

## Part I – General

### 1.1 Scope

A. Furnish Letters/Logos and hardware necessary to install Fabricated Aluminum 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

- A. High-Grade, Aluminum 5052 Alloy

### 2.3 General Construction

- A. Material Gauge: Fabricated Aluminum faces are produced with .090" aluminum. Returns are produced with .063" aluminum.
- B. Cutting: Computer guided lasers cut letters, logos or shapes.
- C. Construction: Letter returns are cut from .063" coil (1", 1.5", 2", 3", 4", 5", 6") to size based on the desired letter depth, bent to the contour of the laser cut faces to produce a hollow-backed letter with 90° angle edges. Inside joints are MIG welded with 1"-1.5" intervals.
- D. Testing: Welds are tested for strength. Finishes are Salt Fog tested to ASTM B-117-95 for corrosion resistance.
- E. Finishes: Fabricated Aluminum is cut from raw 2B 5052 Alloy Aluminum, then typically primed and painted with a 2-part hardened acrylic polyurethane paint – then oven baked. Optional-brushed with a low-gloss clear coating.

### 2.4 Finish Options

- A. 5052 Alloy Aluminum
  - 1. Painted finish, DA sanded face & returns, primed, then sprayed with 2-part hardened acrylic polyurethane paint and oven baked.
  - 2. Brushed finish – vertical grain, brushed face, then clear coated with low gloss acrylic polyurethane.

### 2.5 Fabricated Construction Options – Minimum 16" high letters

- A. Fabricated with Solid Metal Faces
  - 1. Solid Face with No Backs
  - 2. Solid Face with Backs
  - 3. Solid Face with Removable cans
- B. Fabricated with Cut-Out Faces (face or backlit optional LED package)
  - 1. Cut-out Face removable trim face - with Insert – solid back or no back.
- C. Open Channel Face
  - 1. Open face with solid back
- D. Limitations
  - 1. Stroke: minimum 2" stroke & serifs – up to 5" deep. Minimum 3" stroke & serifs at 6" deep.
  - 2. Edges: at 2" deep or deeper, no rounded edges, ends, or serifs.

### 2.6 Back Options

- A. Metal Backs
  - 1. Raw, unpainted or finished backs
  - 2. Removable or non-removable backs
- B. Lexan Backs
  - 1. Removable, flush, clear or light diffused, 16"-24" high: .118 gauge Clear Lexan. Over 24" high .236 Clear Lexan: Light Diffused Lexan .177 - all sizes

## **2.7 Mounting Options**

- A. Standard Mount Options: Side Stud Mount, Shadow-Free Stud Mount, and Detachable Stud Mount.
  - 1. Letters 16"-24": 10-24 threaded studs. Over 24": 1/4-20 threaded studs. Aluminum studs standard, stainless steel studs – optional.
  - 2. Mounting locations determined by manufacture, or per supplied art.
  - 3. Standard stud lengths available with or without spacers. Standard studs are threaded into stud bosses, from the backs of the letters or letter returns with a Top or Bottom stud mount.
  - 4. Bottom stud mounts require tie-backs (not supplied) for letter support. Up to 36", optional thick backs that allow for extra structural support – reduce need for tie-backs. Over 36"-thick backs are standard.

## **2.8 Lit Fabricated with LEDs**

- A. Fabricated letters lit with 12-volt DC LEDs - optional lighting packages.
  - 1. Face lit letters with removable 1"aluminum trim face, 3/4"face outline and translucent acrylic inserts. Custom outline widths available.
  - 2. Back (Halo) lit letters with removable clear or light-diffused Lexan backs.
  - 3. Halo Lit - Removable cans or optional detachable stud options for mounting lit letters and allowing future servicing of LEDs.
  - 5. UL Listed Option: UL approved LEDs, UL sign section labels, Class 2 power supplies, lead wires/cables, wiring diagrams and installation instructions supplied.

## **2.9 Manufacture**

- A. Letters to be made with Aluminum alloy 5052 in multiple finish options.
- B. Letters shall be \_\_\_\_\_ letter style and shall be \_\_\_\_\_ inches high and \_\_\_\_\_ inches deep, as indicated on drawings.
- C. Mounting shall be \_\_\_\_\_ and a mounting template designating stud hole locations (Is/Is Not) required for mounting on a \_\_\_\_\_ surface.

## **Part III – Execution**

### **3.1 Installation**

- A. A qualified installer shall install fabricated letters. Additional structural support may be required for larger/heavier letters and 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.