

Flat Cut Stainless Steel Lettering

Flat cut Stainless Steel lettering, logos and shapes are machined from marine grade Stainless Steel sheet.

All Stainless Steel products are machined via waterjet systems which produces a slight taper on all cut parts. Using special techniques we are able to ensure that any taper runs from back to front. This means that the display face of all cut Stainless Steel products has the taper hidden on the rear of each part.



Stainless Steel parts are cut from Marine grade materials

Thickness (Gauge)

If you are used to working with Plastics and Composites be aware that the same thicknesses do not apply to metals.

For example- 3mm Plastic is thought of as quite thin whereas 3mm Steel is thought of as quite thick.

Metals have more inherent rigidity and strength which means that plastic and composite thicknesses do not apply.

All flat cut products are supplied in 1.2mm gauge material as standard. This thickness gives a good balance between cost and performance.

If you require any other gauge please make this requirement clear in your specification.



Finishes

Two standard finishes are available;

High shine Mirror/ Chrome.
Brushed Satin Silver.

Please be sure to clearly state which finish you require.

Special effects and colours such as Gold finishes are available subject to a lead time of up to 6 weeks.



Sheet sizes

Two standard sheet sizes are available;

2000 x1000mm
2500 x 1250mm

For brushed/ Satin Silver stainless steel please remember that parts cannot be rotated to fit onto sheet sizes. In order to preserve grain direction it is essential that all parts are placed along the long dimension of the sheet used.

Larger sheet sizes may be available subject to lead time and costs.

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.

For 1.2mm Gauge Stainless Steel the base plates are bonded to the rear of each letter using a two part acrylic adhesive.

For 2 and 3mm Stainless Steel the base plates are welded into position.

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 Stainless Steel 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.

This document is for guidance only. All orders accepted subject to our standard terms and conditions. See www.smart-group.co.uk for more information.