

Installation Guidelines for XO® Brand Cellular PVC

Handling

- XO should be handled properly to avoid damage.
- Handle as you would natural softwood board or mouldings as the density is similar.
- Store on a flat surface that is not in an area at risk to extensive heat exposure.
- Clean with mild detergent such as a 50/50 solution of mild detergent and warm water. Be sure to test any and all chemicals in an unaffected area before use.
- Protective eyewear is suggested when cutting, drilling, routing and milling XO.

To Cut, Rout or Drill

- You should cut, drill and rout XO with the same tools used to cut natural hardwoods.
- For cutting and routing, we recommend using carbide tipped blades.
- Standard woodworking drills should be used.
- Pre-drill in temperatures of 32° and below.
- Clean drill periodically as PVC will gum up bits under excessive friction.
- Avoid heat build-up.

Nailing and Fastening

- Never span more than 18" with XO.
- Use durable fasteners (stainless steel or hot dipped galvanized) designed for wood trim and wood siding.
- Fasteners must be installed no more than two inches from the end of board.
- Always work from one end to the other.
- Anchor all board, moulding and sheet applications solidly to substrate.
- Never fasten XO on hollow surfaces.
- Do not use on load bearing applications.

Painting

- **XO does not accept responsibility for any paints used or results incurred by use of any paint application.**
- None of the XO product line requires paint or primer to be applied and is ready for installation.
- Use 100% acrylic latex paint on XO.
- All paints must have a Heat Reflective Value (LRV) value of 55 or higher.
- Follow manufactures guidelines on any paint products used.
- Heat deflective paints are recommended; check with your paint dealer for recommendations.

Joining and Thermal Exposure

- All PVC products are susceptible to changes in temperatures and it is critical to consider this in the installation process.
- When fastening allow for thermal expansion and contraction at the end of runs.
- Always scarf join or ship lap boards and mouldings and use applicable glue and fasteners in conjunction with joint; fig 1.1 illustrates a proper scarf joint.
- Do not butt join boards as thermal expansion and contraction will create gaps under opposite temperatures.
- For use only in applications that do not reach temperatures of 135°F or more.

Gluing and Adhesive Selection

- A variety of PVC cements and glue are readily available. Please follow individual manufacturer's guidelines for usage.

- Be sure to apply the appropriate glue in between all miter and scarf joints.
- All joints should have adequate glue applied in addition to proper fasteners to lock the joint to counteract thermal exposure.
- PVC cements "pipe glues" do work for PVC-PVC bonding, but be aware of its fast setting characteristics that limit working time.
- Use an adhesive when applying PVC material to any substrate or stud backings. Apply the adhesive and fasten as described in the Nailing and Fastening section. See fig 1.1 and 1.2 for more detail.
- Most construction grade polyurethane based adhesives will work for XO.
- Here are some tested and suggested products on the market:

Bond&Fill

- A full line of products dedicated to cellular PVC.
- Adhesives designed for most applications.
- Sealants and caulking available.

<http://www.bondfill.com/>

OSI

- A comprehensive line of adhesive products dedicated to cellular PVC.
- Aesthetically pleasing fastener and plug system.
- Comprehensive installation and training DVD available.

<http://www.osipro.com/>

IPS Weld-On

- Complete industrial line of adhesives.
- Easy to view selection chart.
- Adhesives designed for most applications.

<http://www.ipscorp.com/weldon/selectionguide.html>

Mouldings

- Scarf joining is recommended when applicable.
- Follow gluing instructions as described in the gluing and adhesive selection section.
- Apply two fasteners in each corner of the profile to properly secure the joint.
- See Fig 2.1 for the recommended mitered joint and placement of fasteners.

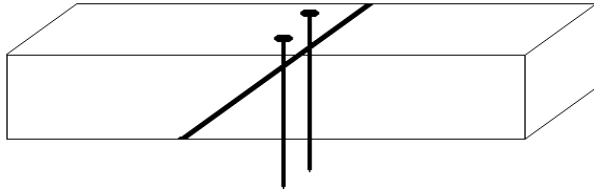
Finishing

- You can sand edges of our full PVC line as you would with wood.
- Use caution with machinery tools that can heat the surfaces.
- Use of quality sealants designed for PVC.
- Wipe clean with mild 50/50 detergent and water solution.

Limited Lifetime Warranty

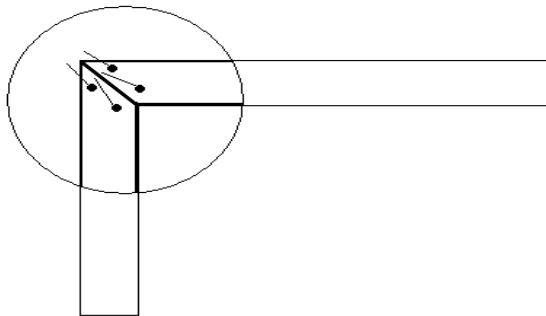
- Warranty information is available at www.xoextreme.com
- Failure to follow recommended installation guidelines in full will void warranty.

Proper Scarf Joining Fig 1.1



- **Cut a 45 degree angle or greater**
- **Apply adhesive**
- **Fasten with two fasteners in the middle of glued joint**
- **Make sure the fasterers drive solidly into backing substrate**
- **Allow adhesive to set**

Proper Miter Joint Fig 2.1



- **Use any miter agnle**
- **Apply adhesive**
- **Fasten with two fasteners on each board**
- **Make sure the fasterers drive solidly into backing substrate**
- **Allow adhesive to set**