Light and Ultralight MDF MOULDING

arauco MOULDING

na.arauco.com

GENERAL NSTALLATION AND HANDLING

Acclimate MDF Moulding

It is extremely important to climatize, or in other words to acclimate, Light and Ultralight MDF moulding for a period of up to 48 hours prior to installation. Moulding should be laid out around the room where installation will occur. It is important that MDF or LDF moulding are never stored lying directly on a concrete floor. It is best to make sure the MDF moulding, 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. Always store MDF moulding indoors in an area that is clean, dry and well ventilated.

Installing Moulding

Many fastening systems are used for assembling ARAUCO MDF moulding 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. MDF Moulding hold screws as well as most natural woods. ANSI minimum values are shown on the right along with some typical values for wood. Our moulding 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.

WARNING

Drilling, sawing, sanding or machining wood products can expose you to wood dust, a substance known to the State of California to cause cancer.
Avoid inhaling wood dust or use a dust mask or other safeguards for personal protection.

For more information go to **www.P65Warnings.ca.gov/wood**

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 Fir	305	370	340
Plywood	366	318	342
Red Oak	656	657	657
Red Alder	582	462	522
Black Walnut Black	622	554	598
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) 0.033
0	66	
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

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Nails and Staples

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.

Corrugated Fasteners

Corrugated tools and fasteners provide 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.

Elastomeric Sealant

To complete the coped joint or 45º miter, finish with an elastometric sealant such as Big Stretch® brand by Sashco, Inc.

Expansion and Contraction

ARAUCO MDF Moulding 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, the MDF moulding can move by .3 percent (.003).

- You will experience some expansion and contraction of MDF moulding 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, and finish it off with an elastometric sealant like Big Stretch, as described above.

Big Stretch is a trademark of Sascho, Inc.

Primer

ARAUCO MDF moulding are pre-primed exclusively with a specially formulated primer. To achieve the best results, a light sand with a 220 grit or higher sand paper or sponge should be done before applying the finished coat. Follow the top-coat manufacturer's instructions when applying the finish.

IMPORTANT:

- **It is important to read the paint manufacturer's recommended temperature range for painting and comply with their recommendation when painting ARAUCO MDF moulding products.**
- **Please call your distributor if you have any additional concerns regarding use or installation.**

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