**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

**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](mailto: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 - ¼”, ⅜”, ½”, ¾”, and 1”

B. Bronze – ¼”, ⅜”, and ½”

C. Brass – ¼”, ⅜”, and ½”

D. Copper – ¼” and ⅜”

E. Stainless Steel – ¼”, ⅜”, and ½”

**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! Arcitectural 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.