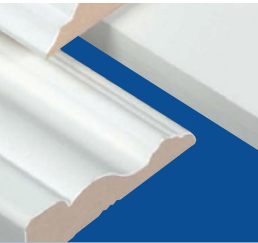


GENERAL INSTALLATION INSTRUCTIONS

MDF MOULDINGS



Tools for the Job : You will need a pair of safety glasses or goggles, tape measure, hand back saw or power saw with a sharp carbide-tipped blade, miter box copingsaw, hammer (or pneumatic nailer) and nail set (1-1/4" – 1-1/2" long), and non-shrinking caulk or putty (to fill the nail holes and for minor touch-ups).



Measuring Mouldings : The first step is to determine how much MDF Moulding is needed. Measure the length of each wall rounding up to the next foot. On the ends that will be mitered to fit an outside corner or around a door and window opening, add the measurement of the width of the MDF Moulding to the length of the wall that is to be mitered. For example, when using a 4-1/4" wide piece of casing on a 36" wide doorway which requires a miter at each end, add 8-1/2" to the 36" opening for a 44-1/2" total length.



Mitering, Splicing and Coping : Truchoice MDF Mouldings make mitering or splicing easy. Start by cutting and fitting outside miters, then fit the inside corner by mitering or coping. Use a carbide-tipped power miter, saw or hand back saw with a miter box to cut miters. For splicing long runs of MDF Moulding, cut both pieces at a 45° angle and glue both ends before butting together and nailing in place. Coping can be used when butting MDF Mouldings at an inside corner. One piece is cut to fit flat to the wall corner at a right angle and the adjoining piece is sawed to fit the face profile of that piece.



Cutting : A triple-chip carbide finishing blade produces a beautiful chip free finish. Crosscut carbide blades also produce acceptable results. Rip or steel blades are not recommended.

Truchoice MDF Mouldings are easy to rout and shape with woodworking tools and equipment. Cut MDF Mouldings with a fine-toothed hand saw or power saw. Use sharp chisels or gouges to carve MDF Mouldings ends to scribed shapes. Rebates are easily machined into MDF Mouldings using power routers. Care should be taken when cutting or shaping, to avoid damage to the primed surfaces. Cut ends should be sealed with a primer or a PVA adhesive to minimize moisture uptake

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Applications : Truchoice MDF Mouldings are intended for dry interior use where a paint finish is specified. They should not be used externally or in high-moisture areas around baths, saunas or shower recesses. The moisture content of the MDF Moulding should be maintained below 16%. Typical applications are as skirting, door jambs and architraves.



Moisture Content and Acclimatization : Like all wood products, Truchoice MDF Mouldings change dimension with changes in moisture content. As moisture content increases, dimensions grow and as moisture content decreases, dimensions shrink. If MDF Mouldings are installed with high moisture content, subsequent shrinkage may lead to the appearance of paint cracking or gaps at joints and mitres. The following guidelines should be followed to avoid or minimize the effects of shrinkage:

- a. Do not store outside or in damp conditions.
- b. Do not store directly on floors, especially bare concrete.
- c. Leave in wrapped bundles until approximately 48 hours before installation.
- d. Unwrap bundles 48 hours before installation and stack individually indoors to allow free circulation of air and adjustment of moisture content.
- e. Wherever possible, acclimatize MDF Mouldings in the room where they are to be installed.

Truchoice MDF Mouldings are manufactured at lower moisture content than will be experienced in most indoor environments. As such, shrinkage is almost always the result of substandard storage and acclimatization. The effects of shrinkage can also be minimized during installation by nailing, stapling or gluing to manufacturers recommendations.

Shrinkage is always a potential issue on a major project with any MDF Moulding. We suggest taking all necessary precautions to prevent the possible absorption of moisture while on site. We also recommend gluing all joints in an effort to further seal the product.

Heat and Air Conditioning, which is not in use at time of installation, can seriously affect the amount of expansion and contraction MDF Mouldings will have. Please take this into account at the time of installation.

Truchoice MDF Mouldings are wood products and, as with all wood, it can absorb and desorb moisture with changes in relative humidity. Like all wood products, you will experience some expansion and contraction of MDF Mouldings and MDF products in general. Interior humidity can fluctuate between 40% to 80% and under these conditions, MDF Moulding can move by 0.3%. In order to lessen the visual effects of the movement of the MDF Moulding it is strongly recommended to apply a bead of PVA glue and a braid nail through the top of the joint down to keep the miter together.

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Damp Buildings : Truchoice MDF Mouldings are a wood-based product and some dimensional movement can occur in response to changes in relative humidity. MDF Mouldings should not be fixed to new cement rendered walls or walls which are permanently or intermittently damp. The cause of moisture must be corrected and the walls allowed drying before installing. It is strongly recommended not to fix MDF Mouldings to damp plaster or any other damp materials. It is important when installing any MDF moulding that you allow about a 1.5 mm gap to avoid the joint from being too tight. A coped joint or a 45° miter can then be caulked and the seam is now complete



Fastening : A variety of automatic fastening equipment can be used to install Truchoice MDF Mouldings. Best results are obtained using 15 to 18 gauge brad and pin nails. Air pressure should be 90-110 psi to countersink the nail 1/16" into MDF Mouldings.



Gluing : Most modern glues and panel adhesives work well to fix MDF Mouldings with adhesive. PVA adhesive (children's white glue) should be used to secure joints or when laminating MDF; yellow carpenter's glue is not recommended. Glue manufacturer's recommendations should be followed in cases of porous damp surfaces, but we don't recommend to fix MDF Moulding on a damp material.



Filing : White Lightning or similar light-weight sanded auto body filler is recommended for filling straight joints or casing corners. Inside corners should be caulked using any good quality, paintable latex caulking. Silicone caulking is not recommended.

GENERAL INSTALLATION INSTRUCTIONS MDF MOULDINGS



Sanding (Optional) : 80 Grit garnet paper is recommended for most sanding applications. Dynamic course/medium double-sided sanding sponges are very good for sanding profiled surfaces.



Top Coat : The super smooth, primed surface of Truchoice MDF Mouldings is ideal for perfect finishing results and will accept any good quality alkyd or latex finish, for most architectural applications. High or semi-gloss finishes provide a more durable finish and are easy to clean.

Lightly sand any putty-filled nail holes or caulked joints with a 220 grit open coat paper or steel wool for best results.

Always read your paint manufacturer's recommended temperature range for painting and comply with their recommendations.



Brick Walls : The following are not permanent solutions to adhere MDF Mouldings to brick walls. OCM's adhesives (one component mastics) need to be applied on a perfectly dry surface in order for MDF Mouldings to adhere to brick. Even if the surface is dry, the initial grab is very poor and thus needs to be supported or tacked in with small panel pins which bring you back to square one, nailing MDF Mouldings to brick in stead of adhering MDF Mouldings to brick.

An easy solution to adhering MDF Mouldings to brick is using a hybrid polymer adhesive like the CT1 adhesive. When the bond has been made between MDF Mouldings and brick, CT1 will remain flexible and will expand and contract with the joint. CT1 contains no solvents therefore will never shrink or attack the MDF Mouldings. For more information, please visit the following website: www.ct1ltd.com

The use of BISON adhesive is also recommended on dry brick or concrete walls.

It is also recommended to apply concrete nails using a nail driver to improve adherence of MDF Mouldings to concrete walls.

For more information contact us at panels@arauco.cl