

CROWN XCL
XTERIOR COMPACT LAMINATES

INSTALLATION INSTRUCTIONS



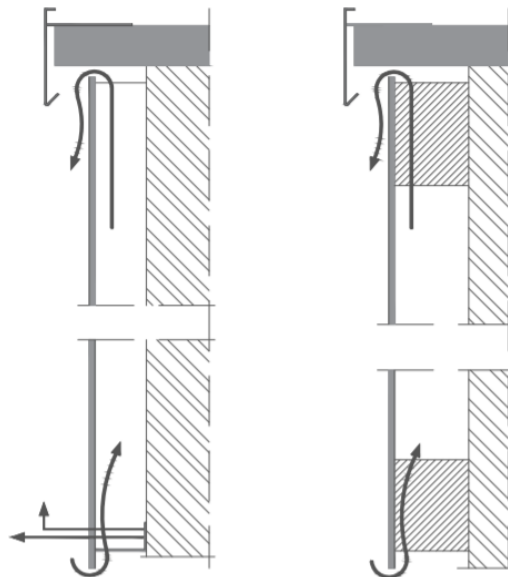
INSTALLATION INSTRUCTIONS

Thank-you for purchasing CROWN XCL panels. This document will outline the necessary steps to ensure that the installation of your panels goes smoothly.

Air Circulation

An air space must be maintained between CROWN XCL compact laminate and the insulation or face of the building. A 19mm minimum unobstructed air space must be left for ventilation behind the panels for air circulation from the bottom to the top of the panel. A minimum 50 cm² space is required for every 1 meter width. Without proper ventilation, CROWN XCL panels will warp.

VENTILATION BETWEEN VERTICAL PROFILES VENTILATION BETWEEN HORIZONTAL PROFILES



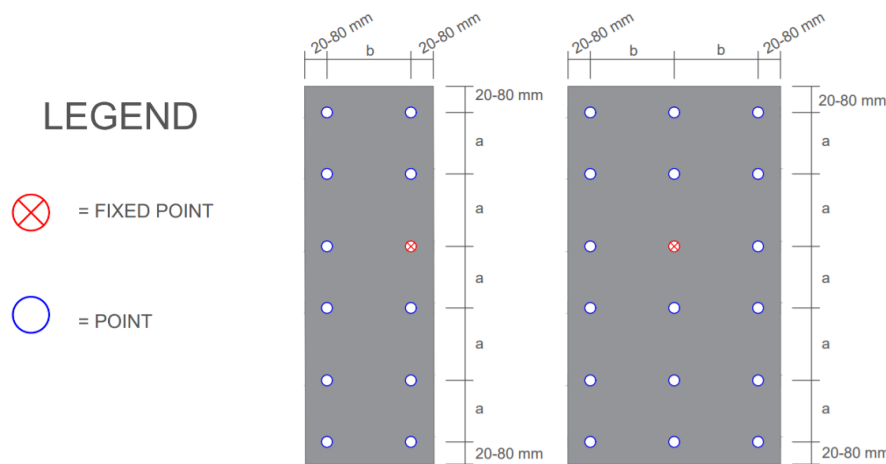
Expansion and Contraction

The varying degree of moisture in the atmosphere changes the dimensions of CROWN XCL at a rate of 2mm per meter. In humid conditions the panels will expand, and dry conditions will cause shrinkage. To allow for fluctuations, an 8mm-10mm reveal must be left between each panel and adjacent finish.

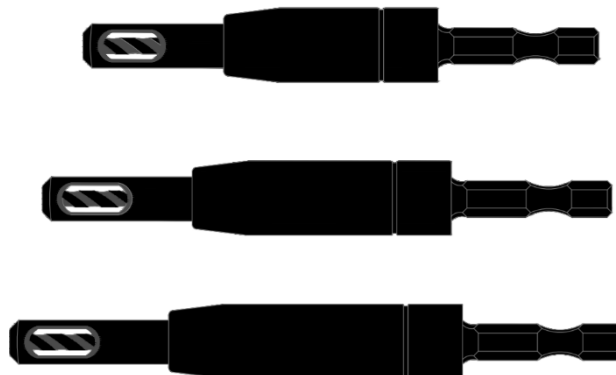
The diameters of the pre-drilled holes for fasteners must be 2-3 mm larger than that of the screw. At the center of every panel there must be a fixing screw. The fixing screw is installed into a hole that is the same diameter as the fastener, which holds the panel in place. The remainder of the screws must be installed using a centering drill to ensure that the holes in the substructure are aligned with the hole in the panel. This will allow the rest of the panel to expand and contract without the panels warping.

Location of Fasteners

Fastener distance must be a minimum of 20 mm apart, and for concealed systems, the distance between screws must be at least 80 mm. The minimum edge distance is 25 mm from the side and 80 mm from the top and bottom as shown below:



For installation with Leland Industries 12-14 Master Drillers, use a 7/32" drill bit for the fixing point and a 1/4" drill bit for the rest of the holes. For the pilot holes for the self-drilling screws use a maximum 5/32" drill bit and a centering tool that can be purchased at hardware stores. **Please note that impact tools cannot be used with Leland fasteners.** When installing the screws be sure not to over tighten the screws as they should be snug to the panel but not tight. If this is not done correctly the panels may buckle or the screws may break. Hold the panel firmly held in place and never use the fastener to pull the panel to the wall.

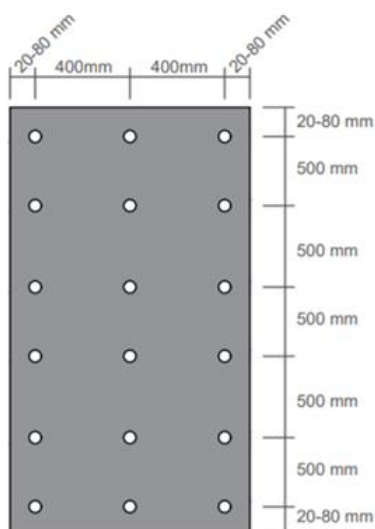


Distances Between Holes

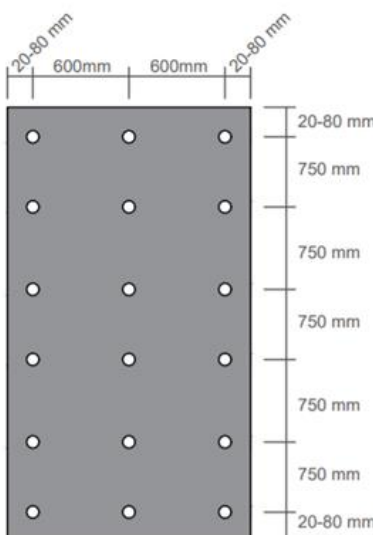
The customer is responsible for the engineering of the substructure to ensure that it will withstand the wind and seismic forces of the location of the building.

Thickness of sheets	6mm	8mm	10mm
Minimum distance of holes to edge	20-80 mm	20-80 mm	20-100 mm
Maximum distance between the holes-width	400 mm	600 mm	750 mm
Maximum distance between the holes-length	500 mm	750 mm	900 mm

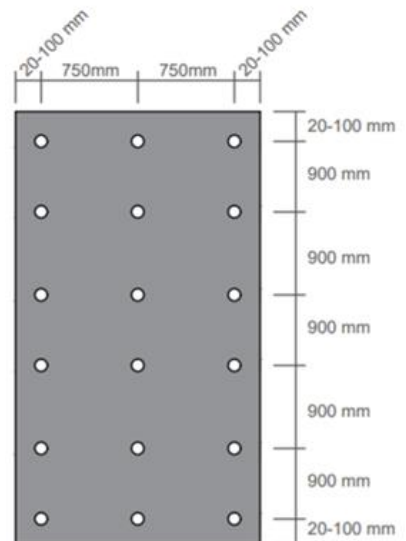
6 mm



8 mm

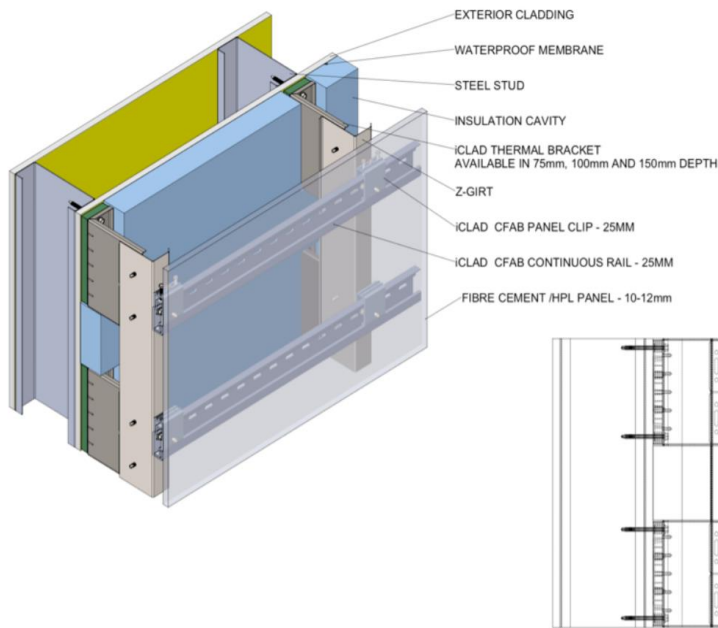


10 mm



iCLAD Concealed Fastening System

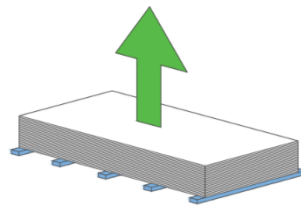
The iCLAD Concealed system is suitable for exterior panels of 10 mm and 13 mm thickness. Suspension components are screwed from the back of the panel, therefore invisible from the front. This system is the most secure application for buildings, and allows easy adjustment of the panels during installation.



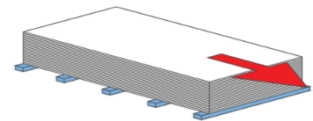
Note: refer to the iCLAD catalogue for details. iCLAD is designed to meet various design requirements.

Handling

When handling CROWN XCL panels, it is recommended to lift each board separately and avoid dragging of the material to minimize the risk of scratching the decorative faces against each other. Hand-held suction lifters or a vacuum lifter is recommended.



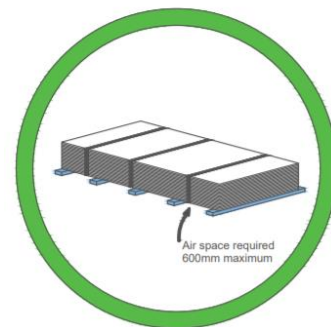
Correct



Incorrect

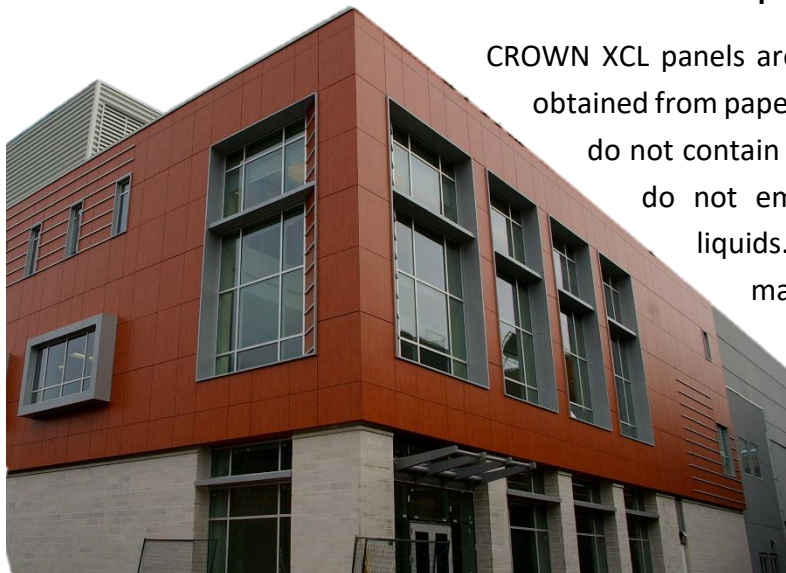
Palletization and storage conditions

- CROWN XCL panels should be transported on pallets larger than the panel size, and supports should be a maximum of 600mm centers.
- Panels must be stored in dry covered conditions to avoid excess humidity and heat. When storing horizontally on pallets, place a protective sheet of sufficient size between the pallet and bottom compact sheet as well as on top of the stack.
- CROWN XCL should always be stored flat in order to avoid any bending or bowing of the sheet. Never store panels with protective sheet for more than 6 months.



Environmental Compatibility

CROWN XCL panels are made up of 80 % cellulose fibers obtained from paper and 20 % thermosetting resins that do not contain any heavy metals or asbestos. They do not emit any gases, fumes, solvents or liquids. The paper which is used for manufacturing CROWN XCL is sourced from sustainable forests.





I have read and understood the instructions and agree to install according to these guidelines:

Company: _____

Customer name: _____

Signature: _____ Date: _____

Installation Company: _____

Installer name: _____

Signature: _____ Date: _____

Witness: _____



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