

## Part I – General

### 1.1 Scope

A. Furnish letters and hardware necessary to install Flat Cut Metal letters and 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 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@geminisignproducts.com

Web: [www.geminisignproducts.com](http://www.geminisignproducts.com)

### 2.2 Materials (Metal Options)

A. Aluminum - 5052 Alloy

B. Bronze – C22000 Commercial Alloy

C. Brass – C46400 Alloy (No Lead)

D. Copper – C1100 Alloy

E. Stainless Steel – C304 Alloy and 316 Alloy (more salt corrosion resistant)

F. Cor-Ten™ Steel

### 2.3 Process

A. Cutting

1. Flat Cut: Laser or Waterjet cut (based on Metal, Gauge and Product), using computer-guided equipment.

2. MINI Letters: Precision CNC cut. (under 3"high), using computer guided equipment.

### 2.4 Finishes (meeting ASTM G4A specifications)

A. Aluminum

1. Brushed face, 5052 Alloy, #2-#3 finish (#4 optional) vertical grain direction standard; horizontal grain, random arc, or orbital sanded optional. Bead-blasted returns, clear low-gloss powder coating, baked.

2. Painted face & returns (standard or custom colors), 5052 Alloy, bead-blasted returns, sprayed with acrylic polyurethane (1.75 +/- .25 mils thick) gloss, semi-gloss, satin or matte sheen, baked.

3. Clear Anodized, 6061 Alloy, bead-blasted returns, process meets A43 Aluminum Architectural grade anodized finish (.8-1 mil), no clear coat.

4. Gold Anodized, 6061 Alloy, bead-blasted returns, process meets A43 Aluminum Architectural grade anodized finish (.8-1 mil), no clear coat.

5. Medium Bronze Anodized, 6061 Alloy, bead-blasted return, process meets A43 Aluminum Architectural grade anodized finish (.8-1 mil), no clear coat.

6. Dark Bronze Anodized, 6061 Alloy, bead-blasted return, process meets A43 Aluminum Architectural grade anodized finish (.8-1 mil), no clear coat.

7. Black Anodized, 6061 Alloy, bead-blasted return, process meets A43 Aluminum Architectural grade anodized finish (.8-1 mil), no clear coat.

8. Champagne and Light Bronze Anodized, 6061 Alloy, bead-blasted returns, process meets A43 Aluminum Architectural grade anodized finish (.8-1 mil), no clear coat.

9. Polished, 6061 Alloy, (not a mirror finish) then Anodized any standard Anodized color, or left Clear Polished Anodized. Process meets A43 Aluminum Architectural grade anodized finish, no clear coat.

10. Polished #8 faces, 5052 Alloy, bead-blasted returns, 2-part hardened gloss acrylic polyurethane clear coat, baked.

11. Nouveau Patina or Rust Powder coated, bead-blasted returns, baked.

12. Premium & Premium MINI Letters: hand sanded, interior display quality finishing, no clear coat on MINI.

B. Bronze/Brass/Copper

1. Brushed face, #2-#3 finish (#4 optional) vertical grain standard; horizontal grain optional, bead-blasted returns, 2-part hardened acrylic polyurethane low-gloss clear coat (gloss optional), baked.

2. Polished face, #8 finish, bead-blasted returns, 2-part hardened acrylic polyurethane gloss clear coat, baked.

3. Oxidized, US10B finish, (available as Standard, Light or Dark Oxidized), bead-blasted returns, 2-part hardened acrylic polyurethane low-gloss clear coat, baked
  4. Verde or Turquoise Patina (finish varies from letter to letter, not uniform), light clear coat, baked.
  5. Premium & Premium MINI Letters: hand sanded, interior display quality finish. No clear coat on MINI.
- C. Stainless Steel (304 or 316 Alloy)
1. Brushed face, #2-#3 finish (#4 optional) vertical grain standard; horizontal grain optional, bead-blasted returns, no clear coat-standard, optional low-gloss clear coating.
  2. Polished #8 face, bead-blasted returns, no clear coat-standard, optional gloss clear coating.
- D. Cor-Ten™
1. Natural rust, color will vary from letter to letter as metal oxidizes, no grain direction, bead blasted returns, no clear coat.
  2. Painted face & returns, bead-blasted returns, baked
- E. Gemini standard Flat Cut Metal Letters do not have polished returns. Premium Finish Letters are available with combinations of Brushed, Polished or hand-sanded faces, straight or beveled returns (price varies by options chosen).

## **2.5 Mounting Hardware & Options**

- A. Blind stud standard, available aligned for Brick, Block, or Rail. Optional Single or Double Rail, Top or Bottom Rail (min. 3/8"thick), Top or Bottom Stud (min.3/8"th). Tie-backs recommended for Top & Btm mounts on letters over 8"high - not included.
- B. Letters under 15", drilled & tapped for 10-24 studs. Thin strokes, 6-32 or 4-40 studs.
- C. Letters 15"+, drilled & tapped for 1/4-20 studs (Aluminum studs with Alum letters, Stainless Steel studs with Bronze letters).
- D. Metal spacer sleeves available upon request, standard or custom lengths available.

## **2.6 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 Flat Cut Metal letters and logos. Additional structural support may be required on larger and heavier Letters & Logos. Stronger adhesives, such as Epoxy may be required to install with studs on heavier products.

### **3.2 Warranty**

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

### **3.3 Maintenance**

- A. Cleaning as needed per manufacturer recommendations.