

# FAB ALUMINUM - Face Lit

PRODUCT STANDARDS

LAY-PS-8  
revised 11/22/2023  
by Jenna Weiers

## Removable Face (Shoebox)

Letters		Bottom Stud		Bars		Logos	
Depth	Min Stroke & Serif	Max Stroke	Min Size*	Max Size	Min Punctuation	Max Size	Max Area sq. in.
2" No LED	2"	12"	16"	48"	2.75"	30"	2,304
3" *	2"	12"	16"	60"	2.75"	48"	3,600
3.5" *	2"	12"	16"	60"	2.75"	48"	3,600
4"	2"	12"	16"	60"	2.75"	48"	3,600
5"	2"	12"	16"	60"	2.75"	48"	3,600
6"	3"	12"	16"	60"	2.75"	48"	3,600

\*6" high &amp; up recommended 4" depth

\* 12" paired with other letters or logos exceeding 16" (all other min. specs must be met as well)

## Removable Can

Letters		Bottom Stud		Bars		Logos	
Depth	Min Stroke & Serif	Max Stroke	Min Size*	Max Size	Min Punctuation	Max Size	Max Area sq. in.
2" No LED	2"	12"	16"	48"	2.75"	30"	2,304
3" *	2"	12"	16"	48"	2.75"	48"	2,304
3.5" *	2"	12"	16"	48"	2.75"	48"	2,304
4"	2"	12"	16"	48"	2.75"	48"	2,304
5"	2"	12"	16"	48"	2.75"	48"	2,304
6"	3"	12"	16"	48"	2.75"	48"	2,304

\*6" high &amp; up recommended 4" depth

\* 12" paired with other letters or logos exceeding 16" (all other min. specs must be met as well)

## Sheet Info

### Horizontal Brushed

42"h x 72"w or 119"h x 36"w  
+100" will not have clear coat

### Vertical Brushed

72"h x 42"w or 36"h x 119"w  
+100" will not have clear coat

### Painted

59"h x 100"w

### Prep for paint

59" x 119"

### Returns (Alum)

Grain runs front to back  
(Short Direction)

### Face Material

\* 0.5" minimum stroke  
required for assembly

### Material Gauge

Face	.09"
Returns	.063"

## Miscellaneous

No Custom Stud Placements

Logos exceeding max letter size  
will require added stiffeners

Panels over max letter size  
will warp

Removable Can or Face  
required on 40"+

## Recessed Insert

	Outside Depth	Inside Depth	Stroke
Min	3"	0.5"	1.75"
Max	4"	1"	1.75"

## Acrylic Insert

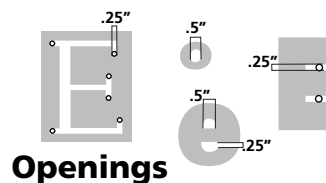
Inline .25"

Fillet Inside & Outside .025"

Thickness .187"

## Rails - Painted or Raw

	Size H x W	Length
C-Chan	1" x 2"	96"
C-Chan	.5" x 1.5"	96"
C-Chan	1" x 3"	96"
C-Chan	.5" x 1"	96"
C-Chan	1" x 1.5"	96"
Angle	1" x 2"	96"



## Openings

Straight Return .25"

Curved Return .5"

This is a general rule and  
depends largely on the  
shape of the opening.

## Face Outline

Up to 48" H .75"

49" H and above 1"

In all the cases when the  
stroke is 10" and above the  
outline needs to be 1"

## INTRANET LINKS

[Fabricated Aluminum](#)

[UL & LED Info](#)

## LED



Wire hole .375"

Standard LED .5" x 1.8"

RGB LED .625" x 2.75"

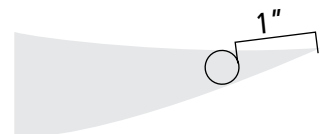
Cable 10' Long Standard

## RGB LEDs (Face Lit)

Min Stroke	Min Size	Min Return	Min punctuation
3"	16"	3"	3"

## Swoosh

### Pointed Tip



.6" stroke needed 1" in from tip  
-return will have a slight inset-

-OR-

### Round Tip



Outside Corners .3" Fillet

No more than 3/4" overhang on  
inset swoosh