

## Flat Cut Aluminium Composite Lettering

Flat cut aluminium composite lettering, logos and shapes are machined from a variety of branded and un-branded aluminium composite materials

We offer various types of aluminium composite.

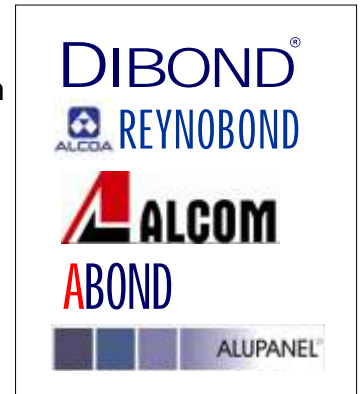
Dibond- the original Aluminium Composite (first tier)

Reynobon- a high quality material (first tier)

Alcom- a good generic brand of aluminium composite (second tier)

Abond- a good generic brand of aluminium composite (second tier)

Alupanel- a reasonably good brand of aluminium composite (second tier).



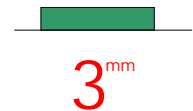
We break our aluminium composites into two tiers. The first tier is the best quality and a more expensive option. Second tier composites are a good balance between price and quality.

Aluminium composite can be machined with CNC router and Waterjet.

Our standard prices are for second tier materials. If you require first tier materials you must specifically request these in your purchase order.

## Thickness & foil

Aluminium composite products are manufactured in 3mm material only. Thicker composites are available subject to lead time and additional cost.



Our standard aluminium composite foil thickness is 0.3mm. This is at the thicker end of the range available. If you require 0.2mm foil you must specifically request this.

## Colouration- batches

Aluminium Composite sheets may vary slightly in colour between batches. If you require multiple sheets of composite we recommend you order in production sized batches.

## Colours

Aluminium Composite sheets are manufactured using the RAL colour reference system.

Solid colours are manufactured with a Gloss face and a Matt face. Please indicate clearly whether you require a Gloss or Matt finish to your flat cut composite products.

Metallic colours will be machined to preserve grain direction. This may result in more material being required that you may have previously calculated.



## Bonding- known issues.

Aluminium Composite can be bonded with flexible adhesives (sign trays) or two part acrylic adhesives (letters).

There are know issues with acrylic adhesives;

As the adhesive cures it contracts. This can case surface distortion on the display face- dishing.

This is a characteristic of Aluminium Composite and has nothing to do with incorrect adhesive use or application. Aluminium Composite manufacturers do not advertise the issue of dishing but will admit the problem when pressed.

Dishing is not normally visible to the naked eye on standard Gloss or Metallic finishes. Highly polished Mirror effect composite will amplify the dishing effect.

Dishing can be reduced or eliminated using a special adhesive application process. This process is used as standard on all flat cut products.

## Letter fixings- cup and peg

Letter fixings are available in three sizes/ diameters. Your lettering will be fitted with fixings whose size is most compatible with the stroke width.

The **minimum stroke width you can use is 13mm**. If your stroke width is less than 13mm there is insufficient area to mount any cup and peg fixing- the peg part of the fixing will overhang your letters. You can outline your original lettering until the 13mm minimum is achieved.

All letter fixings are bonded to the rear of each character using acrylic adhesive. The adhesive used is sourced direct from the manufacturer with particular attention paid to batch dates. Letter fixings are placed in a random pattern. Uniform fixing patterns can be provided on request subject to a small additional charge. Uniform fixing placement allows replacement letters to mount direct onto the cup part of the fixing without the need for re-drilling.

Computer plotted paper layout template(s) are supplied along with instructions as to how to mark and use the template(s)

Fixing screws and rawplugs are not supplied unless specifically requested.



Red= fixing diameter

Blue= standoff distance

## Letter fixings- VHB tape (surface mounting)

If you require letters which “stick” in place or you need letters which are too small for cup and peg fixings we will supply letters pre-installed with VHB\* double sided tape pads.

The standard type of VHB tape we supply is 19mm wide, 0.5mm thick and clear in colour.

This type of VHB\* tape is an industrial product which is suitable for interior and exterior uses.

It is imperative that the fixing surface you apply any VHB mounted letters to is smooth and has been thoroughly cleaned with Isopropranol Alcohol (IPA). Once wiped with IPA you must allow the solvent to evaporate before attempting to mount your letters.

This type of lettering is supplied with a self adhesive template.

**You must NOT use any other cleaning agent. IPA is the ONLY suitable product for use with VHB tapes.**

\* VHB means Very High Bond



## Letter fixings- threaded studs & plates

Letters can be supplied pre fitted with M6 base plates. These plates feature an M6 nut which allows an M6 threaded rod to be wound into the base plate.

The base plates are bonded to the rear of each letter using a two part acrylic adhesive.

These fixings are supplied with 120mm long M6 studding and a computer drawn paper template.

To mount this type of lettering you must ensure that the fixings holes you drill are blown out properly. We recommend the use of a chemical resin system (ChemFix).

Base plates can be trimmed to reduce base plate diameter.

**This type of fixing system is NOT suitable for timber surfaces or surfaces with voids behind.**



You may purchase letter fixings, adhesives and VHB tapes as loose items.

## Ordering

When you place your order we will program your job into our schedules. We aim to deliver aluminium composite flat cut lettering projects as quickly as possible. Standard colours should be available ex stock from our suppliers. Custom colours and projects which require large quantities of aluminium composite sheet may be subject to a delay whilst our suppliers arrange groupage of stock.

When specifying your order the onus is on you to supply accurate, detailed information as to the fixing system you require and the colour you require. Whilst we will endeavour to advise you on all aspects of this product we are not able to carry out on site surveys or technical investigations on your behalf.



We have created a PDF order form for this product which is available from our website.

## Manufacturing from supplied files.

If you require specific typefaces or logo shapes you need to supply us with a “clean” vector based file in .DXF or .AI/ EPS format. If you are working from an Apple Mac platform please ensure your files are exported in PC compatible formats.

If you are using free typefaces sourced from the internet please check the quality of the vector lines. Free typefaces are notorious for poor quality and irregular line shape.

Our production equipment machines EXACTLY what your file tells it to. Jagged lines and stepped curves will be reproduced if they pre-exist in your files.

For Corel users we can accept native .CDR files in versions up to 12. Please remember to convert all text to curves (shortcut key CTRL+Q).

## Manufacturing from supplied specifications.

We manufacture to the specifications provided to us. Please ensure that the specification you provide contains sufficient information so as to clearly explain exactly what you require.

If after manufacture you discover that the original specification is not fit for purpose this does not constitute grounds for free replacement goods, reworking or an entitlement to a full refund. Your specification represents the goods you require. It is in your own interest to ensure you correctly specify each job you undertake.

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