ALUMINUM SIGN BLANKS

(Larger than 18" x 18")

Metal Specification:

Aluminum alloy: Sheet 6061-T6 Gauge: .080" thickness

Manufacturer (fabricator) shall insure the aluminum is free of all corrision, white rust and dirt prior to application.

Dimension and mounting holes shall be in accordance with plans and specifications furnished by the Boston Traffic and Parking Department.

Metal Treatment:

Degrease

a. Vapor: Degreasing by total immersion of sign in a vapor of trichloroethylene or perchloroeythylene. Trademark printing should be removed with lacquer thinner or controlled alkaline cleaning material.

b. Alkaline: Degreasing by immersing signs in a tank containing alkaline solutions controlled and titrated to the solutions manufacturing specifications. Immersion time shall depend upon the amount of soil present

Etch

a. Acid Etch: Etch well in a 6-8% phosphoric acid solution at 100 degrees F. Rinse thoroughly with running cold water and may be followed by a hot water tank rinse.

b. Alkaline Etch: Etch well the pre-cleaned aluminum surface in an alkaline etching material that is controlled by titration, use time, temperature, and concentration specified by the solution manufacter. Rinse thoroughly. Remove smut with an acidic, chromium compound type solution as specified by the solution manufacturer and then rinse thoroughly.

Dry

Dry drying may be accomplished by forced hot air.
Keep metal sheets separated.

Alodize

All signs plates must then be alodized.

Date: July 10, 1972 Revised Feb. 22, 1982

ALUMINUM SIGN BLANKS
(18"x 18" or Smaller)

Metal Specification:

Aluminum alloy: Sheet 5052 Gauge: .080" thickness

Manufacturer (fabricator) shall insure the aluminum is free of all corrision, white rust and dirt prior to application.

Dimension and mounting holes shall be in accordance with plans and specifications furnished by the Boston Traffic and Parking Department.

Metal Treatment:

Degrease

a. Vapor: Degreasing by total immersion of sign in a vapor of trichloroethylene or perchloroeythylene. Trademark printing should be removed with lacquer thinner or controlled alkaline cleaning material.

b. Alkaline: Degreasing by immersing signs in a tank containing alkaline solutions controlled and titrated to the solutions manufacturing specifications. Immersion time shall depend upon the amount of soil present

Etch

a. Acid Etch: Etch well in a 6-8% phosphoric acid solution at 100 degrees F. Rinse thoroughly with running cold water and may be followed by a hot water tank rinse.

b. Alkaline Etch: Etch well the pre-cleaned aluminum surface in an alkaline etching material that is controlled by titration, use time, temperature, and concentration specified by the solution manufacter. Rinse thoroughly. Remove smut with an acidic, chromium compound type solution as specified by the solution manufacturer and then rinse thoroughly.

Dry

Dry drying may be accomplished by forced hot air.
Keep metal sheets separated.

Alodize

All signs plates must then be alodized.

Date: July 10, 1972 Revised Feb. 22, 1982