



## OLD PROCEDURE FOR MONTANA STATE PRISON LICENSE PLATE MANUFACTURING (Until 2006)

- Step 1: **Aluminum roll** is placed on spool and fed into the hot water.
- Step 2: **Hot water tank** cleans and dries the aluminum for a clean surface.
- Step 3: **Metal straightener** makes sure that the aluminum is perfectly flat.
- Step 4: **Scotchlite applicator** laminates the surface to the aluminum. This process is skipped for some types of plates such as the apportioned plate sample.
- Step 5: **Cutter** uses a hydraulic press to "chop" out individual plates. This also punches the holes in the plate so it can be bolted to the car.
- Step 6: **Press** uses a hydraulic action to press into the plates the chosen numbers or letters.
- Step 7: **Roller coater** paints the raised numbers or letters.
- Step 8: **Oven** dries the plates as they go through on a monorail.
- Step 9: **Clearcoating** is applied by dipping before the plates again ride the monorail through the oven.
- Step 10: **Boxing** for shipping to the various county treasurers.

The diagram that shows the plant layout does not have all three presses shown. Each of these is used for different types of plates as follows:

PRESS #1	PRESS #2	PRESS #3
Dealer plates	All small plates	Passenger
Used dealer plates	Motorcycle	Truck
Recreation vehicles	Small trailer	Large trailer
Apportioned (as sample)	Small special mobile	Personalized
Vintage	Combine	Amateur radio
Large exempt	Motorcycle dealer	MT Highway Patrol
State owned	Transit	Disabled
		Ex-POW
		Armed Forces
		Veteran

2000 sets of license plates could be produced per hour when geared for production.



