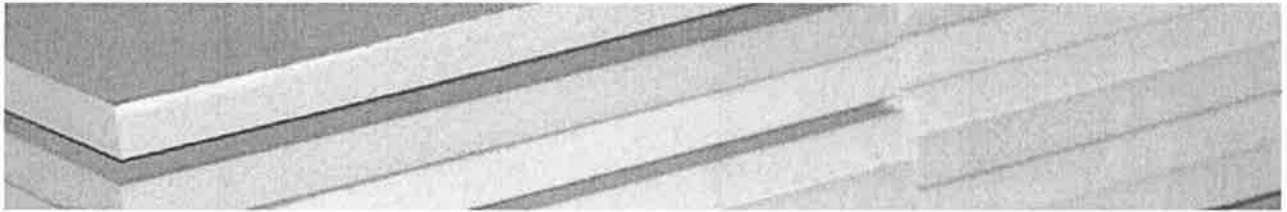




# Prime-Line, Inc.

Doors, Mouldings, & Millwork

## GENERAL INSTALLATION INSTRUCTIONS



Prime-Lite® by Prime-Line, Inc. – It is extremely important to climatize Prime-Lite 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 Prime-Lite 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.

Fastening Prime-Lite – Many fastening systems are used for assembling Prime-Lite 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 dowel butt, miter, rabbet, dovetail, and dados. Typically, the builder or installer should use as much of the board's outer surface as possible. Assembly methods include the use of glues, nails, brads, screws, and staples. When installing with screws, a pilot hole is strongly recommended. Screw holding strength increases more with depth than the diameter of the screw. Prime-Lite holds screws as well as most natural woods. ANSI minimum values are shown on the left along with some typical values for wood. Prime-Lite will exceed these minimums by several pounds. Nails and staples are also an excellent method of applying Prime-Lite. If using pneumatic nailers, the recommended air pressure should be between 100 and 110 PSI. Installers should always test fasteners and air pressure before going into full production. The best fasteners are brads and pin nails in gauges from 15 to 18. When edge nailing, the use of a

### Screw Holding Values for Wood

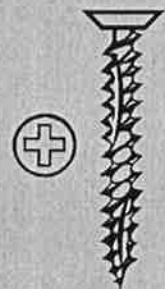
	Face	Edge	Combined
Western Red Cedar	285	295	290
Western Hemlock	320	320	325
White Fir	275	285	280
MDF 3/4"	325 ±	250+	300
Douglas Fir	350	385	365
Ponderosa Pine	305	370	340
Fir Plywood	366	318	342
Red Oak	656	657	657
Red Alder	582	462	522
Black Walnut	622	554	598
Black Cherry	815	824	280

### 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	0.110
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



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.

Miter Corners – Senclamps are an excellent method for fastening Prime-Lite corners and butt joints. Another method is to add a bead of glue to a clean miter cut and then fasten with a brad or pin 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.

Sawing, Drilling and/or Mitering—Carbide tools are highly recommended when machining Prime-Lite. They provide cleaner cuts and have much longer life before sharpening is required.

#### Installing & Finishing Prime-Lite:

Installing – It is important when installing Prime-Lite or any MDF moulding that you allow about a 1/16 of an inch 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. (“Big Stretch” caulk by Sashco Sealants is recommended to use to complete the joint.) Prime-Lite is 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 Prime-Lite 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 carpenters glue and a braid nail through the top of the joint down to keep the miter together.

Finishing – Prime-Lite mouldings are pre-primed exclusively with a specially formulated Valspar primer. Our special water based primer seals Prime Lite from emitting formaldehyde by almost 95.8%. Please see ANSI standard A208.2-1994. ANSI standards are even more stringent than those required by the U.S. Housing & Urban Development Administration (HUD). Prime-Lite’s water based primer provides far more job site protection against mold abuse than all the other latex primers currently on the market.

**IMPORTANT:** It is important to read the paint manufacturer’s recommended temperature range for painting and comply with their recommendation when painting Prime-Lite products.

Please call Prime-Line if you have any additional concerns regarding the use or installation of Prime Lite products.



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