



PrimeCraft Mouldings® by Prime-Line, Inc.

It is extremely important to climatize PrimeCraft mouldings for a period of up to 48 hours prior to installation. Mouldings should be laid out around the room where installation will occur. It is important that MDF or LDF mouldings are never stored lying directly on a concrete floor. It is best to make sure PrimeCraft mouldings, upon delivery to a job site, are off loaded and stacked using some type of stickers or 2 x 4's to eliminate direct ground contact.

Installing PrimeCraft Mouldings®

Many fastening systems are used for assembling PrimeCraft products into finished products. For greater strength, joints should be designed and machined to utilize as much of the board's outer surface as possible rather than the edge. For example, tenons should be machined off center and compound miters are recommended when joining two pieces together. Carbide tools are highly recommended when machining MDF. They provide cleaner cuts and have much longer life before re-sharpening is required. Assembly methods include the use of glues, nails, brads, screws, or staples. When installing with screws, a pilot hole is strongly recommended. Screw holding strength increases more with depth rather than the diameter of the screw. PrimeCraft boards hold screws as well as most natural woods. ANSI minimum values are shown on the right along with some typical values for wood. Our mouldings will exceed these minimums by several pounds. Nails and staples are also an excellent method of applying our moulding. If using pneumatic nailers, the recommended air pressure should be between 90 and 100 PSI. Installers should always test fasteners and air pressure before going into full production. The best fasteners are brads and angle nails in gauges from 15 to 18.



Screw Holding Values for Wood

| | Face | Edge | Both |
|-------------------|-------|------|------|
| Western Red Cedar | 285 | 295 | 290 |
| Western Hemlock | 320 | 320 | 325 |
| White Fir | 275 | 285 | 280 |
| MDF 3/4" | 325 ± | 250+ | 300 |
| Douglas Fir | 350 | 385 | 365 |
| Ponderosa Pine | 305 | 370 | 340 |
| Fir Plywood | 366 | 318 | 342 |
| Red Oak | 656 | 657 | 657 |
| Red Alder | 582 | 462 | 522 |
| Black Walnut | 622 | 554 | 598 |
| Black Cherry | 815 | 824 | 280 |

Minimal Screw Pull Values for MDF

| | Face | Edge |
|---------|---------|---------|
| Board ≤ | 325lbs. | 250lbs. |
| Board > | 300lbs. | 225lbs. |

MDF Pilot Hole Size

| Screw No. | Pilot Hole Drill Gauge No. | Hole Diameter (inches) |
|-----------|----------------------------|------------------------|
| 0 | 66 | 0.033 |
| 1 | 57 | 0.043 |
| 2 | 54 | 0.055 |
| 3 | 53 | 0.059 |
| 4 | 51 | 0.067 |
| 5 | 47 | 0.078 |
| 6 | 44 | 0.086 |
| 7 | 39 | 0.099 |
| 8 | 35 | 0.0110 |
| 9 | 33 | 0.113 |
| 10 | 31 | 0.120 |
| 11 | 29 | 0.136 |
| 12 | 25 | 0.149 |
| 14 | 14 | 0.182 |
| 16 | 10 | 0.193 |
| 18 | 06 | 0.204 |
| 20 | 03 | 0.213 |



General Installation Instructions

When edge nailing, the use of a fine wire gauge nail or staple will generally alleviate any problem when fastening the edges. Wire gauges under 14 are recommended for edge fastening. Coated staples hold better than smooth staples. Nails and staples should be driven at right angles to the surface. Excessive pressure may produce objectionable tool marks or splitting.

Senclamps are an excellent method for fastening corners and butt joints. Seams should have a bead of glue applied to a clean miter cut and then fastened by nailing a brad or angle nail through the top of the joint down. This method will tighten the joint and pull the miter tight. Do not use T-nails or large staples in this application.



The coped joint or 45° miter can then be caulked and the seam is now complete. ("Big Stretch" caulk by Sashco Sealants is recommended to use to complete the joint). PrimeCraft Mouldings are a wood product and, as with all wood, it can absorb moisture. Interior humidity can fluctuate between 40% to 80% and under these conditions, MDF, LDF, or PrimeCraft mouldings can move by .3 percent. You will experience some expansion and contraction of MDF mouldings and MDF products in general. In order to lessen the visual effects of the movement of the moulding it is strongly recommended to apply a bead of carpenter's glue and a brad nail through the top of the joint down to keep the miter together and finish it off with a pliable caulk like "Big Stretch". PrimeCraft mouldings are pre-primed exclusively with a specially formulated Sherwin Williams water-based primer. The primer is formulated to accept water or oil based top coats. A light sand with a 220 grit or higher sand paper or sponge should be done before applying the finished coat to achieve the best results.

IMPORTANT:

It is important to read the paint manufacturer's recommended temperature range for painting and comply with their recommendation when painting PrimeCraft products.

Please call your distributor if you have any additional concerns regarding the use or installation of PrimeCraft Moulding products.



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