

Flat Cut 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 - 5052 Alloy
- B. Bronze – 220 Commercial Alloy
- C. Brass – No Lead CR464
- D. Copper – 110 Alloy
- E. Stainless Steel – 304 Alloy

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.
3. Clear Anodized, sanded return.
4. Gold anodized, sanded return.
5. Medium bronze anodized, bead-blasted return.
6. Dark bronze anodized, bead-blasted return.
7. Black anodized, bead-blasted return.

B. Bronze

1. Natural satin stroke sanded face, bead-blasted return, 2-part hardened acrylic polyurethane clear coat.
2. US9 Finish, hand polished face, bead-blasted return, 2-part hardened acrylic polyurethane clear coat.
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 Fabrication

- A. Letters shall be made of _____.
- B. Letter shall be _____ letter style 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.