



### SIGN COLOURS

	<b>SIGN BOARD BACKGROUND PARKS CANADA HERITAGE GREEN</b> PANTONE COLOUR MATCHING SYSTEM NO.553 SOLID COATED PANTONE PMS 553 C CMYK 60/0/55/80 RGB 43/70/53 HEXIDECIMAL #214332
	<b>SIGN BOARD TEXT AND BACKGROUND WHITE</b> CMYK 0/0/0/0 RGB 255/255/255 HEXIDECIMAL #FFFFFF
	<b>SIGN BOARD SYMBOL YELLOW</b> PANTONE COLOUR MATCHING SYSTEM NO.130 SOLID COATED PANTONE PMS 130 C CMYK 0/30/100/0 RGB 236/183/49
	<b>LOGO FLAG RED</b> PANTONE COLOUR MATCHING SYSTEM NO.032 SOLID COATED PANTONE PMS 032 C CMYK 0/100/100/0 RGB 213/43/30 HEXIDECIMAL #338BEE
	<b>LOGO TEXT BLACK</b> CMYK 0/0/0/100 RGB 0/0/0 HEXIDECIMAL #000000

### SIGN FONTS AND TEXT HEIGHTS

PARKS CANADA LOGO AND OTHER STANDARD PCA SYMBOLS - DIGITAL IMAGE FILES TO BE PROVIDED TO FABRICATOR BY PARKS CANADA

+/-3MM MUST BE THE ALLOWABLE FABRICATION TOLERANCE FOR ALL LETTERS AND SYMBOLS

MESSAGE TEXT TO BE HELVETICA NEUE 75

SCALE = 1:8

## SIGNS MATERIALS AND FABRICATION SPECIFICATIONS

### 1.0 MATERIALS SPECIFICATIONS

- 1.1 ALL MATERIALS MUST BE OF NEW STOCK AND FREE FROM DEFECTS.
- 1.2 SIGNS MUST CONSIST OF ALUMINIUM FLAT SHEETS, EXTRUDED PANELS OR ALUMINIUM COMPOSITE PANELS RETRO-REFLECTORIZED ON THE FACE SIDE WITH ALL LETTERS, NUMERALS, SYMBOLS, BORDERS AND CORNERS AS SHOWN ON THE PLANS.
- 1.3 SIGNS EQUAL TO OR GREATER IN WIDTH THAN SIX FEET ARE CONSIDERED STRUCTURAL (ST) AND MUST BE FABRICATED ON EXTRUDED PANELS OR ALUMINIUM COMPOSITE PANELS. SIGNS LESS THAN SIX FEET IN WIDTH WILL BE CONSIDERED NON-STRUCTURAL (NS) SIGNS TO BE FABRICATED WITH ALUMINIUM FLAT SHEET OR FOAM CORE COMPOSITE. ANY EXCEPTIONS TO THESE FABRICATION STANDARDS WILL BE INDICATED BY THE DEPARTMENTAL REPRESENTATIVE AT TIME OF PURCHASE ORDER.

### 1.4 NON-STRUCTURAL - FLAT SHEET ALUMINIUM SIGNS

SHEET ALUMINIUM SIGNS MUST BE FLAT-SHEET TENSION-LEVELLED, SIGN GRADE ALUMINIUM, ALLOY 5052-H32, CONFORMING TO THE REQUIREMENTS OF ASTM B209M, SPECIFICATION FOR ALUMINIUM AND ALUMINIUM-ALLOY SHEET AND PLATE. NOMINAL THICKNESS FOR SHEET-FACED SIGNS IS 3.0 MM (0.125"). TO ENSURE MAXIMUM TOLERANCING AND BEST APPEARANCE, SHEET ALUMINIUM SIGN PANELS MUST BE CUT USING A NUMERICALLY CONTROLLED DEVICE SUCH AS WATER JET OR LASER CUTTING SYSTEM. ALTERNATIVELY, SHEET ALUMINIUM SUBSTRATES MAY BE SHEARED TO SIZE, CORNER-PUNCHED AND DETAILED, PROVIDED THAT THE DIMENSIONS AND CORNER RADII EXACTLY MATCH THE SUPPLIED SIGN ARTWORK. ALL EDGES MUST BE BROKEN, DE-BURRED AND MADE SMOOTH.

### 1.5 NON-STRUCTURAL ALUMINIUM COMPOSITE SIGNS

NON-STRUCTURAL ALUMINIUM COMPOSITE PANELS ARE TO CONSIST OF DOUBLE SIDED 0.3 mm (0.012") TO 0.4mm (0.015") THICK ALUMINIUM FRONT AND BACK FACE BONDED TO 3 mm POLYETHYLENE FOAM CORE.

ALUMINIUM FACE SHEETS FOR COMPOSITE PANELS TO BE SIGN GRADE ALLOY 5052-H32, CONFORMING TO THE REQUIREMENTS OF ASTM B209M, SPECIFICATION FOR ALUMINIUM AND ALUMINIUM-ALLOY SHEET AND PLATE.

SINGLE FACE TO BE FINISHED WITH 20 MICRONS FACTORY BAKED ACRYLIC WHITE PAINT MEETING REQUIREMENTS OF ASTM D-4214, D-2244. FACTORY COATED FACE WILL ACT AS BACK FACE OF FINISHED SIGN. NO-FACTORY COATED FACE MAY BE SUPPLIED AS MILL FINISH PROVIDED IT WILL ACCEPT LAMINATED RETRO-REFLECTIVE SHEETING, SCREEN PRINT AND DIGITAL PRINT TYPE INKS ASSOCIATED WITH SIGN GRAPHICS DESIGN.

PANELS SHALL BE PERFORMANCE BOND TESTED TO PASS ASTM C481-C.

ACCEPTABLE PRODUCT FOR NON-STRUCTURAL PANELS IS 'ALUPANEL' BY MULTIPANEL

### 2.0 FABRICATION SPECIFICATIONS

- 2.1 THE MAXIMUM ALLOWABLE DEVIATION FROM FLATNESS MUST NOT EXCEED 0.1MM PER 1CM (0.010 INCH PER INCH) WIDTH OF THE SIGN PANEL.
- 2.2 NO HOLES MUST BE MADE IN SIGNS FACES UNLESS REQUESTED BY DEPARTMENT. MOUNTING DETAILS VARY FROM SIGN TO SIGN. WHERE HOLES ARE REQUESTED, THEY MUST BE DRILLED AND EDGE SEALED SIMILAR TO OTHER CUT EDGES.
- 2.3 ALL ALUMINIUM SUBSTRATE MUST BE GIVEN A CHROMATE CONVERSION COATING IN ACCORDANCE WITH ASTM B 449, CLASS 2, AND MUST BE PREPARED BY ONE OF THE TREATMENT SEQUENCE OPTIONS DESCRIBED IN ASTM B 449, APPENDIX X2. THE CHEMICALS AND SOLVENTS MUST BE APPLIED IN STRICT ACCORDANCE WITH THE MANUFACTURER'S RECOMMENDATIONS. SUFFICIENT LABORATORY FACILITIES TO TEST AND CONTROL THE CONCENTRATION OF THE SOLUTIONS USED MUST BE MAINTAINED AT THE TREATING PLANT. A LOG OF THE CONCENTRATION OF TREATING SOLUTIONS MUST BE MAINTAINED. TREATED PANELS MUST BE HANDLED IN SUCH A MANNER AS TO PREVENT CONTAMINATION. PANELS MUST BE STORED IN A DRY, CLEAN AREA FREE FROM DUST, ACID FUMES OR VAPORS. WHEN ALUMINIUM IS SHIPPED TO A SECONDARY LOCATION FOR RETRO-REFLECTORIZING, ADEQUATE PRECAUTIONS MUST BE TAKEN TO ENSURE THAT THE MATERIAL ARRIVES AT THE DESTINATION UNCONTAMINATED.
- 2.4 BACKGROUND COLOURING (WHITE) MUST BE APPLIED AS A LAMINATED RETRO-REFLECTIVE SHEETING, COLOURED AS INDICATED ON DRAWINGS. SHEETING TO BE ASTM STANDARD D4956-11A, TYPE IV, CLASS I. USE ASTM D 4956 TYPE IX, XI OR AASHTO M 268 TYPE C OR D PRISMATIC RED FOR RED BACKGROUND PORTIONS OF SIGNS. RETROREFLECTIVE SHEETING MUST BE HIGH INTENSITY THAT IS AN UNMETALLIZED MICRO PRISMATIC REFLECTIVE MATERIAL.
- 2.5 BACKGROUND COLOURING (GREEN) MUST BE APPLIED USING POWDER COAT PROCESS. THE ENTIRE SIGN PANEL MUST BE POWDER COATED PRIOR TO APPLYING RETROREFLECTIVE SHEETING.
  - 2.5.1 BASE COAT: THERMOSETTING EPOXY POWDER COATING, WHITE OR GRAY IN COLOUR. APPLY ONE (1) COAT OF MINIMUM THICKNESS OF 2 MILS (0.0508 MM).
  - 2.5.2 TOP COAT: TRIGLYCIDYL ISOCYANURATE (TGIC) POLYESTER POWDER COAT FINISH, HIGH GLOSS, 'PCA HERITAGE GREEN' IN COLOUR. APPLY ONE (1) COAT OF MINIMUM THICKNESS OF 2 MILS (0.0508 MM).
  - 2.5.3 USE "POWDURA POLYESTER TGIC POWDER COATING" BY SHERWIN-WILLIAMS OR APPROVED EQUAL. PRODUCT SUBSTITUTIONS MUST BE APPROVED BY MASTER PAINTER'S INSTITUTE (MPI) AND SHALL MEET ASTM D3451 - D6(2012) STANDARD GUIDE FOR TESTING COATING POWDERS AND POWDER COATINGS AS A MINIMUM STANDARD.
- 2.6 ALL SIGNS MUST BE OF THE HIGHEST QUALITY WITH CONSISTENT DAYTIME AND NIGHTTIME COLOR AND RETRO-REFLECTIVITY
- 2.7 APPLY CLEAR COATING OR EDGE SEALER AFTER APPLICATION OF THE RETRO-REFLECTIVE SHEETING AS RECOMMENDED BY THE SHEETING MANUFACTURER. WHERE CLEAR FINISH IS USED, THE FINISH MUST BE APPLIED AFTER SCREENING OF MESSAGES AND BORDERS AND DRILLING OF ALL HOLES, WHERE EDGE SEALER IS USED, THE SEALER MUST BE APPLIED TO ALL HOLES AND EDGES. THE COMPLETED SIGN FACE MUST BE FREE FROM AIR BUBBLES, WRINKLES OR OTHER BLEMISHES.
- 2.8 LETTERS AND SYMBOLS MUST BE APPLIED TO THE BACKGROUND OF THE SIGN BY THE DIRECT OR REVERSE SCREEN PROCESS. MESSAGES AND BORDERS OF A COLOR DARKER THAN THE SIGN FIELD MUST BE APPLIED TO THE RETROREFLECTIVE SHEETING BY THE DIRECT PROCESS. MESSAGES AND BORDERS OF A COLOR LIGHTER THAN THE SIGN FIELD MUST BE PRODUCED BY THE REVERSE SCREEN PROCESS. INKS USED IN THE SILKSCREEN PROCESS MUST BE OF THE TYPE TO PRODUCE THE DESIRED COLOR AND DURABILITY WHEN APPLIED ON RETROREFLECTIVE SHEETING. SILKSCREEN INKS MUST BE USED IN ACCORDANCE WITH THE MANUFACTURER'S RECOMMENDATIONS. THE INK MUST PRODUCE THE DESIRED COLOR WHEN APPLIED ON RETROREFLECTIVE SHEETING BACKGROUND AND MUST DRY TO A GOOD FILM WITHOUT RUNNING, STREAKING OR SAGGING. THE SCREENING MUST BE DONE IN A MANNER THAT RESULTS IN A UNIFORM COLOR AND TONE, WITH SHARPLY DEFINED EDGES OF LEGEND AND BORDER WITHOUT BLEMISHES ON THE SIGN FIELD THAT WILL AFFECT THE INTENDED USE. SIGNS AFTER SCREENING MUST BE DRIED IN ACCORDANCE WITH THE MANUFACTURER'S RECOMMENDATIONS TO PROVIDE A SMOOTH HARD FINISH. ANY SIGNS ON WHICH BLISTERS APPEAR DURING THE DRYING PROCESS WILL BE REJECTED.