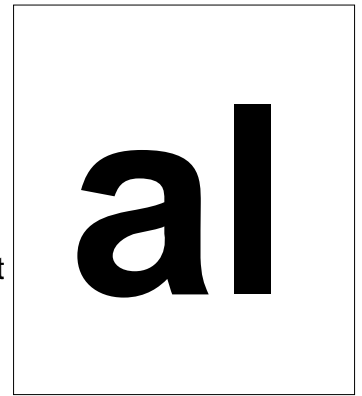


Flat Cut Aluminium Lettering

Flat cut aluminium lettering, logos and shapes are machined from high grade, solid aluminium sheet material.

All aluminium products are cut using CNC waterjet technology. This system creates a slight taper on all cut parts. During the cutting process we reverse the taper direction so that the taper is hidden from view on the rear of the cut part.

All aluminium used is 98%+ pure



Products available in aluminium

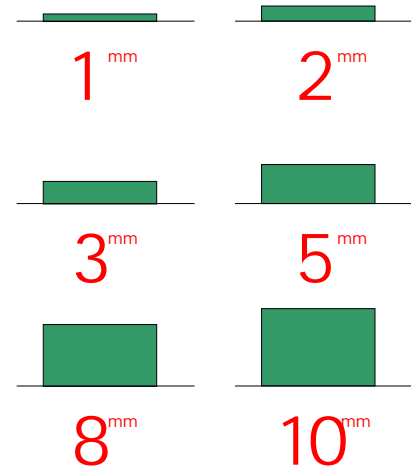
We are able to cut aluminium in any flat 2D shape. You can purchase lettering, logos, sign blanks, fret work, grilles, screens and machine parts or components.

Solid folded aluminium sign trays with welded corners are also available. We do not recommend that built up letters be made in aluminium due to the risk of progressive adhesive failure.

Thickness

Aluminium cut parts are available in a range of thicknesses (gauges).

Thicknesses differ from Plastic and Composite requirements. Metals are stronger and more rigid which means that thinner gauges can be employed successfully.



Sheet sizes

Solid aluminium sheet is available in standard sheet sizes of;

- 2000 x 1000mm
- 2500 x 1250mm
- 1500 x 3050mm

Larger sheets are available subject to a lead time.

Finish

Parts cut from solid aluminium sheeting are delivered in natural Mill finish (Silver).

Mill finish aluminium cannot be used externally without a suitable paint finish. By exposure to air and water Mill finish aluminium will oxidise- creating dark build up and/ or a White chalky finish.



Colours- finishing

Mill finish aluminium parts can be finished in an RAL colour using a Powder Coating process. Powder Coating is recommended over wet spray finishing as it can be much cheaper and Powder Coat is a more durable surface treatment.

Powder coat powders are supplied in 25kg boxes. If you require a colour which is already stocked you will not be charged a minimum powder charge.

If you require a powder colour which is not stocked there will be a powder charge for the full 25kg minimum- irrespective of how much powder is actually needed for your project.

Pantone matching may be possible but is not a guaranteed option.



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 an 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

All fixings **MUST** be applied after powder coating

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

All fixings **MUST** be applied after powder coating

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.

All fixings **MUST** be applied after powder coating



Ordering

When you place your order we will program your job into our schedules. We aim to deliver aluminium flat cut lettering projects as quickly as possible. Standard sheet sizes and gauges should be available ex stock from our suppliers. Custom sheet sizes 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 RAL 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.