

Cut Metal Letters

CSI Specifications

Section 10 14 19 (Section 10430)

Dimensional Letter Signage

Impact Architectural Signs
26 E Burlington Ave
LaGrange, IL 60525

(708) 469-7178

[http://www.impactsigns.com/metal-letters/
specifications@impactsigns.com](http://www.impactsigns.com/metal-letters/specifications@impactsigns.com)

Part 1 – General

1.1 Section Includes

- A. Cut Aluminum Letters
- B. Cut Bronze Letters
- C. Cut Brass Letters
- D. Cut Copper Letters
- E. Cut Stainless Steel Letters

1.2 Scope

A. Furnish letters and hardware necessary to install cut metal letters shown on drawings and herein specified.

1.3 Submittals

- A. Manufacturer's descriptive literature and specifications.
- C. Shop Drawings
- B. Installation instructions

1.4 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

A. Impact Architectural Signs
26 E Burlington Ave
LaGrange, IL 60525

(708) 469-7178

[http://www.impactsigns.com/metal-letters/
specifications@impactsigns.com](http://www.impactsigns.com/metal-letters/specifications@impactsigns.com)

B. Substitutes: Substitutes are not acceptable.

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 or 316 Alloy

2.3 Finishes

A. Aluminum

- 1. Natural Satin faces, bead-blasted returns, 2-part hardened acrylic polyurethane clear coat.
- 2. Painted baked enamel finish. Select from manufacturer's standard colors or specify PMS color match. Standard finish for paint is semi gloss. Matte and High gloss are available upon request.
- 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.

C. Brass

- 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.

D. Copper

- 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.

B. Stainless Steel

- 1. Specify Alloy 304 or Alloy 316
- 2. Natural satin stroke sanded face, bead-blasted return
- 3. US9 Finish, hand polished face, bead-blasted return

Note: Flat Cut Metal Letters do not have polished returns.

2.4 Thickness

- A. Aluminum - $\frac{1}{4}$ ", $\frac{3}{8}$ ", $\frac{1}{2}$ ", $\frac{3}{4}$ ", and 1"
- B. Bronze – $\frac{1}{4}$ ", $\frac{3}{8}$ ", and $\frac{1}{2}$ "
- C. Brass – $\frac{1}{4}$ ", $\frac{3}{8}$ ", and $\frac{1}{2}$ "
- D. Copper – $\frac{1}{4}$ " and $\frac{3}{8}$ "
- E. Stainless Steel – $\frac{1}{4}$ ", $\frac{3}{8}$ ", and $\frac{1}{2}$ "

2.5 Font Styles

- A. Select from Manufacturers Standard font list
- B. Specify a custom font
- C. Provide a vector art file for custom logo shapes.

2.6 Mounting Hardware

- A. Cut metal letters are tapped for threaded stud insertion.
- B. All aluminum letters under 18" use aluminum studs

- C. All other letters use stainless steel studs.
- D. Spacers can be used to "float" letters from wall. From .25"
- E. Paper Installation template with marked stud locations should be provided.
- F. Double Rail Mounting, Bottom Rail Mounting may be used where individual letter installation is not possible

2.7 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 cut metal letters.
- B. Impact! Arcitectoral Signs offers installation nationwide for architectural signage.
- C. Install signs level, plumb, and at the height indicated with sign surfaces free from distortion or other defects in appearance.

3.2 Warranty

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