

### Storage & Handling

- Store product on a flat, level surface to prevent warping.
- Handle the product with care as you would with wood to avoid damage.
- Protect Fypon Cellular PVC Trim from debris and dirt. If product becomes dirty, clean after installation.

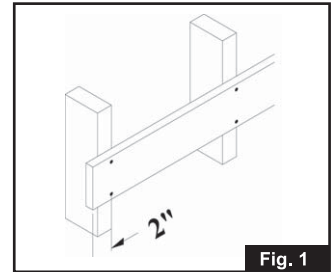
### Machining

- **Cutting:** For the best results, use blades that are designed for cutting wood or plastic. Carbide tipped blades work best and are recommended, however, rough-cut blades for wood or plastic may be used. Do not use fine tooth blades, as excessive heat build-up from friction can occur.
- **Drilling:** For best results, use standard wood or metal drill bits. Care should be taken to avoid heat build-up from friction. Occasional removal of shaving may be necessary. Drill bits designed for drilling rigid PVC pipe should not be used.
- **Routing:** Use standard router bits for machining the product. Multi-fluted carbide bits are highly recommended. Routing the product can leave a surface that is somewhat rough. Sanding and painting creates a more acceptable surface.

### Fastening

- For best results, use stainless steel, smooth shank, screw, annular threaded, or spiral type nails. Hot dip galvanized may also be used. Make sure the fastener has sufficient tensile strength to prevent bending. Ring shank nails should not be used as they can create excess frictional heat when penetrating the product. Staples are not recommended.
- The fastener should be long enough to penetrate the substrate a minimum of 1".
- Power nailers work well with this product but should be adjusted to prevent overdriving the nail into the material. This will prevent excessive nailing pressure which can result in cracking.
- Pre-drilling is only recommended when using large fasteners or when installing the product in temperatures below 40°F.
- When installing, nail from one end and work to the other end. **Never nail from both ends to the middle.**

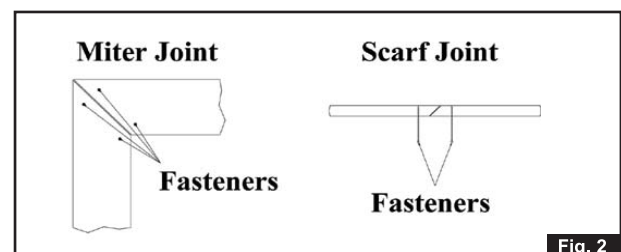
- For best results, use two fasteners per framing member for trim board applications. Trim board wider than 12" as well as sheets will require additional fasteners. Fasteners must be installed no more than 2" from the end of each board (see Fig. 1).



- Proper fastening is important in limiting expansion and contraction. It is recommended that a minimum of 16" on center nailing pattern be used to help restrict seasonal movement of this product.
- It is recommended that nails are kept 3/4" away from the board edge and staggered slightly. Staggering the fasteners reduces the chances of cracking along the line of fasteners as the material expands and contracts.

### Gluing

- All joints should be glued to prevent joint separation. Numerous adhesives are available to use for gluing this product, but **Bond & Fill™ Adhesive** is recommended for the best results. It is also recommended that fasteners be used on each side of the joint to allow adequate bonding time (see Fig 2). Whenever possible, construction adhesive should be applied to the back side of the trim at the joints. This will help hold the trim at the joints, forcing it to expand and contract in the center, preventing unsightly gaps at the joints.
- For best results, surfaces to be glued should be smooth, clean and have complete contact with each other.
- When bonding together two smooth or non-machined surfaces of the PVC board it is recommended that you clean the surfaces with acetone.
- On long lengths of trim, like corner boards or fascia, a scarf joint (opposing 45-degree bevels) should be used (see Fig. 2).



- A variety of adhesives are available to bond this product to specific substrates. Read the adhesive label or consult the manufacturer to determine which adhesive is most suitable. It may be best to test the application for suitability before proceeding.

### Expansion & Contraction

- This product expands and contracts with changes in temperature. To minimize this characteristic the recommendations given in the **Fastening** and **Gluing** sections should be followed.
- When installing this product allow 3/16" per 18 foot for expansion and contractions. Remember that it is recommended that all joints be glued and where possible, fastened to the substrate to prevent joint separation. See the **Fastening** and **Gluing** sections for recommendations.
- It is recommended that a urethane acrylic sealant (Benjamin Moore® - Moorlastic 55 year urethane acrylic sealant 465, Siroflex Duo-Sil® urethane acrylic sealant and adhesive, OSI® Pro-Series H2U acrylic urethane sealant) be used to fill any gaps. This sealant expands and contracts at approximately the same rate as the product.

### Spanning

- **This product is not to be used in load bearing applications.**
- If it is to be used as fascia, a structural sub fascia should be applied first.
- It may be used in spanned applications for soffits and ceilings. For spans 16" - 24" it is recommended to use 1" thick board. When thinner product is used the span should not exceed 16". If the product is installed in temperatures 40 degrees or less the span should not exceed 12". Under no circumstances should the span distance for any of this product exceed 24".

**The installation suggestions presented are to be used only as a guideline. Fypon, Ltd. assumes no liability for any damages, including but not limited to personal, property, incidental, or consequential damages, resulting from the installation of its product. Fypon's sole responsibility in connection with the sale and installation of its products is as stated in the Limited Warranty.**

### Finishing Preparation

- For small blemishes, fill holes using **Dap® Fast and Final Exterior Spackling** or any other comparable product. Any holes (larger than the size of a dime) or gaps should be filled using a urethane acrylic sealant as mentioned in the **Expansion & Contraction** section.
- Remove any rough areas by sanding. Note that once the product is sanded or machined, the original surface may have been removed. In this case, a slightly textured surface can be revealed. Painting will cover this texture.

### Painting

- This product does not require painting but may be painted to achieve a custom color.
- Use a 100% acrylic latex paint (Sherwin Williams® Super Paint Exterior Latex Satin or comparable paint) with a **Light Reflectance Value (LRV) of 55% or higher**. Whites and bright yellows have the highest LRV, while black and bright blues have the lowest LRV. Paints that have a lower LRV will absorb light, which carries heat, and will warm up the product. Paints that have a higher LRV will reflect light (and therefore heat) and will reduce or eliminate this effect. Most paint manufacturers can provide a LRV of any color paint chip. **NOTE: Using paint with a LRV of 54% or lower will void the warranty.**
- Follow the paint manufacturer's recommendations for applying their paint.