

PART I GENERAL

1.01 REFERENCE

A. Related DRIANGLE™ INC. Literature

1. **DRIANGLE™ INC. Product Brochures**
2. **DRIANGLE™ INC. Installation Instructions**

B. Glossary

1. Architectural Mouldings: decorative shapes, cornices, sills, quoins, keystones, and similar shapes. Expanded Polystyrene (EPS) meeting the requirements defined in this Glossary, stock or custom profiled, coated with Base Coat and Reinforcing Mesh.
2. Backwrapping: at edges of Architectural Mouldings, where the reinforcing mesh and Base Coat extend from the back side of the Insulation, around the termination edge, onto the front of the insulation, thereby becoming an integral part of the Lamina application.
3. Base Coat: the material applied on to the Insulation, thereby anchoring the layer(s) of reinforcing mesh, rendered to a smooth surface onto which the Finish may be applied.
4. Building Expansion Joints: a joint through the entire building structural system, designed to accommodate building movement. Refer to Expansion Joints.
5. Contractor: the skilled contractor (sub-trade) that is contracted to install the Architectural Mouldings.
6. Control Joints: normally provided for traditional stucco applications. This definition is often confused with Expansion Joints. Refer to Expansion Joints.
7. Designer: the specifier of the Architectural Mouldings, typically a licensed professional, contracted by the Owner for the design of the project.
8. Expanded Polystyrene (EPS): for the Architectural Mouldings, the insulation shall be Type I EPS, nominal density of 16 kg/m³ (1 lb/ft³), compliant to ULC-S701-96, as per the National Building Code.
9. Expansion Joints: junctures in building substrate, for the purpose of allowing independent movement within the wall assembly, i.e., dissimilar structural materials, deflection control, or discontinuity of material type. Refer to 1.02 in this specification for more information.
10. Finish: typical, formulated 100% acrylic polymer-based material with integral colour and texture applied over the base coat material. The designer has the option to select a specialty finish in lieu of the aforesaid.
11. Flashing: metal or other suitable material, provided within the scope of the exterior wall construction, i.e., EIFS, windows, sealants, other cladding systems, etc. The Designer shall ensure that the proper Flashing is included within the scope of the project details and specifications.
12. Insulation: refer to Expanded Polystyrene.

13. Joints: where the Architectural Mouldings are butted, or mitered for aesthetic continuity. These are not to be confused with Expansion Joints.
14. Lamina: Base Coat with encapsulated Reinforcing Mesh, and Finish.
15. Mouldings: refer to Architectural Mouldings.
16. Owner: the party with legal ownership of the project.
17. Reinforcing Mesh: balanced glass fibre fabric (with a specific density), applied in conjunction with base coat, provides stability for impact resistance in the Lamina.
18. Sheathing: a sheet or board material installed, typically installed over framed wall systems, thereby providing the Substrate.
19. Substrate: the wall surface onto which the EIFS and Architectural Mouldings shall be attached and installed.

1.02 DESCRIPTION

A. DRIANGLE™ INC. Architectural Mouldings are manufactured shapes providing the following aesthetic effects:

1. Mouldings: including sills, cornices, & banding
2. Details: including quoins, pilasters, & keystones
3. Columns & Capitals

B. Design Requirements

1. Substrate Systems

- a. Shall be engineered by others.
- b. The maximum deflection under full flexural design loads of the substrate shall not exceed $1/240$ times the span.
- c. The Substrate shall be flat within $1/4"$ (6.4 mm) in a 4'-0" (1.2 m) radius.
- d. It is the Contractor's responsibility to ensure that the Substrate surface is of a type and condition acceptable for application of Architectural Mouldings.
- e. Application of Architectural Mouldings shall be to the following recommended substrates and surfaces:
 - i) Poured concrete, clean of all dust, form agents, and other deleterious materials.
 - ii) Masonry blocks and veneer meeting the inspection requirements of a DRIANGLE™ INC. technical representative.
 - iii) EIFS, manufacturer must be approved by DRIANGLE™ INC.
 - iv) Stucco, structurally sound and intact.
 - v) Cement board finishing.

2. Detail Treatment

- a. The Architectural Moulding edges shall be completely encapsulated with the exterior lamina.
- b. The length and slope of inclined surfaces shall follow the guidelines listed below:
 - i) Minimum slope: 6" (152 mm) of rise in 12" (305 mm) of horizontal projection.
 - ii) Maximum length of slope: 10" (254 mm).
 - iii) Architectural Mouldings shall not be used for areas defined as roofs by applicable building codes.

3. Sealants/Sealant Systems

- a. Sealant: shall be the following, unless other wise approved by DRIANGLE™ INC.
 - i) Tremco 511, with Primer A.
 - ii) Dow Corning 790 & 795, with 1200 Prime Coat.
- b. Sealant system includes the sealant, closed cell backer rod, bond breaker tape, primer and accessories.
- c. The DRIANGLE™ INC. materials shall be completely dry prior to the installation of sealant (24 - 48 hours minimum drying time).

4. Expansion Joints

- a. Expansion joint design and location is the responsibility of the designer. DRIANGLE™ INC. recommends a minimum 3/4" (19 mm) wide where expansion joints are configured through the Architectural Mouldings.
- b. Continuous expansion joints in the Architectural Mouldings shall be installed but not limited to the following locations:
 - i) Where expansion joints occur in the cladding system.
 - ii) Where building expansion joints exist.
 - iii) When the Architectural Mouldings traverse dissimilar surfaces.

C. Performance Requirements

1.

TEST	METHOD
Accelerated Weathering	ASTM G 53
Freeze/Thaw Resistance	EIMA 101.1 ASTM C 67
Waration	EIMA 101.2 ASTM C 331
Tensile Adhesion	EIMA 101.03 ASTM C 297 No bond failure of basecoat to EPS
Water Resistance	ASTM D 2247
Mildew Resistance	ASTM D 3273 23 day exposure
Impact Resistance	EIMA 101.86
Flame Spread	ASTM E 84
Smoke Developed	ASTM E 84

2. DRIANGLE™ INC. has established through independent third party testing that the Architectural Mouldings will perform in various climate conditions. Test reports can be made available from DRIANGLE™ INC., however, the information is confidential, and is subject to signing a waiver for non-disclosure.

1.03 SUBMITTALS

- A. Submit copies of manufacturer's specifications and installation instructions.
- B. Submit the colour and texture of Finish selected for use with the Architectural Moulding. The profile of the sample shall represent that which is used on the project.



1.04 QUALITY ASSURANCE

A. Manufacturer

1. Architectural Mouldings manufacturer shall be DRIANGLE™ INC.
2. EIFS manufacturer, and associated products, shall be approved by DRIANGLE™ INC.

B. Designer:

It is the responsibility of the Specifier to determine if a product is suitable for its intended use. The Specifier selected by the purchaser shall be responsible for all decisions pertaining to design, detail, structural capability, attachment details, shop drawings, etc. DRIANGLE™ INC. has prepared guidelines in the form of specifications, installation details, application instructions, and product data sheets to facilitate the design process only. DRIANGLE™ INC. is not liable for any errors or omissions in design, detail, structural capability, attachment details, shop drawings, etc., or for any changes which a Specifier or their appointed representatives may make to published DRIANGLE™ INC. documents.

C. Contractor:

Shall be recognized by DRIANGLE™ INC.

1.05 DELIVERY, STORAGE, AND HANDLING

- A.** Deliver all materials in original, unopened packages with labels intact.
- B.** Protect all DRIANGLE™ INC. materials from weather and direct sunlight.
- C.** Store all DRIANGLE™ INC. materials in a cool, dry location at a temperature not less than 40°F(4°C).

1.06 PROJECT CONDITIONS

A. Existing Conditions:

The contractor shall have access to electric power, clean potable water, and a clean work area at the location where the DRIANGLE™ INC. materials are to be installed.

B. Environmental Conditions:

1. The ambient air and wall surface temperature shall be a minimum of 40°F(4°C) during the time of installation.
2. The temperature must remain at a minimum of 40°F(4°C) for at least 24 hours thereafter or longer if necessary for the materials to sufficiently dry.

C. Protection

1. Adjacent areas/materials shall be protected from damage, drops, and spills during the application of the DRIANGLE™ INC. materials.
2. The DRIANGLE™ INC. materials shall be protected by permanent or temporary means from weather and other damage prior to, during, and immediately after application. Care must be taken to prevent condensation and/or heat build-up when using a tarp or plastic to prevent damage to the DRIANGLE™ INC. products.

D. Sequencing and Scheduling

1. Installation of Architectural Mouldings shall be coordinated with associated trades.
2. Sufficient personnel and equipment shall be employed to ensure a continuous operation free of cold joints, scaffold lines, texture variations, etc.

1.07 LIMITED MATERIALS AND LABOUR WARRANTY

- A.** DRIANGLE™ INC. shall provide a one (1) year limited material warranty for the Architectural Mouldings, and associated products. Receipt of a properly executed warranty request and completed project form is required.
- B.** The Contractor shall offer a written limited one (1) year labour and workmanship warranty.
- C.** Warranty documents are not released by DRIANGLE™ INC. until all materials supplied are paid for in full, no exceptions.

PART II - PRODUCTS**2.01 GENERAL**

- A.** All components for the Architectural Mouldings shall be supplied by and obtained from DRIANGLE™ INC. or its authorized distributors. Substitutions or additions of materials other than specified will void the warranty.

2.02 MATERIALS**A. Adhesive Material**

- 1.** As specified by the approved EIFS Manufacturer.
- 2.** A high performance acrylic modified cement material. Typically available in:
 - a. Pails, field mixed with Portland Type 10 or 20 cement, at a 1:1 by weight ratio.
 - b. Bags, field mixed with potable water, mixing dependent upon Manufacturer.

B. DRIANGLE™ INC. Architectural Mouldings

- 1.** Mouldings
- 2.** Details
- 3.** Columns & Capitals

C. DRIANGLE™ INC. Reinforcing Mesh

- 1.** Joint Tape: glass fibre mesh, self-adhering, shall weigh a minimum of 95 g/m² (2.5 oz/yd²). Individual rolls are supplied in 100 mm (4") wide by 45.7 m (50 yd) in length.

D. DRIANGLE™ INC. Joint Compound

- 1.** Apply the applicable joint compound material for embedding Joint Tape for butt and miter joints in the Architectural Mouldings.

E. Finishes

- 1.** Finishes: as specified and recommended by the approved EIFS Manufacturer. Typically, acrylic polymer based finishes with quartz aggregate, and integral colour and texture.

F. Primers

- 1.** Primer; as specified and recommended by the approved EIFS Manufacturer. An acrylic-based, colour pigmented primer for use with Finishes.

G. Mechanical Fasteners

1. Where specified, shall include a corrosion resistant screw, suitable for substrate penetration and attachment; and a plastic washer as follows;
 - a. PB Washer, by ITW Buildex
 - b. Wind-Devil, or Wind-Devil 2, by Wind-Lock Corporation
 - c. Grid Mate PB, by Demand Products

2.03 EQUIPMENT

- A. All mixing shall be done with a clean Goldblatt Jiffler Mixer No. 15311H7 or equivalent powered by a 1/2" (13 mm) drill or equivalent at 400 - 500 RPM.
- B. A high-speed wood router with proper bit(s), a hot knife, or hot groover.
- C. Hand or power tools associated with the plastering and EIFS trades.

PART III EXECUTION

3.01 SYSTEM INSTALLATION**A. General**

1. Refer to DR-101, DRIANGLETM INC. Installation Instructions for Architectural Mouldings.
2. When requested, DRIANGLETM INC. will supply MSDS on all products and materials.

B. Surface Preparation

1. Ensure that the surface is clean, dry, free of grease, oil, paint, and other foreign materials.
2. The surface should be plane and true, (3 mm (1/8") within 1.2 m (4')). Wall surface and ambient temperature shall be a minimum of 4°C (40°F) and rising.

C. Attachment

1. Architectural Mouldings may be attached with adhesive, mechanical fasteners, or a combination of the two.
2. Mechanical Fasteners, when used alone, should be installed at 400 mm (16") minimum horizontal centres (at least coinciding with stud system).
3. Adhesive should be applied as per EIFS Manufacturer specifications.

D. Joint Treatment

1. All butt and miter joints in the Architectural Mouldings shall have Joint Tape applied to ensure that at least 50 mm (2") of reinforcement extends onto each edge.
2. DRIANGLETM INC. Joint compound shall be applied over the Joint Tape to completely encapsulate the reinforcement mesh.
3. Inspect the joints after the Joint Compound is dry, sand off any rough edges, or trowel marks.

E. Finish Application

1. Shall be installed as per the approved EIFS Manufacturer specifications.

F. Sealant Application

1. All expansion joints in the Architectural Mouldings require the exposed to be treated with base coat and reinforcing mesh.
2. Sealants shall be installed as per manufacturer specifications.

3.02 PROTECTION

- A.** Adjacent materials and the Architectural Mouldings, and associated products, shall be protected from the weather and other damage during installation and while curing.

DISCLAIMER

Information contained herein conforms to the standard detail recommendations and specifications for the installation of DRIANGLETM INC. products as of the date of publication of this document and is presented in good faith. DRIANGLETM INC. assumes no liability expressed or implied as to the architecture, engineering, or workmanship of any project. No representation is made herein with respect to the compliance of any DRIANGLETM INC. typical details or specifications with local building code or fire code compliance. It is the responsibility of the project designer, builder or general contractor or the end user to insure that the use of DRIANGLETM INC. product meets the local building code and satisfies the local fire code requirements. To ensure that you are using the latest, most complete information, contact DRIANGLETM INC.

INSTALLATION INSTRUCTIONS

ONE GREAT FINISH DESERVES ANOTHER.TM

Revision Date: July 19, 2002.
Document: DR-101

Read complete instructions before beginning installation of DriangleTM Inc. Mouldings and refer back to appropriate section as you progress through the installation.

1.0 EQUIPMENT REQUIRED

Measuring tape, 3/8" notched trowel, cutting equipment (power miter saw, or hand saw), miter box (if using a hand saw), chalk line, putty knife, 4' level, power drill and paddle mixer, hammer and nails.

2.0 SITE INSPECTION

Ensure surface is clean, dry and free of foreign material such as oil, dust, form release agents, paint, wax, water repellents, or any other surface contamination that may interfere with proper bond of adhesive. Also insure that surface and ambient temperature is above 40° F (4° C) prior to application and is maintained at this temperature until adhesive is fully dry, typically 24 hours.

3.0 SUBSTRATE

(Fig. 1)

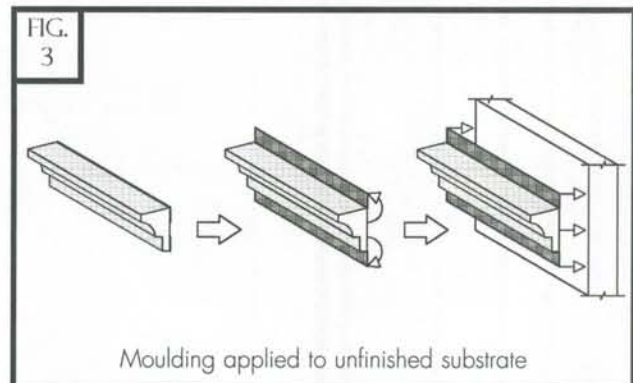
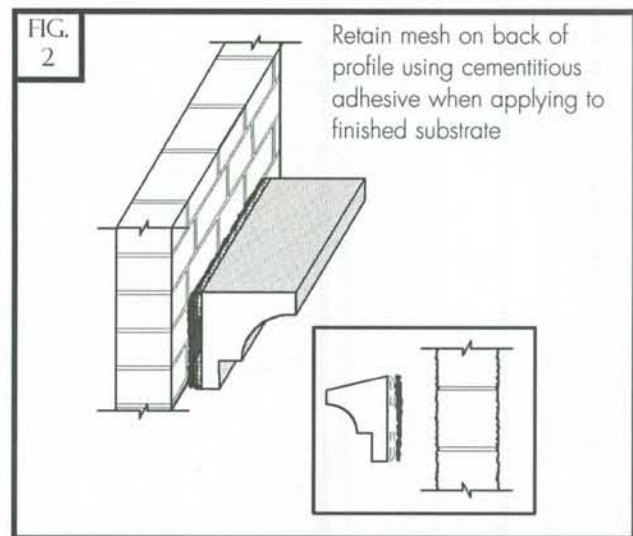
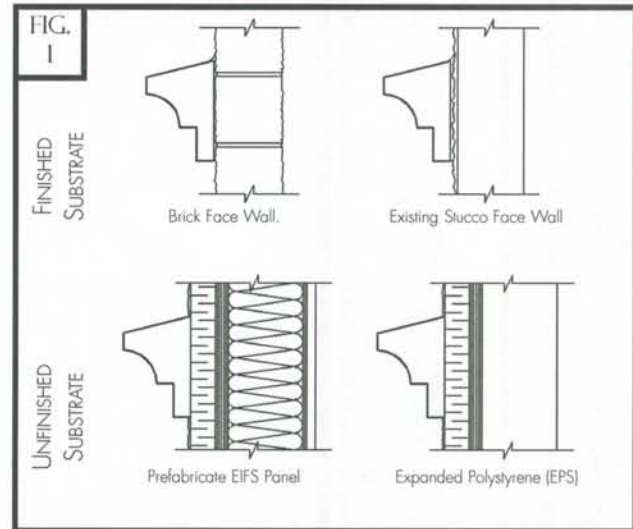
(A) FINISHED SUBSTRATE: brick, stone, existing finished stucco, painted concrete/masonry. If the substrate is finished stucco or other painted surface, insure that stucco or paint is structurally sound and is compatible with adhesive. Removal of paint or other finish material should be done for all questionable surfaces.

(B) UNFINISHED SUBSTRATE: expanded polystyrene (EPS), stucco base coat ready for finish, levelled concrete/masonry, and sheathing.

4.0 TRANSITION TREATMENT

(Fig. 2-3)

If the moulding is being applied to a finished substrate, the transition mesh on the back of the moulding is to be fully embedded to the back of the moulding using the cementitious adhesive. If the moulding is being applied to an unfinished substrate, peel the mesh on the back of the molding along the entire length prior to adhesive application.



5.0 INSTALLATION PROCEDURES FOR EXTERIOR SHAPES

5.1 General

During the installation of DriangleTM Inc. Mouldings, it is recommended that personal protective equipment be worn such as gloves, eye protection and a full sleeved shirt. Also, during the cutting and sanding process, ensure that respiratory protection is used.

5.2 Mouldings

5.2.1 Layout

Using a measuring tape and level, mark the location for each moulding being installed. A chalk-line should be used to mark the location for longer sections insuring straight and true lines. All markings should coincide with one of the straight edges of the moulding; top or bottom, which ever will be most visible during installation.

5.2.2 DRY RUN

Layout mouldings and identify each piece for installation sequence (Example: when dressing all sides of a window, the window sill section should be installed first). All mouldings that require being cut to length or miter cuts, should be measured, cut and dry fitted before moving to the adhesive application step. Miter cuts can be made on a standard miter saw using a fine or masonry blade. All inside and outside corners should be miter cut. Before cutting the window's section, determine if the ends are to be returned, or finished straight. For miter returns, cut ends of section and "end caps" on a 45° angle. "End cap" should be cut to a dimension equal to the width of the molding so that all pieces finish flush on the contact surface and finish side.

Tip: for end caps, cut 45° miter first and then cut to length. The "end cap" should be in the shape of a right angle triangle when finished.

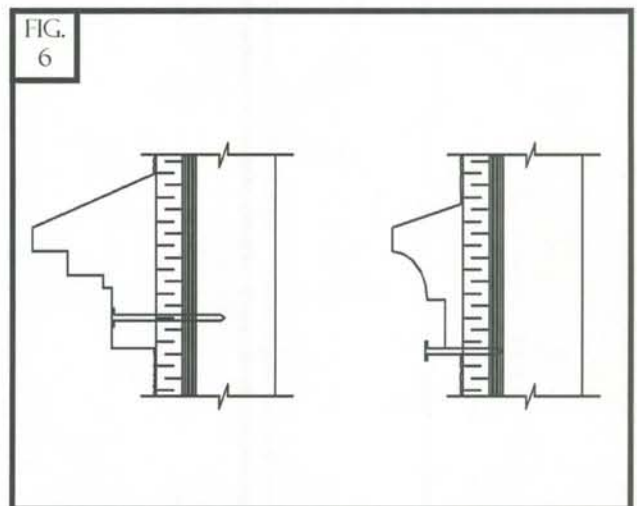
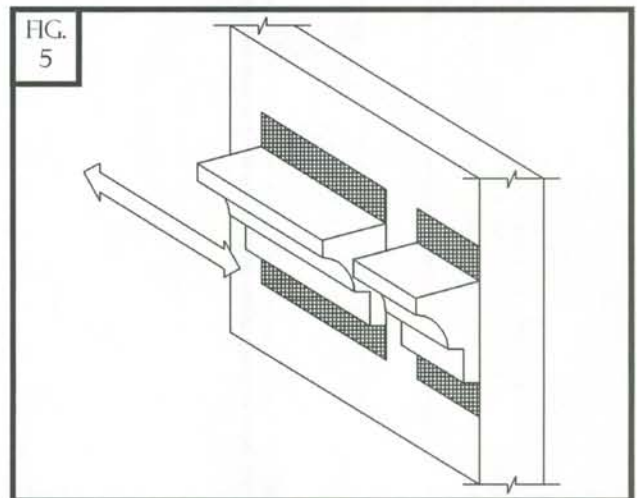
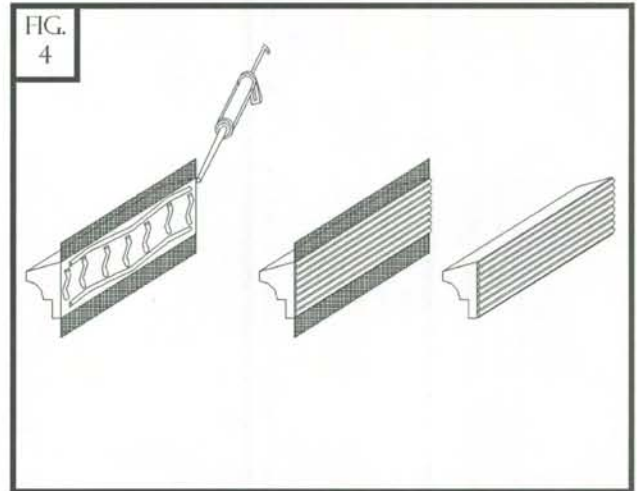
5.2.3 Adhesive

(Fig. 4-6)

Once all mouldings have been cut, the appropriate adhesive must be selected.

If adhering mouldings to EPS (unfinished substrate), use an approved urethane or cementitious adhesive. For approved urethane adhesives apply the adhesive on the back of every moulding in a continuous bead along the perimeter. Then apply vertical strips of adhesive at approximately 12" on centre.

If adhering mouldings to sheathing use the appropriate corresponding adhesive for that sheathing to foam. Mechanical fasteners are necessary when applying to sheathing covered with building paper.



If adhering mouldings to the remaining substrates listed in section 3.0 (both finished and unfinished substrates), use an approved cementitious adhesive. When adhering mouldings to substrates where extension of joint treatment mesh onto the substrate is not possible (E.g. Brick) adhere joint treatment mesh to substrate, top and bottom, at joint locations for a back-wrap.

Prepare the adhesive as per the instructions printed on the packaging. Using a 3/8" stainless steel notched trowel apply adhesive to the contact surface of the moulding over its entire length. Immediately install the moulding while the adhesive is still wet by pressing and slightly sliding the moulding back and forth into place. Butt moulding ends tightly together, leaving no or a minimal gap between sections. If there are any gaps between joints due to irregularity in substrate, insert slivers of foam to fill in gap. Depending on the size of the moulding, a temporary support can be used until the adhesive has completely dried. Larger mouldings may require some type of mechanical fastener (See mechanical fastener manufacturer's specifications to determine appropriate fasteners). Remove excess adhesive before it dries. Allow adhesive to fully dry before moving to the transition treatment.

5.2.4 Transition Treatment

(Fig. 7)

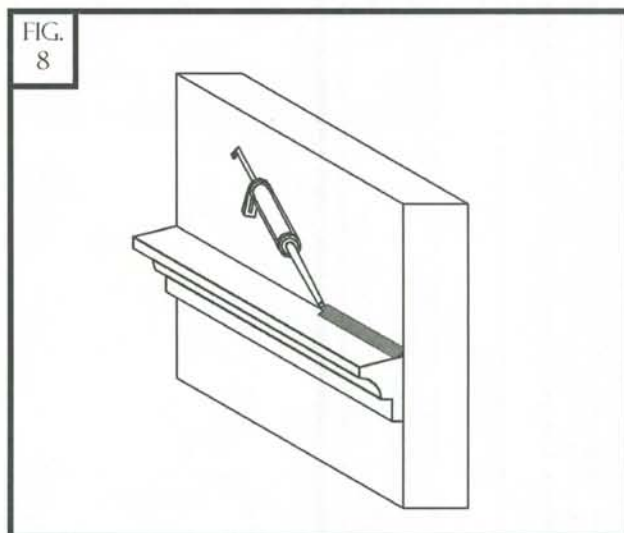
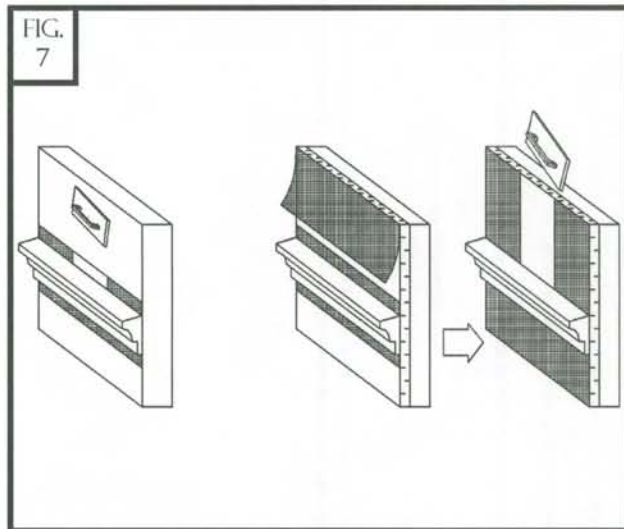
5.2.4.1 Unfinished Substrates

If applying a moulding to EPS, embed transition mesh first and then complete joints. These meshes are then overlapped with wall mesh, using a suitable base coat material to produce a seamless and durable transitions. On other unfinished substrates, use a suitable base coat to embed the exposed moulding transition mesh to the substrate and then feather out to produce a seamless and durable transition.

5.2.4.2 Finished Substrates

(Fig. 8)

In situations where DriangleTM Inc. products are being applied on a finished substrate, apply the appropriate sealant along the top edge and sides of the products that come in contact with the wall. Bottom of products receive no caulking. Sealant should not make contact with exposed foam therefore all moulding ends should be base coated (See 5.2.6). If applying sealant to an acrylic stucco finish use a colour matched low modulus sealant. If applying sealant to a traditional cementitious stucco finish or brick use a paintable sealant with bond breaker tape. The sealant should be applied before painting or applying a textured finish.



5.2.5 Joint Treatment

Once adhesive has dried (typically 24 hours), treat the joints of the mouldings using the corresponding joint compound. Driangle™ Inc.'s Angle Base 2000 Joint Compound on Angle Base 2000 coated mouldings and an approved cementitious joint compound for Strata Base coated mouldings. It may be beneficial to complete all joints prior to transition treatment.

Tip : *precut the needed amount of mesh to an easy working length.*

5.2.5.1 Butt Joint

(Fig. 9)

Begin by applying the base coat material to the moulding using a simple putty knife. Apply the precut mesh and embed into the base coat material. The mesh should be centered on the joint and overlap either side of the joint by minimum 2". Insure that the mesh is applied over the entire joint and extends a minimum of 2.5" onto the wall at the top and bottom on an unfinished substrate. On finished substrates, the mesh should be adhered to the substrate at joint locations to complete a back-wrap to encapsulate the moulding. Feather out edges to create a smooth flush joint. A second layer of joint material may be needed to achieve a smooth joint. If so, allow the first coat to fully dry prior to applying the second. Some sanding may be required before applying the second coat.

5.2.5.2 Corner Joint

(Fig 10)

When joining to create a corner, first miter cut the mouldings, and butt joint at the miter end to ensure a tight fit. Apply joint tape and compound to treat the joint as stated in section 5.2.5.1.

5.2.6 Base Coated Ends

(Fig. 11)

For mouldings that are finished square such as on a sill or header section, treat exposed end with base coat material and reinforcing mesh. Begin by first cutting mesh in the basic shape of the moulding profile leaving some extra length that is to lap onto the surface of the molding. Small relief cuts in the mesh may be required to allow mesh to follow the moulding profile when lapping onto the surface. Apply base coat and embed mesh, completely covering exposed expanded polystyrene and overlapping onto the "face" of the molding. Two coats minimum are required to produce a paint ready surface.

5.2.7 Cut Stone Look

(Fig.12)

When trying to achieve the look of cut stone, several details

FIG.
9

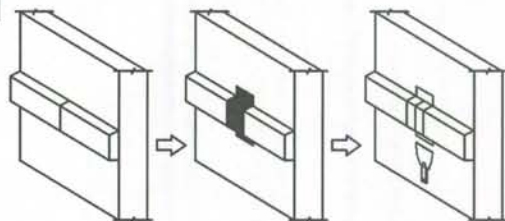


FIG.
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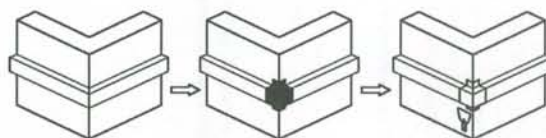


FIG.
11

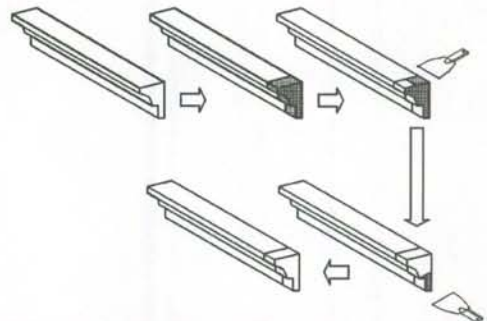
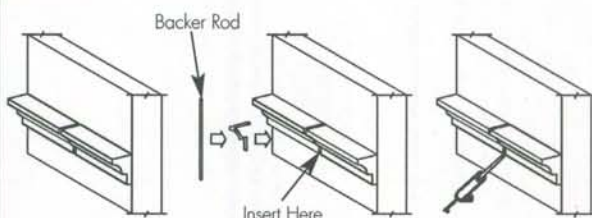


FIG.
12



must be considered. It is not recommended to strive for this look when applying mouldings directly to an EPS substrate. All moulding ends must be base coated (see section 5.2.6) and primed with sealant primer before installing moulding on the determined substrate. The same adhesion and transition treatment instructions (see sections 5.2.3 & 5.2.4) still apply. Allow adhesive and/or joint compound to fully dry before proceeding to treating the joints with sealant. Once gap between mouldings has been determined (typically $\frac{1}{2}$ " to 1") and sealant primer has dried, insert an appropriately sized closed cell backer rod as per sealant manufacturer's specifications. Apply sealant and allow to dry before applying finish (see section 5.6).

5.3 Keystone

When installing keystones on their own, follow the same installation procedures noted in sections 5.1 through 5.2.5. If you are applying keystones as accents on window or door trims these additional steps must be followed. During the dry run stage mark the location of the keystone on the moulding it will be intersecting and make the appropriate miter cuts to the moulding so the keystone will fit. Make sure everything is dry fitted before proceeding to the adhesive application.

5.4 Quoins

(Fig. 13)

When installing individual quoins, first determine the spacing between the quoins. If the quoins are being applied onto a finished substrate, be sure to embed all transition mesh to the back sides of the quoin. If being applied to an unfinished substrate, peel back the transition mesh along the perimeter of the quoin. Apply the adhesive on the back of quoin and install immediately. Press on the quoin and slide the quoin up and down to ensure complete adhesion (see sections 5.2.3 & 5.2.4). Temporary fasteners may be required to support the quoin while the adhesive dries. Use a spacer between the quoins to maintain the desired gap.

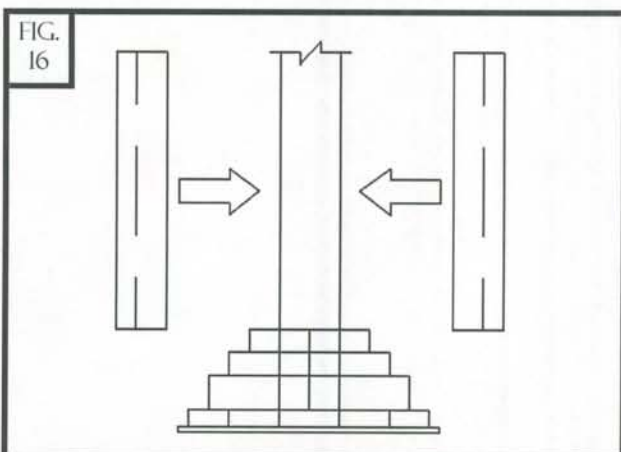
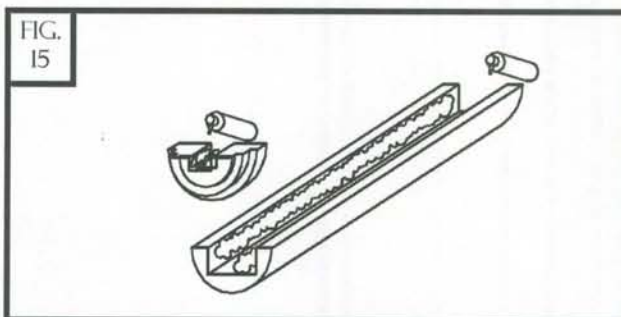
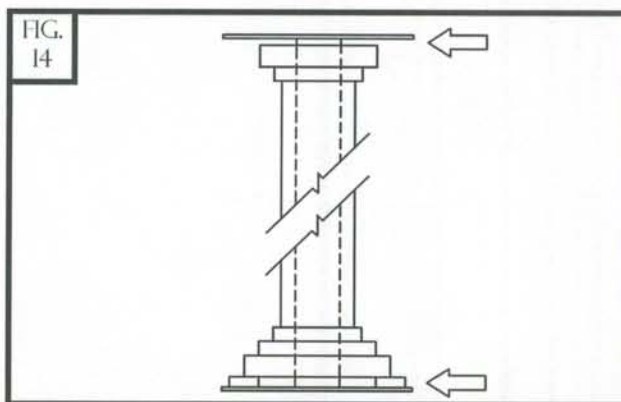
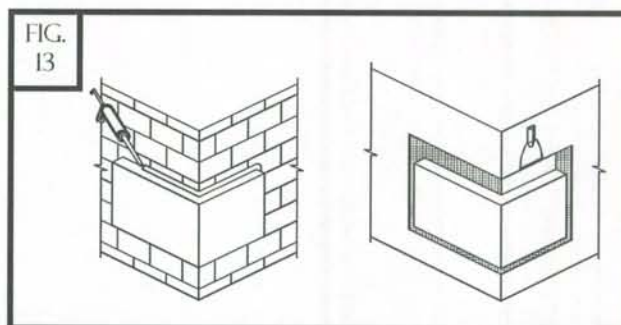
If applying a continuous quoin corner cap, combine procedures for installing mouldings and individual quoins.

5.5 Columns

(Figs. 14-19)

5.5.1 Standard Columns

When installing a column assembly, temporarily set the base and capital in place. The base section should be kept a minimum $\frac{3}{4}$ " from finish slab or support footing and the capital should be kept a minimum of a $\frac{1}{2}$ " from the soffit. Measure the distance between the capital and base in order to size the column. Cut the column and dry fit all the sections.



Tip : Measure twice and cut once.

After cutting and dry run, install the base around the structural column. Apply a minimal expansion polyurethane foam adhesive to area of the base section that will contact the supporting member only. Do not apply adhesive to the ends of the sections that will join together. Set the base sections and squeeze together. Remove any excess adhesive while wet. Be sure to maintain $\frac{3}{4}$ " space between base and slab. Allow base section to dry and follow same procedure for column sections.

Apply adhesive to the column sections along the entire length of column that will come in contact with the supporting member. Set column halves and squeeze together. Banding may be used to hold sections tightly together while adhesive dries. Remove any excess adhesive while wet.

The next step is to install the capital. Follow the same procedure as installing the base.

Once the installation is allowed to dry, treat all joints with mesh and appropriate joint compound (see section 5.2.5). Once dry, sand to a smooth finish.

Once all joint treatment is complete, apply backer rod and sealant between both the base and slab, and the capital and soffit. Use a low modulus sealant for this application.

If applying a column, capital, and base in halves on to the wall follow the procedures stated in sections 5.1-5.2.5.

5.6 Applying Finish

Prior to applying finish, ensure that:

- All shapes are completely adhered and fully cured.
- All temporary fasteners are removed. All permanent fasteners have been covered with mesh and appropriate base coat and sanded flush.
- All joints have been treated and sanded flush.
- All surfaces are dry, clean and free of dirt, dust and other contaminants as per finish coat manufacturer's specifications.

DISCLAIMER

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FIG.
17

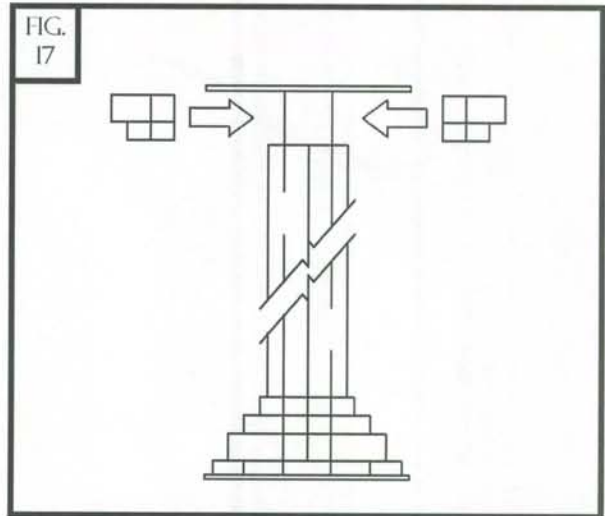


FIG.
18

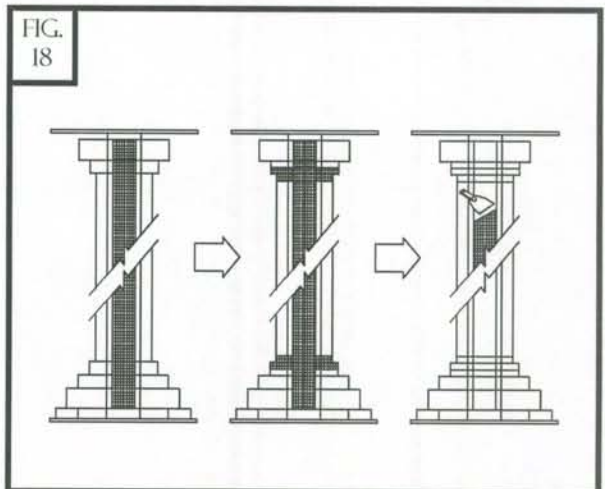
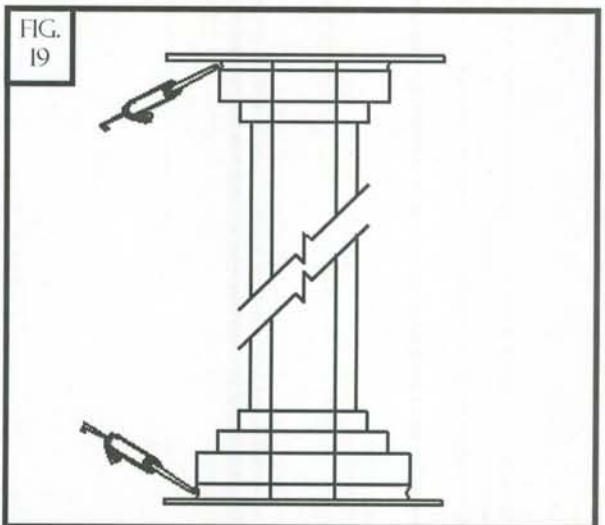
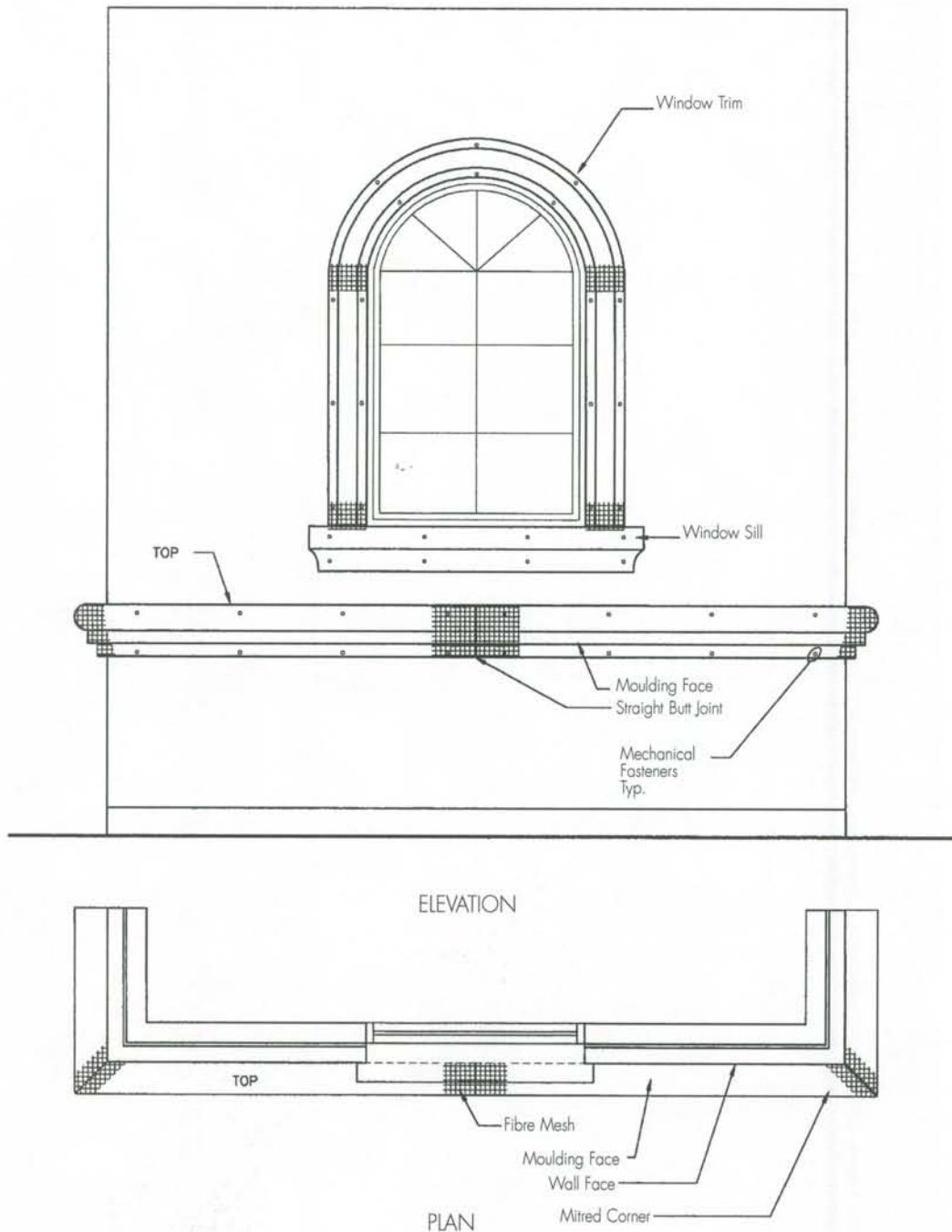


FIG.
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