We're door people. CraftMaster INTERIOR DOORS

Cellini Application Instructions



Materials Required:

- Door (slab or pre-hung unit)
- Cellini Plant on Parts
- Method to heat parts to approximately 100° F such as a simple hot box powered by light bulbs, a heat lamp or a hair dryer.
- 36" Long Straight Edge
- Micro Pin Nailer
- Pins 5/8" Long
- Hot Glue Gun or an adhesive system comparable to 3M's Jet Weld system with a minimum cure time of 4-6 minutes.

Note: A cold press glue can also be used, such as National Casein PVC 54M acrylic adhesive. Using this glue will require that the parts lay perfectly flat, or are held flat mechanically, while the glue cures.

Steps for Application

**Note: door and plant on parts are supplied with white primer already applied. For clarity, the instructions are illustrated with the door in a grey tone.*

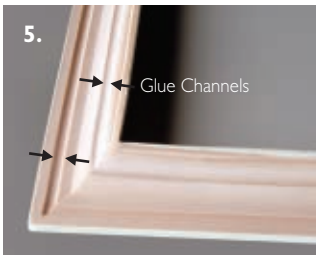
1. Dry fit the Parts to ensure fit is good before applying adhesive or pre-heating the Parts.

2. Prepare the hot glue gun and the pin nailer. Use plant air for the pin nailer at the appropriate pressure as dictated by the tool manufacturer.

3. Pre-heat the Parts to approximately 100° F to ensure they will lay flat during the layup process. The application of heat will also make the Parts pliable and easy to work with. We strongly recommend using a hot box.

4. Lay the pre-heated Parts next to the door that they will be applied to. Make sure the orientation of the bottom panel is correct by dry fitting the Part in the molded window.







5. Begin applying glue to the back side of the Cellini Plant on Part, using the glue channels as a guide. Be sure to apply a generous bead in the channel, but use glue sparsely outside of the channel to avoid glue squeeze-out on the door surface. Work quickly to avoid the glue setting before the Part is in place.

6. Once glue is applied around the entire part, carefully set the Part in place. The Part will nest exactly within the door profile.





7. Starting at one corner, ensure the Part is fully seated.

8. Apply two (2) pins outside of the corner. Be sure to nail the Part perpendicular to the high slope inside the cove as shown in the detail below. This will ensure maximum holding power and minimize the possibility of chipping.





9. Fasten each corner as you move around the door panel, applying two (2) pins in each corner.



(continued)

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10. Use the straight edge to line up each side of the Part. Again, the Part should nest well within the profile. Attach pins as you move along the Part and along the straight edge. Pins should be spaced approximately 8" apart. Again, ensure you nail the Part perpendicular to the high slope inside the cove detail of the door panel.


10.


11.

11. Move along all 4 sides of the door panel using the straight edge to ensure the Part is square on the door with respect to the corners. Apply pressure to the Part as you nail to help 'set' the glue.





Note: For the Caiman panel, pin the middle of the arch first, then work toward each corner, pushing on the Part as you nail to ensure that the Part is fully seated in the profile.

DON'T

Do not nail or pin the Part close to the edge; the Part may chip or crack.

Be sure to nail the Part perpendicular to the high slope inside the cove as shown in the detail (Step 8.) This will ensure maximum holding power and minimize the possibility of chipping.

Optional Assembly Processes:

A cold press casein glue, as referenced in materials required, may be used for Part installation. With this type of glue, the following methods may be used for a slab door only:

1. Follow steps 1-11 for assembly. Upon completion, stack down the material with weight on the Parts as the last step. This will hold the parts flat while the glue cures.

2. You can also use a hold-down jig utilizing a simple plywood cutout and tension hold-downs (as shown). Follow steps 1-7 and use hold-downs to keep part in place until glue cures.



The following options are possible with both slabs and pre hung door units:

3. Use brad nails of the same length as the pins (specified in the material list) nailed in the same places. The brads will provide good hold down power and will not require the use of a stack down method or hold-down clamps. However, the brads will require touch up work before painting. Follow all other steps as indicated above.

4. Use a double sided tape as the adhesive. 3M offers two (2) tapes: 3M Double Sided Tape 9500 and 3M Double Sided Tape 9549 LE. Use a 1" wide tape. Follow 3M's application instructions to use the tape. Note that once applied, the tape cannot be easily removed so accuracy on the first try is important. Apply the tape to the Parts, not to the door. Once the tape is firmly in place on the Part, peel the backing from the other side of the tape and set the Part in place. Ensure the Part is in the correct location. Use a roller, such as a wallpaper seam roller, along the top surface of the Part to set the Part in place.

The Parts will work with a variety of adhesives and installation methods. Consult with your adhesive supplier for tips and recommendations on application.

IMPORTANT: Read and understand all application instructions before adhering the Part to the Product (CraftMaster Caiman® or Carrara®). The statements expressed in this technical document are the recommendations for the application of the product as outlined and illustrated under normal conditions of installation. CMI is a manufacturer of building materials, including CraftMaster doors, but not the Cellini Part referred to in this document. CMI does not practice architecture or engineering or other manufacturing. The recommendations provided in this bulletin represent our best judgement based on our experience to date with normal application. CMI is not responsible for the inaccurate application of the Part to the Door.

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