

ALDOT-245-83
**PROCEDURES FOR SAMPLING AND INSPECTION OF ROADWAY SIGNS, AND OVERHEAD
SIGN STRUCTURES**

1. Scope

- 1.1. This procedure establishes the requirements of project and Central Laboratory personnel in relation to the inspection and sampling of roadway signs, and overhead sign structures.
- 1.2. All required certifications should be shipped to the Project Engineer, with the exception of overhead sign structures. Certifications for overhead sign structures should be shipped to the Bureau of Materials and Tests, Certification Engineer for approval. If samples are required, on projects with less than 200 ft² of sign material, the Project Engineer should select samples from the material delivered to the project. The Project Engineer will in turn process these items through the proper channels prior to authorizing payment for the item.
- 1.3. Signs and structures should not be installed until the engineer has a passing test report in hand. When samples are required, in addition to certified test reports, payment should not be authorized until sample testing is complete and certified test reports are approved by the Central Laboratory.

2. Job Sampling Requirements

- 2.1. Projects requiring 200 ft² (20 m²) or less of standard sign panel may be accepted under ALDOT-195 without sampling. The Project Engineer should make a visual inspection of all materials in addition to this to assure items are correct. If any items look suspect, samples may be taken in the same manner as would be required for large projects.
- 2.2. On projects requiring over 200 ft² (20 m²), the Project Engineer shall notify the Bureau of Materials and Tests, Certification Lab, of the arrival of sign materials on the job prior to installation. An inspector from the Certification Lab will make an inspection visit to the project to check all hardware such as nuts, bolts, washers, angles, channels, supports, and sign panels. The inspector along with project personnel will inspect these materials and select samples, in accordance with Section 710 of the Testing Manual. Due to the destructive nature of the testing no samples will be taken from large multi-panel signs unless material certifications are not correct for material specifications or material is suspect.
- 2.3. When tube and beam supports are used on ground mount signs, the producer may furnish certified test reports as outlined in ALDOT-195 or furnish an additional 39 in (1 m) length of each type with the shipment. This section shall be used as the sample in lieu of destroying a prefabricated support. Should this sample fail to meet the required specification, it will be necessary to sample a completed support.
- 2.4. High strength bolts, nuts, and washers for break-away signs shall be shipped to the project in sealed containers with lot numbers marked in accordance with Section 508 and 836 of the Specifications. Samples and certifications shall be furnished in accordance with Article 836.33 of the Specifications and Section 508 of the Testing Manual and submitted to the Central Laboratory for analysis. In addition, the contractor shall supply additional fasteners to compensate for five (5) sets of fasteners, per lot, selected by the Department Inspector for calibration of the contractor's torque

wrench used for installation. All fasteners selected as samples will be randomly sampled from the sealed and marked containers. Project Engineers should contact the Bureau of Materials and Tests, Certification Laboratory, prior to installation to arrange for an inspector to come and calibrate the contractor's equipment.

- 2.5. A 3 in x 12 in (75 mm x 300 mm) sample shall be furnished by the producer for each run of porcelain-enameled signs. This sample shall be submitted to the Central Laboratory for testing. Samples of completed signs will not be required unless non-specification materials are suspected.

3. Overhead Sign Structures

- 3.1. Upon Department approval of shop drawings, the fabricator shall notify the Bridge Bureau of the intended time that fabrication is to begin. The Department may elect to send an inspector to visit the plant prior to fabrication or the Department may elect to allow the producer to begin without an inspection, depending on the history of the fabricator, size and type of structure, and availability of the inspector.
- 3.2. Upon completion of fabrication and prior to galvanization, the fabricator will contact the Department (Bridge Bureau Steel Inspector) for an inspection. The Department may elect to have a representative present at the coating process. This, again, is dependent on the factors listed in 3.1.
- 3.3. Should the Department elect not to have an inspector present at galvanization the fabricator may be allowed to furnish certified test reports covering the galvanization of the structure to the project engineer or attach two metal coupons made of the same material as the structure to each structure prior to galvanization. If coupons are used then they will remain in place during the coating process and the project engineer will remove the coupons and submit them to either Division or Central Laboratory for testing.
- 3.4. The Project Engineer shall notify the Bureau of Materials and Tests, Certification Lab, of the arrival of sign materials on the job prior to installation. An inspector from the Certification Lab will make an inspection visit to the project to check all hardware such as nuts, bolts, washers, angles, channels, supports, and sign panels. The inspector along with project personnel will inspect these materials and select samples, in accordance with Section 710 of the Testing Manual. Due to the destructive nature of the testing and the large size of the panels, no samples will be taken from them unless material certifications are not correct for material specifications or material is suspect.
- 3.5. High strength bolts, nuts, and washers for overhead sign structures shall be shipped to the project in sealed containers with lot numbers marked in accordance with Section 508 and 836 of the Specifications. Samples and certifications shall be furnished in accordance with 836 of the Specifications and Section 508 of the Testing Manual and submitted to the Central Laboratory for analysis. In addition, the contractor shall supply additional fasteners to compensate for five (5) sets of fasteners, per lot, selected by the Department Inspector for calibration of the contractor's torque wrench used for installation. All fasteners selected as samples will be randomly sampled from the sealed and marked containers. Project Engineers should contact the Bureau of Materials and Tests, Certification Laboratory, prior to installation to arrange for an inspector to come and calibrate the contractor's equipment.