FITTING PROCEDURE FOR FIREFACE AND FIREFACE PLUS/EXTRA

Fireface should be fitted on panels that are sound, without damage or decay.

Fireface may be fitted to plain panels and painted or varnished surfaces that are free from flaking or peeling. If timber is polished then it will have to be cleaned back to the original timber surface.

Method 1 (under beads)

Remove beads, fill any cracks/splits and voids in panel and between edge of panel and frame with Masterseal. Cut Fireface to size of panel and adhere with recommended adhesive.

If, when the beads are removed, the panel is seen to be retained in a groove in stiles and rails, cut Fireface to allow 2mm gap to all edges.

Refit beads, bedding onto Masterseal. Pin at 150mm centres with 40mm steel pins at 25°-35° inclination. Decorate as normal.

NB If door construction is loose panel held by one set of beads against a rebate, remove beads and panel, apply Fireface to both sides of panel, refit panel and beads, bedding into Masterseal on all edges.

Method 2 (up to beads)

Fill any cracks and splits in the panel with Masterseal. Cut Fireface to suit exposed panel, leaving a 2mm gap to all edges, bond in place with recommended adhesive. Fill 2mm gap with Masterseal. Apply intumescent paint to beads following manufacturer's recommendations. Finally, complete decoration as normal.

NB If door construction has panel set into a groove in the stiles and frame with integral beads, follow this method.

In all cases the materials should be applied to clean, dust and grease free surfaces that have been abraded to ensure good adhesion. The doors and panels themselves, and the surrounding area, should be realistically dry (a normal moisture content for a dry surface is 12%). Areas of high humidity, dampness and great seasonal change should be avoided.

Recommended Adhesives

1. Sealmaster Fireface Contact Adhesive with accelerator -

A spirit based contact adhesive to which a separate accelerator is added at 5% by volume. Apply to both surfaces with applicator supplied. As soon as dry to touch, bring surfaces together with firm pressure.

2. PVA woodworking adhesive -

Water based PVA glue may be used (Resin W or similar). Follow manufacturer's recommendations. Panel must have all paint removed prior to bonding. Fireface Plus must be clamped to panel until adhesive has cured (12-24 hours).

3. Urea formaldehyde resin -

A two part adhesive system comprising a resin and acid catalyst. The resin is applied thinly to one surface, the acid to the other - the two are clamped together and the bond effected. Depending upon resin and catalyst type and bond temperature, press times as low as 5 minutes can be achieved. (Dynochem aerolite KL+CHS hardener). All paint must be removed from the panel prior to bonding.

Over Veneering

Fireface Plus is able to accept a decorative veneer enabling its application to polished hard wood door leaves. The veneer should be hot-press bonded to the ply surface of the Fireface Plus with either a urea-formaldehyde resin or cross linked PVA adhesive prior to being applied to the door. This veneer should be applied cross-grain to the ply of Fireface. (When ordering specify "grain to short length for over veneering").

NOTE: Fireface/Fireface Plus only improves the fire resistance of the panels on to which it is fixed. Its use does not guarantee the fire resistance of the doorset as a whole.

If in any doubt, please contact our Technical Department for assistance.

Sealmaster

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