

## Guidelines for gluing profile to vertical surfaces

Profile can be adhered directly to a wall using the instructions below. Recommended substrates are: painted dry-wall, painted wood or sealed wood. These instructions are for directly adhering Profile Panels.

## Materials Needed

### CUSTOMER SUPPLIED

- 1" wide foam brushes

### ADHESIVES NEEDED

- 3M Primer 94, 3form part #3-05-0072 (1 can for every 25ea. 4x8 sheets of material)
- 3M VHB 4496 (Double sided foam tape) 3form part # 3-20-313 (1 roll for every 2 sheets)
- Momentive SCS 1201 Structural silicone 3form part # 3-05-0070 (1 tube for every 2 sheets) or Liquid Nails LN-903
- Extruded aluminum support angle (part# 3-15-1320) This angle must be used for any material over 1/4" thick. See example diagram on next page.

- Apply the VHB tape over the areas that you primed and use a J-roller to roll the VHB tape down which will make it bond instantly.
- Use Momentive silicone or Liquid Nails to place dabs on the back of the panel per the sketch
- **REQUIRED FOR 3FORM PROFILE PANELS:** Determine where the vhb tape will bond to the wall and apply a thin layer of Primer 94 to the wall and let flash off. Be careful when applying the sheet to the wall as once it sticks, it will not come back off.
- For full sheets, it will be important to have 2 people to help attach the sheets to the wall. Rest the bottom of the sheet on the aluminum angle and then as you raise the sheet up, make sure it is plumb before it sticks.
- Use your hand or a J-roller to apply pressure to the areas where the VHB is placed to assure the best bond.
- Repeat process on subsequent sheets.

## Installation Process

### ATTACHING THE ALUMINUM SUPPORT ANGLE (REQUIRED)

All Profile panels **MUST** be supported at the bottom of the panel. Support must be attached structurally and level to the wall. Make sure to countersink screws into the angle so they do not stick out and damage the sheet.

- Determine location of studs in the wall where sheet will be adhered.
- Predrill and countersink the aluminum to line up with the studs.
- Screw the angle to the wall making sure it remains level.
- This angle will help support the material as well as give you a ledge to rest the sheet on to aid in alignment when gluing panels to the wall.

### GLUING AND ADHERING PROCESS

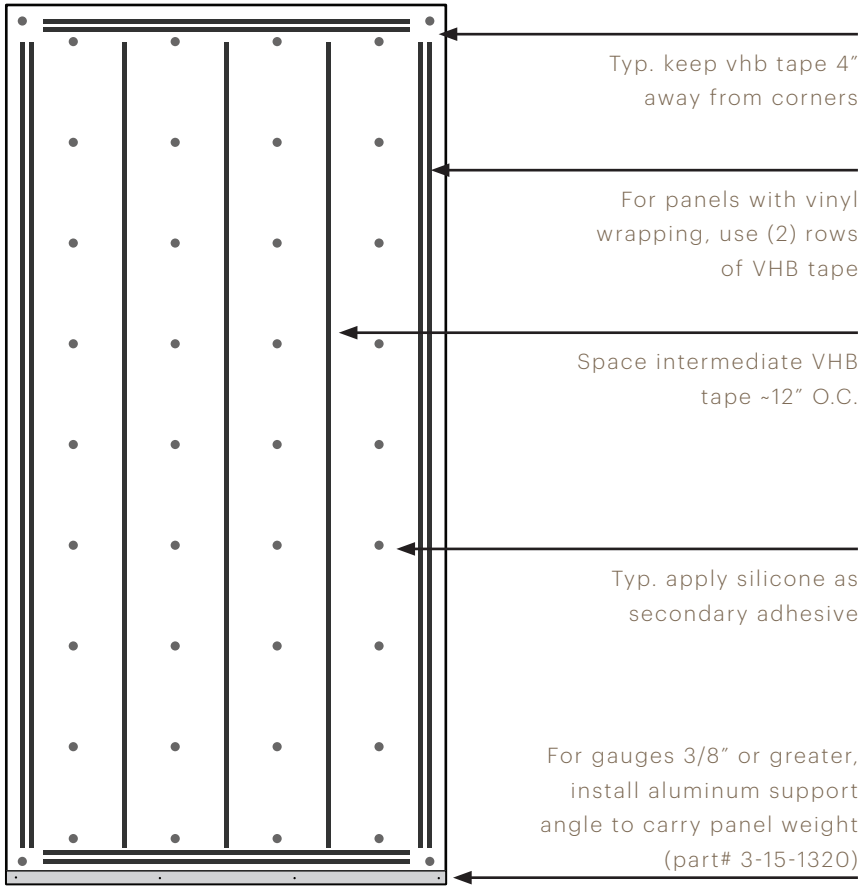
- These sheets will likely be bowed due to the amount of material machined off the face of the MDF.
- Lay sheet face down on a clean, dry, supported surface. Make sure not to scratch or scuff the sheet.
- For best results, apply 2 layers wide of the VHB tape (refer to diagram on page 2) around the perimeter of the panel.
- Determine the layout of the VHB tape and use the foam brush and Primer 94 to lightly seal only the area where the VHB tape will bond to the panel.

### NON-SEAMLESS INSTALLATIONS (WRAPPED OR PAINT GRADE PANELS)

- For non-seamless installations 4'-16' wide, standard direct glue methods can be used as long as there will be at least a 1/4" space on both sides of the installation. Panels can butt tightly together.
- For non-seamless installations 20'-40' wide, it is required to have a 1/16" - 1/8" gap between panels and a 1/2" space on both sides of the installation.

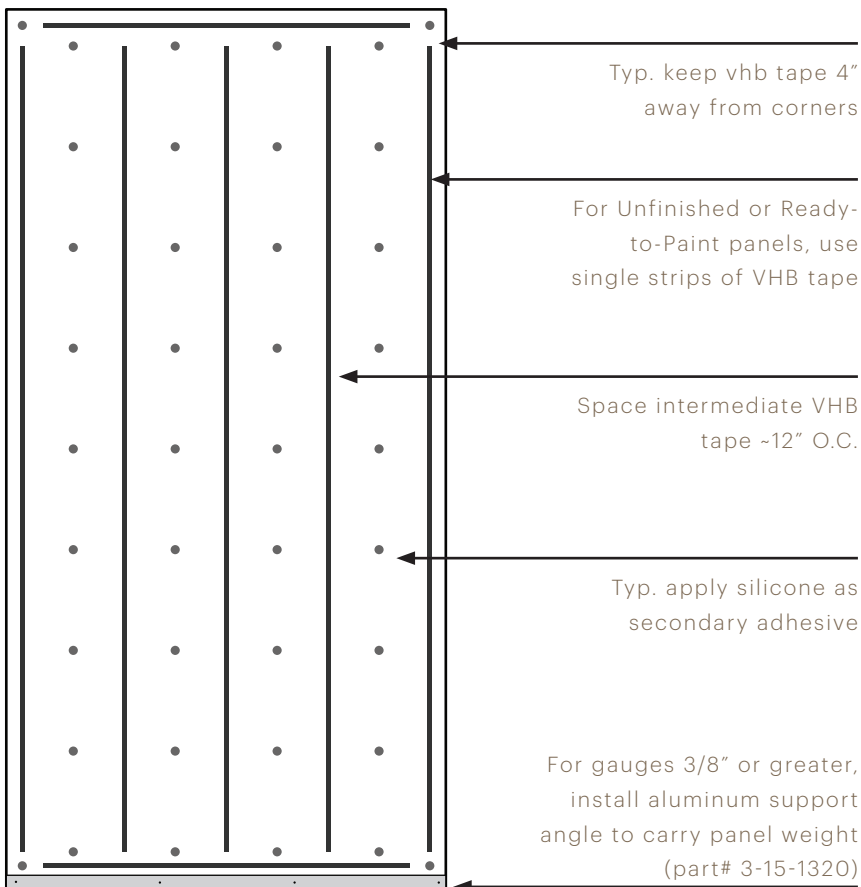
### SEAMLESS INSTALLATIONS (PAINT GRADE PANELS ONLY)

- For seamless installations 8'-16' wide, standard direct glue methods can be used as long as there is at least a 1/4" space on both sides of the installation
- Install these panels with a 1/16" gap between panels. You can then carefully mask off the face of the joint and apply Bondo (auto body putty) to fill the joint. Let the Bondo dry, then carefully sand to feather in the Bondo without affecting the geometry of the panel. Use a white primer to seal the Bondo joints, then paint the entire installation.
- For seamless installations 20'-24' wide, panel cleats installation is required. There must be a minimum of 1/2" space on both sides of the installation. Please refer to the Profile Solutions Document for instructions.
- For seamless installations 28'-48' wide, panel cleats installation is required. There must be a 1/4" space every 16' and a minimum of 3/4" space on both sides of the installation. Please refer to the [Profile Solutions Document](#) for instructions.



## VINYL WRAPPED PROFILE PANELS

Profile panels wrapped with a vinyl finish require (2) rows of vhb tape around the perimeter



## UNFINISHED AND READY-TO-PAINT PANELS

Unfinished and Ready-to-Paint panels require only (1) row of vhb tape around the perimeter