

CAST METAL - Letters & Logo Specifications

Part I - General

1.1 Scope

A. Furnish letters and hardware necessary to install cast letter/logos, shown on drawing and herein specified.

1.2 Submittals

A. Manufacturer's illustrated product literature and specifications.

B. Installation instructions

1.3 Quality Assurance

A. Manufacturer to have a minimum of 15 years experience in manufacturing Letters/Custom Signs/Logos.

B. All letters to be manufactured by one manufacturer.

Part II - Products

2.1 Acceptable Manufacturer or Manufacturers Representative

A. LettersandSigns.com (a division of Trademarks Signs)
11447 Strang Line Rd
Lenexa, KS 66215
Phone: 816-800-9444
Email: sales@lettersandsigns.com
WEB: www.lettersandsigns.com

2.2 Materials

A. Aluminum - 514 Alloy.

B. Bronze - Navy G (lead and mercury free bronze) alloy.

2.3 Finishes

A. Aluminum - (Alloy #514).

1. Brushed: directionally sanded faces to a standard #2-#3 finish, (#4 finish optional), vertical grain direction (optional horizontal grain, random arc, or orbital sanded), bead-blasted returns, low-gloss clear coated, baked.
2. Painted: (standard or custom colors), directionally sanded faces, bead-blasted returns, liquid sprayed with a 2 part hardened acrylic polyurethane, oven baked to cure paint.
3. Clear Anodized: directionally sanded faces, bead-blasted returns, anodized to meet A31 Aluminum Architectural Class II anodized finish (.4-.7 mil), no clear coat.
4. Gold Anodized: directionally sanded faces, bead-blasted returns, anodized to meet A43 Aluminum Architectural Class I anodized finish (.7-1 mil), no clear coat.
5. Light Bronze Anodized: directionally sanded faces, bead-blasted returns, anodized to meet A44 Aluminum Architectural Class I anodized finish (.7-1 mil), no clear coat.
6. Medium Bronze Anodized: directionally sanded faces, bead-blasted returns, anodized to meet A44 Aluminum Architectural Class I anodized finish (.7-1 mil), no clear coat.
7. Dark Bronze Anodized: directionally sanded faces, bead-blasted returns, anodized to meet A44 Aluminum Architectural Class I anodized finish (.7-1 mil), no clear coat.
8. Black Anodized: directionally sanded faces, bead-blasted returns, anodized to meet A44 Aluminum Architectural Class I anodized finish (.7-1 mil), no clear coat.
9. Champagne Anodized: directionally sanded faces, bead-blasted returns, anodized to meet A44 Aluminum Architectural Class I anodized finish (.7-1 mil), no clear coat.
10. Buff (near-polish #6 - #7 finish): buffed faces (not mirror finish), bead blasted returns, sprayed with 2 part hardener clear polyurethane, baked.
11. Rust Powder coated: directionally sanded faces, bead blasted returns, powder coated with Rust color paint, baked.

B. Bronze (NAVY G Alloy - lead & mercury free)

1. Brushed: directionally sanded faces, #2-#2 finish (#4 optional), vertical grain direction standard (horizontal optional), bead blasted returns, sprayed with 2-part hardened acrylic polyurethane low-gloss clear coat, baked.
2. Polished US9 Finish: polished face - #8 finish, bead-blasted returns, 2-part hardened acrylic polyurethane gloss clear coat, baked.
3. Light Oxidized US10B Finish: directionally sanded face (vertical standard), bead-blasted returns, oxidized, then faces are hand rubbed, directionally, to a light oxidized finish (exposing most bronze), returns left black, low gloss clear coated, baked.
- 3.1 Oxidized US10B Finish: directionally sanded face (vertical standard), bead-blasted returns, oxidized, then faces are hand rubbed, directionally, to a oxidized (antique) look (slightly exposed bronze), returns left black, low gloss clear coated, baked.

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2.3 Finishes - Continued

B. Bronze

5. Medium Oxidized US10B Finish: directionally sanded face, bead-blasted returns, oxidized, then faces are lightly hand rubbed directionally, to create a Dark Bronze look (minimal bronze exposed), low gloss clear coated, baked.
6. Traditional or Turquoise Patina: belt sanded face, faces and returns are chemically treated to create a colored patina look (finish will vary from letter to letter, not uniform), light clear coating, baked.

2.4 General Construction

- A. Cast Letters or Logo's are cast from either standard pattern styles, or custom styles per the customer's clean vectored files.
- B. Cast Letters and Logo's are hand finished per order, per custom specifications. Face grain direction is standard at vertical. Horizontal grain direction is optional per the customers specifications.

2.5 Mounting Hardware & Options

- A. Blind stud standard. Available aligned for Brick, Block, Rail. Optional Single or Double Rail, Top or Bottom Rail, Bottom Angle Brackets, Top & Bottom Stud
- B. Letters under 15", drilled & tapped for 10-24 threaded studs. Thin stroke letters typically have 6-32 threaded studs.
- C. Letters 15" and taller, drilled and tapped for 1/4-20 threaded studs (Aluminum studs with Aluminum Letters, Stainless Steel studs with Bronze letters)
- D. Aluminum spacer sleeves available upon request. Standard lengths per online catalog offerings (generally 1" long). Custom lengths upon request.

2.6 Manufacture

- A. Cast metal letters shall be made of _____
- B. Letters shall be _____ letter style or font, and shall be _____ inches high as indicated in approved drawings.
- C. Finish shall be _____
- D. Mounting shall be _____ with a drilling pattern, designating stud locations, for mounting on a _____ surface.

Part III - Execution

3.1 Installation

- A. A qualified installer shall install cast letters and logos.

3.2 Warranty

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

3.3 Maintenance

- A. Cleaning of Letters / Logos as needed, per manufacturers recommendations.