

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

2.2 Materials (Metal Options)

A. Aluminum - 5052 Alloy & 6061 Alloy for Anodized finish

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.