

Flat Cut Acrylic lettering overview

Flat cut acrylic lettering is made from sheets of clear and coloured acrylic material. Letters, logos and shapes can be cut using CNC routers and CNC waterjets.

We offer three branded ranges of acrylic.

Perspex- the most widely known acrylic in the UK.

Plexiglas- a German brand widely used in Europe and the US

Repsol- a Spanish brand used extensively in the UK and Europe.



All three brands of acrylic have the same characteristics and are of equal quality. In order to offer you the best possible choice of colours we offer three brands which can be mixed and matched.

Cast or Extruded

We supply Cast acrylic as standard. If you require extruded you must specifically request this type of acrylic.

Most colours are made in Cast format only. You may request extruded acrylic when you are simply working with clear acrylic. Please note that not all thicknesses of clear are available in extruded.

Cast is a higher quality, high performance acrylic with good durability and light fastness. Extruded is a lower quality acrylic which can be used on some clear projects. Extruded acrylics require different adhesives and do not machine as cleanly as Cast acrylics.

Thickness- colours

There are two standard colour thicknesses available;

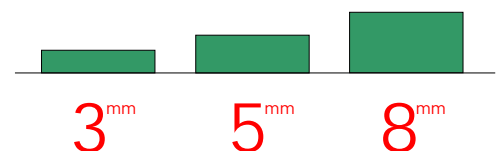
3mm and 5mm.

Both 3 and 5mm letters can be used internally or externally. The thinner 3mm letters are more delicate than 5mm. Large letters 600mm+ are not recommended to be made from 3mm as there may be issues with warping in sunlight.

Naturally the difference between 3mm and 5mm colours is cost- the thicker the acrylic the higher the cost. If you wish to back light your acrylic letters be aware that NOT all acrylic colours are suitable for lighting.

If you require a thicker letter we can supply an 8mm thick coloured acrylic product. This material is Gloss on one side, Matt on the other. This material is not suitable for back lighting.

All coloured lettering, logos and shapes will be made from Cast acrylic by default.



3^{mm}

5^{mm}

8^{mm}

Thickness- clear

Clear acrylics are available in a wider range of thicknesses than coloured.

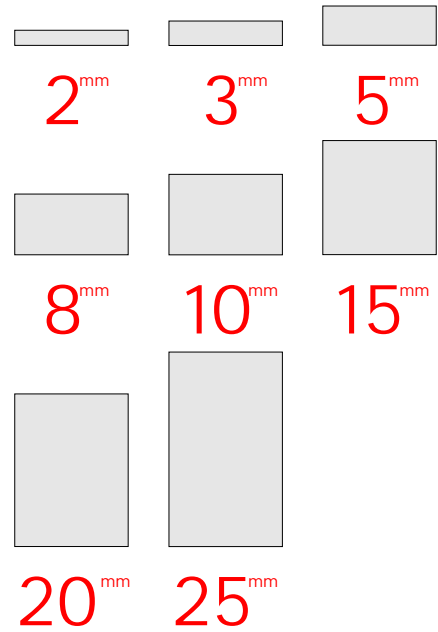
You may specify letters, logos or shapes in any thickness of clear upto a maximum of 25mm thick.

The cost of clear acrylic letters increases in direct relationship to the thickness of the material used.

Clear acrylic with a thickness greater than 10mm require a more complicated machining strategy which is reflected in the price.

Clear acrylic may be waterjet cut subject to sight of artwork.

Continental 4mm thickness is subject to availability.



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 exterior grade acrylic cement. 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).

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.

Colour references & matching

Individual acrylic manufacturers make their own range of colours. These colours are NOT referenced to RAL or Pantone.

Be aware that backlit acrylic normally features a colour difference between illuminated and non illuminated states. Be aware that NOT all acrylic colours will back light.

Perspex and Plexiglas will manufacture custom colours subject to a minimum order of around one metric ton of material.

Repsol may manufacture custom Pantone coloured acrylic subject to a minimum order of 80kg. This equates to x3 full sheets of 5mm acrylic (3050 x2050mm sheets). This may be subject to change and there will be a lead time associated.

Manufacturers do not supply colour swatches in volume which means we are not able to supply every potential customer with a full swatch.

We can normally supply colour chips in colour groups- ie. if you want a Yellow we can send you a selection of Yellow chips. PDF documents with day/ night photographs of Perspex and Plexiglas are available on our website.

If we have full swatches available we can send these to potential customers.

Ordering

When you place your order we will program your job into our schedules. We aim to deliver acrylic flat cut lettering as quickly as possible. Standard colours should be available ex stock from our suppliers. Custom colours and projects which require large quantities of acrylic 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, the thickness 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.