



## MOULDS FIXING MANUAL

Lightweight mouldings come in two standard forms. Solid Lightweight (Architrave's, Stringers and Sills) and Lightweight with polystyrene core (Parapet and Eaves Trim).

Both of the above mouldings are to be mechanically fixed to the following substrates; Precast concrete, Block work, Brick and render and Harditex base sheet.

Solid Lightweight Mouldings (Architraves, Stringers and Sills) have no polystyrene core and are drilled and mechanically fitted to the substrate with mushroom head nylon anchors, depending on the size of the moulding.

When fixing to Harditex substrate, the solid lightweight moulding is to be nailed or screwed through the Harditex into the sub frame, either steel or timber.

Solid Lightweight Mouldings can be easily cut with a tungsten tipped handsaw and mitre box, or an electric drop saw.

### Substrate Surface Preparation

Make sure the substrate is level prior to installing the Solid Lightweight Mouldings. Should the substrate be uneven, install suitable packers at the low points to level out the substrate.

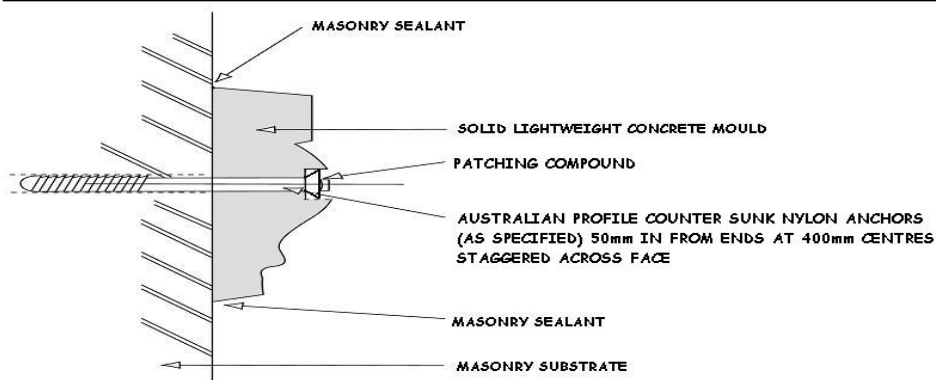
When the solid lightweight moulding is installed onto a true and level substrate, it eliminates undue stress that can result in cracking of the moulding at a later date with expansion and contraction.

### Positioning & Fixing

Prior to installation of the solid lightweight moulding, mark the wall with a chalk line to achieve a level datum line, and install temporary nails along the chalk line, so as to allow the moulding to sit in position, whilst being screw fixed into the substrate.

When fixing the solid lightweight moulding, drill through the moulding and into the substrate with a masonry drill, to suit the size of the nylon anchor (at least 3mm below the moulding surface).

### FIXING DETAILS FOR SOLID LIGHTWEIGHT MOULDS



The nylon anchor is then inserted through the moulding, into the substrate and the nylon anchor is nailed home, with care taken not to damage the face of the moulding.

Fixings are to be installed within 50mm of each end of the moulding, then stagger fixings are to be installed at 400mm centres along the length of the moulding.

Where the mouldings are wider than 100mm, two fixings are to be installed 50mm in from the ends and butt joints with on going fixings staggered at 400mm centres (refer to the Fixing Details for Large Standard and Lightweight Moulds).

Countersunk fixings can be filled with patching putty and sponged off to achieve the same surface texture as the moulding.

After the full length of the moulding is fixed into position, both side edges must be sealed between the moulding and the substrate with Bostik Seal 'n' Flex FC or Sikaflex-11 FC Polyurethane sealant or equivalent.

**NOTE:** *Acrylic-based / water-based gap filler mastics are not to be used.*

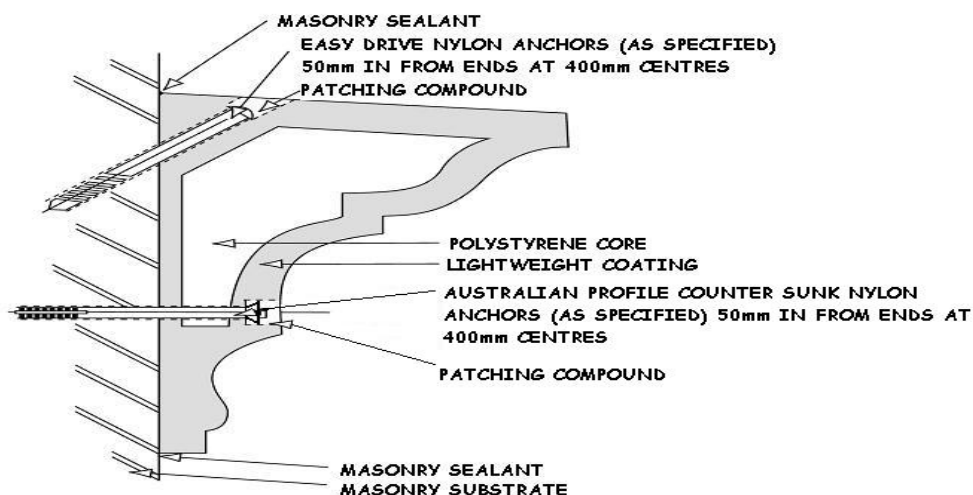
Joins in the mouldings are to have a 5mm straight cut gap filled and surface levelled (*clean*) with the polyurethane sealant, leaving a fine visible pencil line joint.

When the lightweight moulding intersects an expansion joint in the substrate, the same size expansion gap must be carried through the moulding.

**NOTE:** *DO NOT run the Decorative Moulding over any expansion joint.*

Upon completion of the lightweight moulding installation, the complete exposed surface of the moulding is to be painted with 1 coat of Acra-Prime to act as a base in readiness for the final coat of paint.

#### **FIXING DETAILS FOR LARGE LIGHTWEIGHT CORE FILLED**



**Note:** *Parapet Mouldings are polystyrene cored*

The Lightweight Mouldings with polystyrene core have an approximate 13mm thick layer of cement fibre reinforced cover completely incasing the core. It is reinforced and fully integral. The top and bottom leading edges of these mouldings are more solid with approximate 20mm depth of cement fibre reinforced cover.

The fixing of these mouldings are similar to the solid lightweight mouldings with the difference being that in a parapet style moulding, the top edge fixing is at angle of 45 degrees through the top coating into the substrate and secured with an easy drive type nylon anchor, 50mm in from each end and at 400mm centres.

A double row of fixing is required for larger parapet mouldings (*refer to Fixing Positions for Solid Lightweight Mouldings up to 100mm wide*).

The head of the anchor is countersunk into the top layer of the coating and patched using the Mortafil patching compound. All other fixing instructions are the same as indicated for Solid Lightweight Mouldings. (*Refer to attached drawings for additional fixing details*)

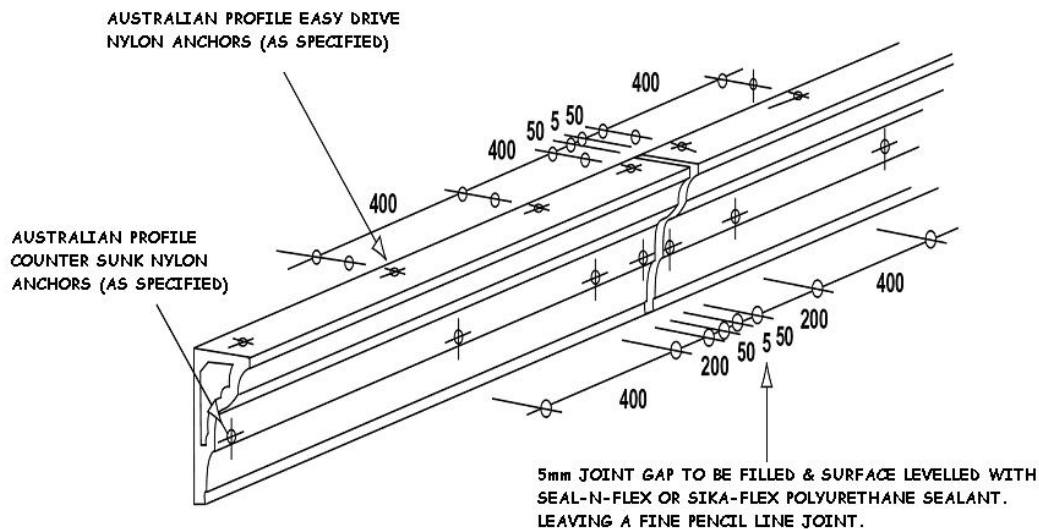
Where lightweight mouldings are to be fixed to face brickwork, the brickwork must be cleaned prior to installation and it is suggested to render or bag the brick around the window reveal to blend in with the window architrave moulding.

Brick joints must not be raked where mouldings are to be applied around windows, to allow complete fixing and sealing to face brick substrate.

Please check the Australian Profile Pty Ltd website for preferred method of application for non-standard Mouldings.

Future performance of substrate eg: movement of slab or block wall is detrimental to the movement tolerance of the Decorative Moulds.

#### FIXING POSITIONS FOR LARGE STANDARD LIGHTWEIGHT MOULDS



**NOTE:** Australian Profile Pty Ltd Lightweight Decorative Mouldings must be fully cured prior to installation. Please check with Australian Profile Pty Ltd for the preferred fixing method of non-standard mouldings.