

# Cast Letters Specifications

## Part I – General

### 1.1 Scope

- A. Furnish letters and hardware necessary to install cast letters shown on drawings and herein specified.

### 1.2 Submittals

- A. Manufacturer's illustrated product literature and specifications.
- B. Installation instructions

### 1.2 Quality Assurance

- A. Manufacturer to have a minimum of 20 years experience in manufacturing letters.
- B. All letters to be manufactured by one manufacturer.

## Part II – Products

### 2.1 Acceptable Manufacturer or Manufacturer's Representative

- A. Gemini Incorporated  
103 Mensing Way  
Cannon Falls, MN 55009  
Phone: 800-538-8377 or 507-263-3957  
Fax: 800-421-1256 or 507-263-4887  
Email: sales@signletters.com  
Web: www.signletters.com

### 2.2 Materials (Metal Alloys)

- A. Aluminum
- B. Bronze – Lead Free

### 2.3 Finishes

#### A. Aluminum

1. Natural Satin faces, bead-blasted returns, 2-part hardened acrylic polyurethane clear coat.
2. Baked Enamel, bead-blasted returns, #319 aluminum alloy.
3. Clear Anodized, sanded return, #514 aluminum alloy.
4. Gold anodized, sanded return, #514 aluminum alloy.
5. Medium bronze anodized, bead-blasted return, #514 aluminum alloy.
6. Dark bronze anodized, bead-blasted return, #514 aluminum alloy.
7. Black anodized, bead-blasted return, #514 aluminum alloy.

#### B. Bronze

1. Natural satin stroke sanded face, bead-blasted return, 2-part hardened acrylic polyurethane clear coat, NAVY G 88-8-0-4 lead and mercury free bronze alloy.
2. US9 Finish, hand polished face, bead-blasted return, 2-part hardened acrylic polyurethane clear coat, NAVY G 88-0-4 lead and mercury free bronze alloy.
3. Oxidized, NAVY G 88-0-4 lead and mercury free bronze alloy, 2-part hardened acrylic polyurethane clear coat, US108 finish.
4. Green Patina, varies from letter to letter, not uniform.

### 2.3 Mounting Hardware

- A. Cast metal letters have threaded stud bosses for stud insertion.
- B. All aluminum letters under 18" use aluminum studs
- C. All other letters use stainless steel studs.

### 2.4 Manufacture

- A. Letters shall be made of \_\_\_\_\_.
- B. Letter shall be \_\_\_\_\_ letterstyle and shall be \_\_\_\_\_ inches high, as indicated on the drawings.
- C. Finish shall be \_\_\_\_\_.
- D. Mounting shall be \_\_\_\_\_ and a mounting template designating stud locations is/is not required for mounting on a \_\_\_\_\_ surface

## Part III – Execution

### 3.1 Installation

- A. A qualified installer shall install cast letters.

### 3.2 Warranty

- A. Letters should be guaranteed for the life of the business against defects.