



UNITED STATES PLYWOOD CO., INC.
103 Park Avenue, New York

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INSTRUCTIONS FOR ERECTING FLEXWOOD

FOREWORD:

IT IS easy to do a perfect Flexwood job, but these instructions must be carefully followed. You are erecting a fine material which will last as long as the building which it adorns. Our reputation and yours depends upon your doing the work carefully.

We will guarantee the erected job if supervised by us or one of our agents and we will charge for such supervision at cost. All guarantees must be in writing and signed by an officer of the UNITED STATES PLYWOOD Co. We *will not* guarantee work over which we have no control, but remember—a perfect job only requires the careful following of these directions. **FLEXWOOD CAN NOT BE HUNG ON A WET WALL.** You may be urged to proceed because the tenant or owner insists that a job must be finished on a certain date. Do not yield to any pressure of this kind because it means certain trouble and loss. *Do not hang Flexwood on a wet wall.*

FOR PLASTER WALLS

1—Prepare the Wall.

(a) **New Walls:** *The wall must be dry.* The edge of a coin will make a black line on a dry wall and slips, making a faint line, on a wet wall. Sandpaper will gum on a wet wall. Remove grit with sandpaper and point up all wall defects with patching plaster or Swedish putty. Test wall as follows to determine if weak: Apply a small piece of Flexwood with Flexwood cement to bare wall, allowing to dry overnight. Pull the Flexwood and if plaster tears from wall easily, it is advisable to apply one or two coats of thin shellac. New plaster should be sanded to remove grit and unbonded dust film left by troweling.

(b) **Old Walls:** Wallpapers, calcimine flat paint or paint that is flaked or checked must be removed.

Where lead and oil paint is present, test paint by applying a small piece of Flexwood in several places with Flexwood cement and allow it to stand overnight. Pull the Flexwood off and if the paint comes with it, the paint will have to be removed.

2—Laying Out the Work.

Lay out the sheets for each wall. Use a plumb line for marking the center joint, using the same number of sheets on each side for matched effects. Flexwood is numbered on the back for this purpose.

Knotty Pine is usually hung random avoiding matching of grain or knots. Reversing adjacent sheets and staggering trim in various sheets is helpful in getting desired random effects.

3—Applying Flexwood.

NOTE—*If Flexwood cement is too heavy for easy spreading, place can in a pail of hot water or on a warm radiator until cement flows freely.*

First apply coat of Flexwood cement to the entire wall surface, brush it out thoroughly and allow to *thoroughly dry*. This takes about two to four hours, though in damp weather it is advisable to allow Flexwood cement to remain overnight to set thoroughly on wall.

Second apply Flexwood cement to the back of the Flexwood using a short bristled brush. Brush out thoroughly being sure there are no uncovered spaces. Allow cement to become tacky to the touch which will require five to ten minutes, being sure to hang Flexwood before any dry spots appear.

Brush cement out thoroughly. An excess of cement on wall or back of Flexwood will form hard lumps which can not be removed after the cement is dry.

Third hang the Flexwood by using a stiff 3 inch painter's scraping or broad knife, using firm pressure and *scraping the entire surface in the direction of the grain*, overlapping each stroke and keeping the knife clean of all cement. The edge of the first Flexwood sheet applied to the wall must be true to the established center plumb line. After each sheet is hung, go over entire surface with a stiff broadknife, *using all pressure possible*, with the grain. Make sure that there are no air spaces between Flexwood and wall. Apply second and all consecutive sheets in same manner, butting all edges and carefully scraping all joints firmly. Remove all Flexwood cement from surface of wood promptly as each sheet is applied, using sandpaper.

Fourth after the Flexwood has been applied from four to twenty-four hours, inspect entire surface thoroughly for blisters, looking against the light. If any are discovered these can be securely laid with a hot iron, using a piece of Flexwood or heavy wrapping paper between iron and Flexwood.

4—Finishing the Flexwood.

The newly applied Flexwood should be allowed to dry two to three days before applying the finish. Any finish may be applied to Flexwood that is used for finishing fine cabinet wood. A typical method of finishing is:

(a) Sand entire surface thoroughly, using No. 1 or No. 1/2 sandpaper, carefully sanding all joints to an even surface and removing any cement remaining on Flexwood surface. Sand only in the direction of the grain.

(b) Apply thin coat of white shellac and when dry putty any open joints and corners, using wood fibre or lead putty colored to match wood, sanding the entire surface lightly using No. 1 sandpaper.

(c) Remove all grit and dust by wiping clean with rags dampened with benzine.

(d) Apply one coat of gloss varnish; when dry rub entire surface lightly with steel wool and wipe clean.

(e) Apply one coat of a good extra flat varnish.

APPLICATION TO OTHER THAN PLASTER WALLS PLASTER BOARD

Apply the plaster board in regular way, providing a 1/16" joint between adjoining boards and securely nail in place with 3d Blued lath nails, spacing nails not more than 6" apart, countersinking without breaking board. Point up all nail heads and joints level, using board manufacturers' recommended patching plaster, and sand smooth. Apply Flexwood cement to wall allowing to dry thoroughly. Apply Flexwood cement to back of Flexwood and hang in usual manner.

PRESWOOD AND QUARTER BOARD

Apply in same manner as plaster board, using 3d Blued lath nails spaced not more than 3" apart, countersinking them. After pointing up nails and joints level, sand entire surface. Use rough side of preswood. Apply Flexwood as for plaster board.

INSULATION BOARD AND OTHER FIBROUS WALLBOARDS

This type of board is not recommended due to its uneven surface, which causes a wavy appearance to the finished job.

METAL

The entire surface should be thoroughly cleaned, applying salsoda with brush and rubbing thoroughly with steel wool. Wash clean. Apply Flexwood as for plaster board.

MARBLE, CEMENT, GLASS, ASBESTOS BOARD, GLAZED TILE, ETC.

Clean as indicated for metal surfaces. Apply Flexwood as for plaster board.

TRICKS THE MECHANIC SHOULD KNOW

TURNING FLEXWOOD ACROSS THE GRAIN

While Flexwood can be turned over corners easily with the grain, this is more difficult to do against the grain. The piece to be turned should be applied to one side of the turn in the usual manner and allowed to dry. After the Flexwood is set, moisten the face of the wood at the turn and bend it around the corner, carefully using the warm iron. This should not be done until the surface to go around the corner has received a well-brushed-out coat of cement and has been allowed to become tacky.

INSIDE CORNERS

It is very bad practice to carry a sheet of wood around an inside corner, as this results in loose corners. The space up to the corner should be measured with the dry Flexwood, which should be returned to the table and cut with a straight edge with an allowance of $\frac{1}{4}$ " to $\frac{1}{2}$ " to take care of any irregularity in the corner. When this has been pasted and become tacky it should be applied in the usual manner, which will give a short lap over the corner and on the adjacent wall. Using the cutting knife held out from the first wall with the scraping knife, cut corner running the knife edge against the second wall, being careful not to cut into the plaster. This gives a slight excess of material which, however, can be worked tightly into the corner. Apply the cut off sheet, lapping and cutting as above. This gives a perfect joint that will not show a white line when dry unless there is movement in the plaster wall.

APPLICATION OF SQUARES

On any given wall space, a horizontal and vertical line should be drawn bisecting the center point on the wall. These lines should be established with the level and, having been established, the remainder of the lines to indicate the spaces occupied by the squares or other shapes should be snapped on the wall with a cord in the usual way. Application of the squares should begin at the middle point of the wall and work out in each direction. Thus any irregularity in the wall can be taken up by the size of the pieces at the top and bottom and sides of the wall.

IN MAKING MITRED CORNERS

The wood in both stile and rail should be lapped, zinc strip inserted and the wood cut from corner to corner through both thicknesses, lifting out the cut off piece. The two ends then fall in place on the wall with a perfect joint. The same lapping is desirable in cutting square corner joints.

APPLYING FLEXWOOD WHERE MOULDINGS AND CASINGS ARE ALREADY IN PLACE

Usually these can be sprung enough to tuck in at least $\frac{1}{4}$ " of wood and this should be done whenever possible. If these can not be opened in any way, then bring the wood to the moulding and cut on the moulding in the manner indicated for cutting corners, which will bring the wood fully flush to the moulding and leave no open joint.

APPLYING HORIZONTAL COURSE ABOVE VERTICAL COURSE

Establish horizontal line before hanging the vertical wood. As the vertical wood is hung allow it to lap the horizontal line $\frac{1}{4}$ " to $\frac{1}{2}$ ". Trim ends of each sheet of vertical wood as the application proceeds, cutting to established line with straight edge and inserting zinc strip beneath Flexwood.

Flexwood is manufactured and marketed jointly by The Mengel Company Incorporated and the United States Plywood Co., Inc.

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FLEXWOOD DIVISION

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