Part I – General

1.1 **Scope**

A. Furnish letters and hardware necessary to install flat cut out (FCO) letters shown on drawings and herein specified.

1.2 Submittals

A. Manufacturer's illustrated product literature and specifications.

B. Installation instructions

1.2 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 Supplier

Toronto Stamp Inc.
120 Midwest Road
Toronto, ON M1P 3B2
Phone: 416-368-7022 or 1-800-637-5813
Fax: 416-368-2478 or 1-800-637-5814
Email: sales@torstamp.com
Web: www.torstamp.com

2.2 Materials (Metal Alloys)

A. Aluminum - 5052 Alloy/5083 Alloy

B. Bronze – 220 Commercial Alloy

C. Brass – No Lead C46400 NAVAL Brass Alloy

D. Copper – C1100 Alloy

E. Stainless Steel – C304 Alloy/316 Alloy

F. Cor-Ten™ Steel

2.3 Finishes

A. Aluminum

1. Natural Satin faces, bead-blasted returns, powder-coated with acrylic polyurethane clear coat, baked.

2. Baked Enamel, bead-blasted returns, sprayed with acrylic polyurethane, baked.

3. Clear Anodized, bead-blasted returns, meets A43 Aluminum Architectural grade anodized finish.

4. Gold anodized, bead-blasted returns, meets A43 Aluminum Architectural grade anodized finish.

5. Medium bronze anodized, sanded return, meets A43 Aluminum Architectural grade anodized finish.

6. Dark bronze anodized, sanded return, meets A43 Aluminum Architectural grade anodized finish.

7. Black anodized, sanded return, meets A43 Aluminum Architectural grade anodized finish.

8. Polished #8, bead-blasted returns, 2-part hardened acrylic polyurethane clear coat.

B. Bronze/Brass/Copper

1. Natural satin stroke sanded face, bead-blasted return, 2-part hardened acrylic polyurethane clear coat, baked.

2. Polished, US9 Finish, hand-polished face, bead-blasted return, 2-part hardened acrylic polyurethane clear coat, baked.

3. Oxidized, NAVY G 88-0-4 lead and mercury free bronze alloy, 2-part hardened acrylic polyurethane clear coat, US10B finish.

4. Green Patina, accelerated oxidation, varies from letter to letter, not uniform.

C. Stainless Steel

1. Natural satin, no clear coat.

2. Polished, no clear coat.

D. Cor-Ten™

1. Natural rust.

Note: Flat Cut Metal Letters do not have polished returns.

2.3 Mounting Hardware

A. FCO metal letters are drilled & tapped for stud insertion. Letters 1/8" thick are plain or have threaded stud bosses.

B. All aluminum letters use aluminum studs, type based on stroke and thickness. 10/24 is standard.

C. All other letters use stainless steel studs.

2.4 Fabrication

A. Letters shall be made of_____.

B. Letter shall be _____ letter style and shall be _____ inches high, as indicated on the drawings.

C. Finish shall be_____.

D. Mounting shall be _____ and a mounting template designating stud locations is/is not required for mounting on a _____ surface.

Part III – Execution

3.1 Installation

A. A qualified installer shall install FCO letters.

3.2 Warranty

A. Letters should be guaranteed for the life of the business against defects.