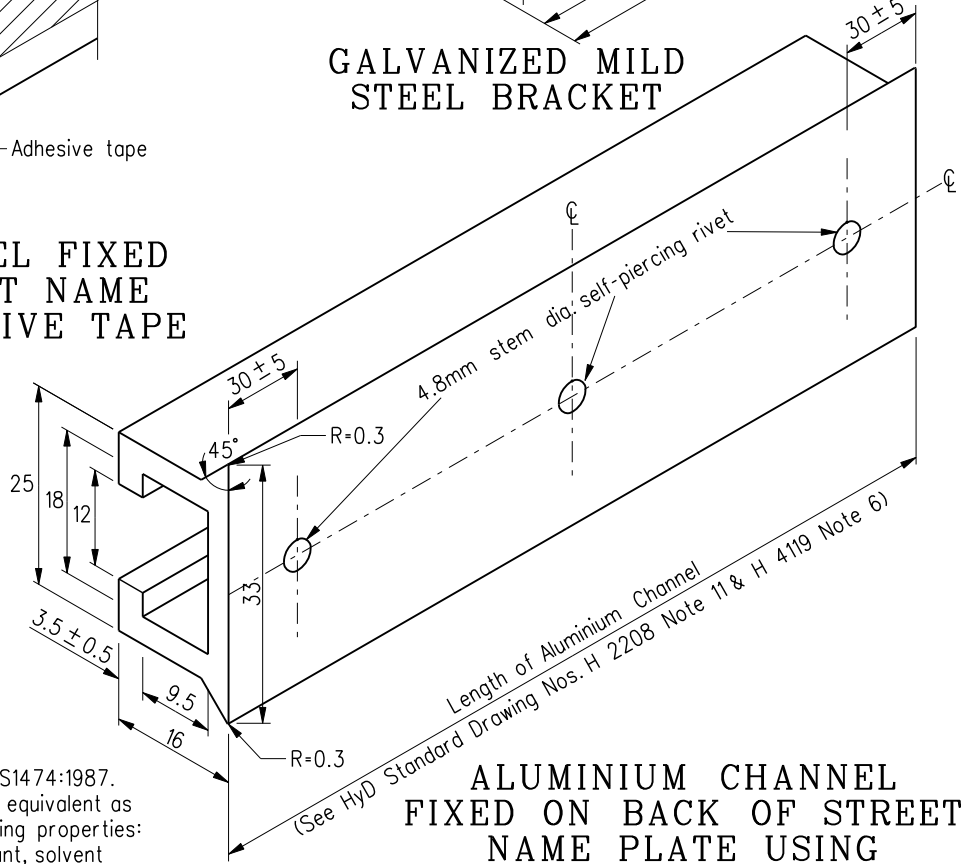


GALVANIZED MILD STEEL BRACKET

ALUMINIUM CHANNEL FIXED ON BACK OF STREET NAME PLATE USING ADHESIVE TAPE



ALUMINIUM CHANNEL FIXED ON BACK OF STREET NAME PLATE USING SELF-PIERCING RIVETS

Note :

1. All dimensions are in millimetres.
2. Steelwork shall be Grade 43 to BS4360.
3. Steelwork shall be hot dip galvanized to BS EN ISO 1461:1999.
4. Aluminium shall be to A6063T5 as per BS1474:1987.
5. Adhesive tape shall be 3M VHB 4950 or equivalent as approved by the Engineer with the following properties:
 - pressure sensitive, temperature resistant, solvent resistant, moisture resistant, and ultra-violet resistant acrylic foam closed cell double coated tape of minimum 1mm thick.
 - minimum Peel Adhesion strength of 400N/100mm for 90° peel with tape adhered to stainless steel when tested with a minimum jaw speed of 300mm/min at room temperature in accordance with ASTM D-3330.
 - minimum Normal Tensile Strength of 950 kN/m² with tape adhered to aluminium when tested with a minimum jaw speed of 50mm/min at room temperature in accordance with ASTM D-897.
 - minimum Static Shear strength of 150g/cm loadings at 60°C with tape adhered to stainless steel in accordance with ASTM D-3654
 - minimum Dynamic Shear strength of 500 kN/m² with tape adhered to stainless steel when tested with a minimum jaw speed of 12mm/min at room temperature in accordance with ASTM D-1002.
6. The following particulars and samples of the proposed adhesive tape shall be submitted to the Engineer for approval before application of the adhesive tape starts:
 - (i) Certificates for the adhesive tape showing the manufacturer's name, the date and place of manufacture, and test results showing compliance with the above minimum strengths of Peel Adhesion, Normal Tensile, Static Shear and Dynamic Shear.
 - (ii) The methods specified by the adhesive tape manufacturer for the preparation of the bonding surfaces and application of adhesive tape onto the bonding surfaces.
7. The surface preparation and application of adhesive tape shall be in accordance with the methods specified by the adhesive tape manufacturer.
8. The self-piercing rivet shall be galvanized steel with countersunk head and chamfered poke. The self-piercing rivet head shall not be visible. The sign surface at the rivet position shall not be indented and shall not protrude by more than 0.3mm from the sign surface.

REF.	REVISION	SIGNATURE	DATE
C	Note 3 updated		Sep 07
B	Alternative fixing of aluminium channel using self-piercing rivets and Note 8 added.		Nov 06
A	Drawing title revised. Mounting details revised.		Oct 04
	New issue		Mar 04

CHANNEL AND BRACKET FOR MOUNTING STREET NAME PLATES

HIGHWAYS DEPARTMENT			
REFERENCE	DRAWING No.	CAD	
SCALE	NOT TO SCALE	H 2211C	