CAST METAL – Letters & Logos Specifications

Part I – General

1.1 Scope
A. Furnish letters and hardware necessary to install cast letters/logos, shown on drawings 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 25 years experience in manufacturing Letters/Logos.
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@geminisignproducts.com
   Web: www.geminisignproducts.com

2.2 Materials (Metal Alloys)
A. Aluminum – 514 Alloy.
B. Bronze – NAVY G (lead and mercury free bronze) alloy.

2.3 Finishes (meeting ASTM G4A specifications)
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 powder 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 (.7-1mil), 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 (.7-1mil), no clear coat.
   8. Black Anodized: directionally sanded faces, bead-blasted returns, anodized to meet A44 Aluminum Architectural Class I anodized finish (.7-1mil), no clear coat.
   9. Champagne Anodized: directionally sanded faces, bead-blasted returns, anodized to meet A44 Aluminum Architectural Class I anodized finish (.7-1mil), no clear coat.
   10. Buffed (near-polish #6–#7 finish): buffed faces (not a mirror finish), bead blasted returns, sprayed with 2-part hardened clear polyurethane, baked.

B. Bronze (NAVY G Alloy – lead & mercury free)
   1. Brushed: directionally sanded faces, #2–#3 finish (#4 optional), vertical grain direction standard (horizontal optional), bead-blasted returns, sprayed with 2-part hardened acrylic polyurethane low-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.
   4. Oxidized US10B Finish: directionally sanded face (vertical standard), bead-blasted returns, oxidized, then faces are hand rubbed, directionally, to create an oxidized (antique) look (slightly exposed bronze), returns left black, low-gloss clear coated, baked.
   5. Dark 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.
   4. 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. Gemini cast Aluminum/Bronze Letters & Logos - in one of multiple company foundries.
B. Styles: Cast Letters are cast from either standard pattern styles, or custom styles per customer’s vectorized art files.
C. Cast Letters are hand finished per order, per customer specifications. Face grain direction is standard at vertical – horizontal grain direction is optional.

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 or Bottom Stud.
C. Letters 15”+, drilled & tapped for 1/4-20 threaded studs (Aluminum studs with Alum letters, Stainless Steel studs with Bronze letters).
D. Aluminum spacer sleeves available upon request. Standard lengths per catalog offerings. Custom lengths upon request.

2.6 Manufacture
A. Cast metal 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 __________________ with a Drilling pattern, designating stud locations
   Are/ are not required for mounting on a ____________ surface.

Part III – Execution
3.1 Installation
A. A qualified installer shall install cast letters. Additional structural support may be required for larger/heavier Letters/Logos.

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

3.3 Maintenance
A. Cleaning of Letters/Logos as needed, per manufacturer’s recommendations.