

Sign Fab's Sign Industry Reference Guide: Chapter Four

Chapter Four of our Reference Guide covers all the necessary parts to a finished sign project. From the faces, to the mounting, we'll cover everything that goes into your sign and why it's important. This will serve as a complete guide to your sign, but if you ever have any questions, don't hesitate to contact our sales team at (800) 544-6381 or e-mail us at signfab@signfab.com.

Face

The face of any sign is the first part manufactured. Here at Sign Fab, we use $\frac{3}{16}$ " acrylic for our channel letter signs and logos and .090 aluminum for reverse channel signs. For cabinets, we use a standard .063, .080, or .125 aluminum depending on the construction necessary. There are many standard colors available to choose from. If you haven't received a copy of our 2014 SIGN Guide catalog, feel free to request one on our website [here](#) or simply call us. To view these color options, see page 21 in our catalog or view our virtual online catalog by following [this link](#). If you can't find the color you like, you may also choose a vinyl color, located on [page 23](#), or even send in an image for the digital print logos.



Trim

Our trim is a standard size of $\frac{3}{4}$ " to 1" and is also available in many different colors. Our color options are available on page 24 of our recent catalog, or you can click [here](#) to view this page online. Trim is not necessary on reverse channel signs or cabinets. We use a high-quality glue to adhere the trim to the faces.

Return

The return may either be prefinished or welded. Prefinished return for most channel letter signs is 5". Our welded return standards are 2-8" for non-illuminated, 3-8" for open channel neon, and 5-8" for LED-illuminated signs.

For reverse channel signs, we only use welded construction. The standard depth of our reverse channel return is anywhere from 2" to 8" depending on the construction and the specifications. For all sign types, we use a standard .063 gauge aluminum metal. You can find the available [return color options](#) on pages 25 and 26 of our catalog.

Back

The backs of our channel letter signs are a standard .050 or .063 aluminum with CNC cut mounting holes. The backs of non-illuminated reverse channel signs are either .050 or .063 aluminum, and the backs of our illuminated reverse channel signs are $\frac{3}{16}$ " polycarbonate. To fasten the backs to the return, we use staples for preformed channel letter signs, welding for non-illuminated reverse channel, and use mounting clips for illuminated reverse channel signs.



LED

Our standard LEDs are the Principal LED Fusion 2 Series. At two modules per foot, they are available in white, red, blue, green, orange, and amber. We do have other brands and series available for special circumstances and customer requests. The Fusion 2 Series LEDs have VHB tape on the back of each module, and we also silicone the modules to the backs of the sign to ensure they will stay in place for the life of the sign. For reverse channel signs, the LEDs are attached to the backs facing inward to create the perfect halo effect. If the LED color options available do not suit your reverse channel sign project, we can also place vinyl on the polycarbonate back to offer a wider variety of color options. Our standard LEDs come with a 5-year product warranty and a 2-year labor warranty.

Power Supply

For most sign projects, we use a standard 12-volt, 60-watt power supply. If requested, we offer a 60-watt, 277-volt power supply. Our standard power supplies, both 12-volt and 277-volt, offer a 2-year product warranty. For raceway-mounted signs, we use 16-gauge red and black wire, and for remote signs, we use an insulated 18-gauge red and black wire.



Mounting

Our channel letters signs are generally either raceway-mounted or remote. Here at sign fab, we offer two different types of raceways: extruded or fabricated. Our extruded raceways are 7" tall by 4.5" deep by the appropriate length. Our fabricated raceways are made from .050 aluminum with a 1" square tube frame and are 7.25" tall and deep by the length of your sign. Our mounting brackets for our extruded raceways are made from .25" x 2" aluminum and are adjustable while our fabricated raceways include mounting brackets that are made from .25" x 1.5" aluminum flat bar. The mounting brackets are placed every 5' or as needed to support the sign.

Our cabinets may include pole wells, ³/₈" nutserts, and/or ¹/₂" mounting holes as necessary for installation. Our reverse channel signs can either be mounted to an oversized raceway, a backer panel, or simply be manufactured as a remote sign. We use ¹/₄" or ³/₈" nutserts and ¹/₄" mounting holes as a standard for our reverse channel signs.

We hope you've found this Tip of the Month valuable. If you ever have any questions about how our signs are manufactured, don't hesitate to contact our sales staff, and they'll be able to answer all of those questions for you. Thank you for reading, and keep reading our newsletters for future Tips!