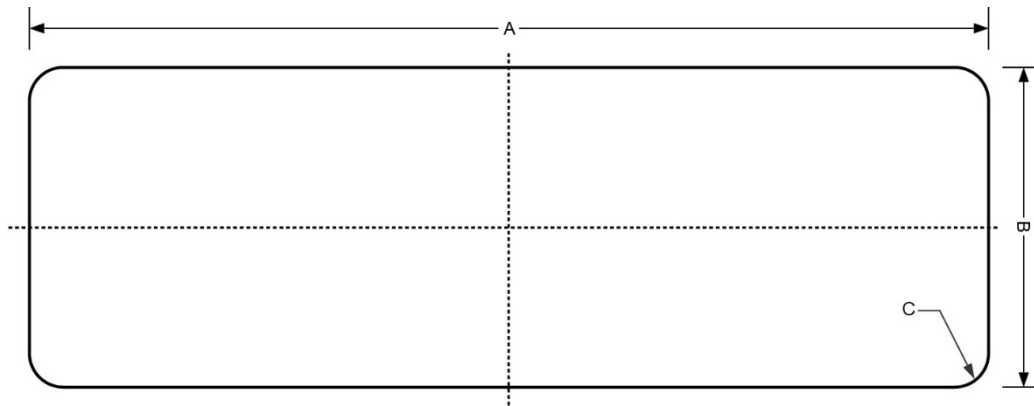


BLANK STD.	A	B	C	THICK.
330536	24	12	1.5	.080
330554	48	24	1.5	.080
330563	72	36	1.5	.080

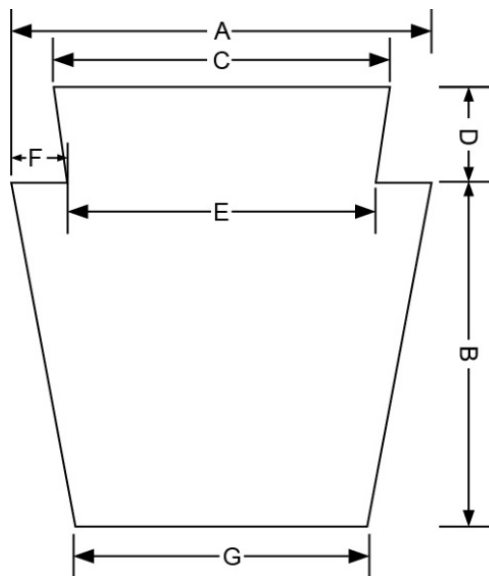


BLANK STD.	A	B	C	THICK.
330538	24	18	1.5	.080
330532	18	12	1.5	.080
330545	30	24	1.5	.080

PCI – Specifications for Sign Blanks

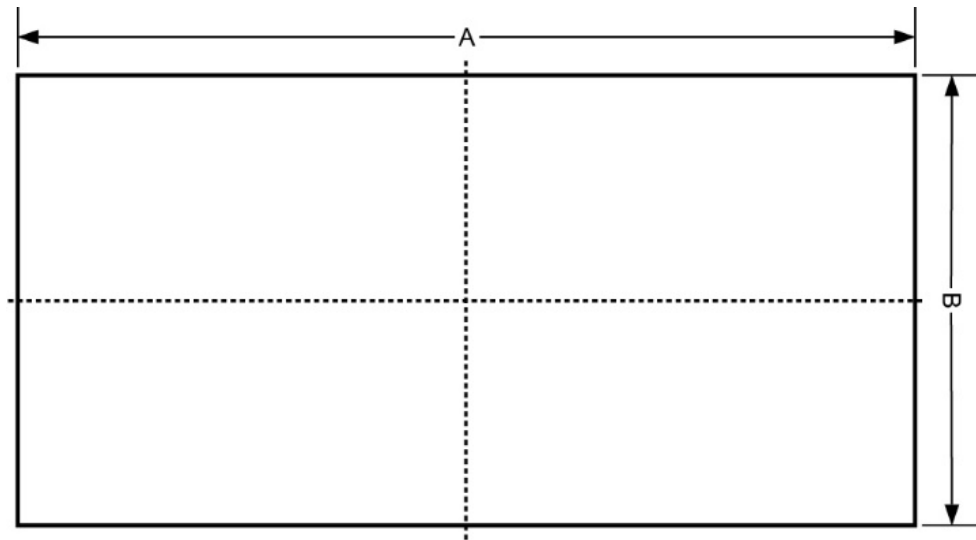


BLANK STD.	A	B	C	THICK.
330548	36	12	1.5	.080
330561	72	24	1.5	.080

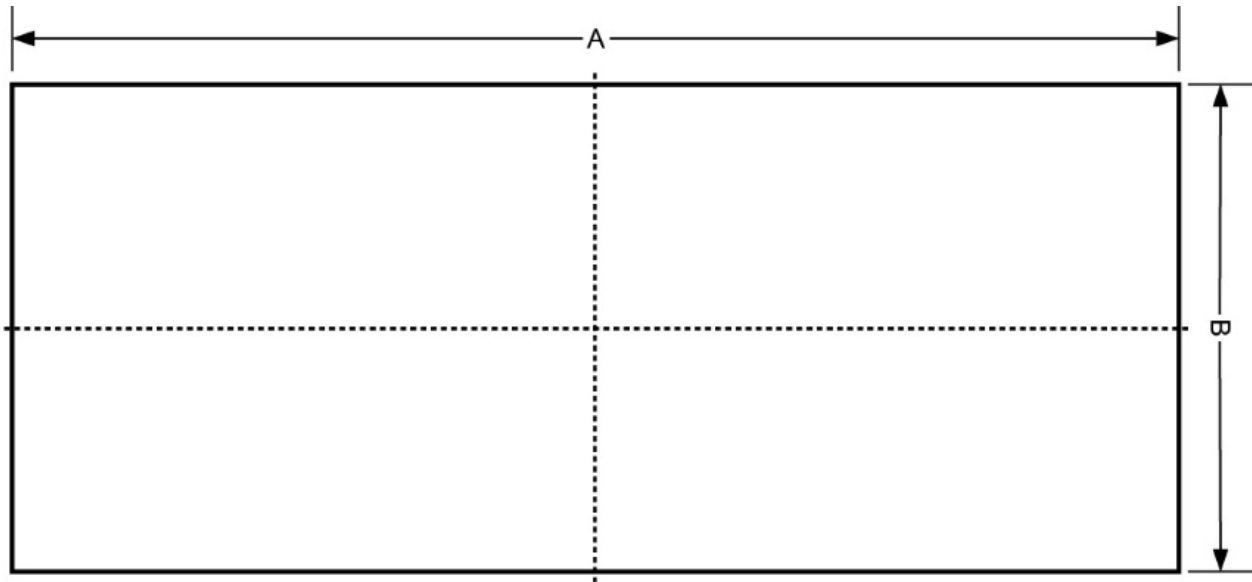


BLANK STD.	A	B	C	D	E	F	G	THICK.
334083	48	48	35	8	32	8	35	.080
	24	24	19	5.625	15.625	4.1875	18.5	.080

PCI – Specifications for Full Sheets



BLANK STD.	A	B	THICK.
341518	96	48	.032
341520	96	48	.063
330565	96	48	.080
330517	96	48	.100
341525	96	48	.125
341527	96	48	.040



BLANK STD.	A	B	THICK.
341522	14	60	.080