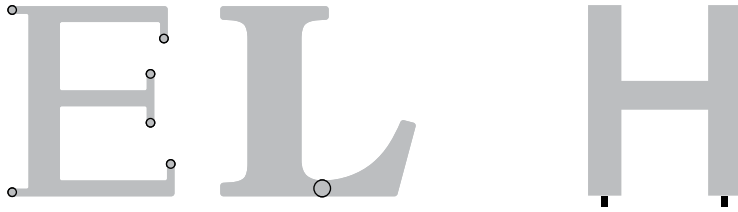


FAB ALUMINUM - With Backs

PRODUCT STANDARDS

LAY-PS-4
revised 1/7/2025
by Jenna Weiers



Letters

Depth	Min Size	Max Size	Min Stroke & Serif
1.0"	12"	30"	1.75"
1.5"	12"	30"	1.75"
2.0"	12"	60"	1.75"
3.0"	12"	60"	2"
3.5"	12"	60"	2"
4.0"	12"	60"	2"
5.0"	12"	60"	2"
6.0"	12"	60"	3"

Bottom Stud

Min Punctuation
2.75"
2.75"
2.75"
2.75"
2.75"
2.75"
2.75"
2.75"

Bars

Max One Piece
40"
48"
48"
60"
60"
60"
60"
60"

Max Area sq. in.
900
900
3,600
3,600
3,600
3,600
3,600
3,600

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

Anod Horiz

42"h x 72"w or 84"h x 36"w

Anod Vert

72"h x 42"w or 36"h x 84"w

Painted

59"h x 100"w

Prep for paint

59" x 119"

Returns (Alum)

Grain runs front to back
(Short Direction)

Alum Assembly

Requires additional structure
Nothing over max letter size

Backers

	Thickness	Gap
Light Diffused	.177"	.06"-.013"
Clear	.118"	.06"-.013"

Default is Light Diffused

Removable Backs are

Recessed 1/8"

Non-Removable Metal

Backs are Flush

Weep Holes are 3/8" Square
in Low Point Corners

Miscellaneous

1/4" Stokes for masking

No Custom Stud Placements

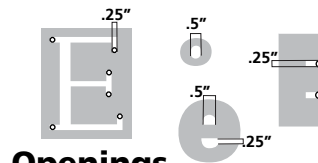
Removable can required on 40"+

Logos exceeding max letter size
will require added stiffeners

Panels over max letter size
will warp

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"**

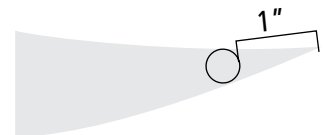
This is a general rule and
depends largely on the
shape of the opening.

Material Gauge

Face	.09"
Returns	.063"

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

INTRANET LINKS

[Fabricated Aluminum](#)