

## Guidelines for glueing Varia to vertical surfaces

Varia can be adhered directly to a wall using the instructions below. Recommended substrates are: painted dry-wall, painted wood or sealed wood.

## Materials Needed

### CUSTOMER SUPPLIED

- 1" wide foam brushes

### ADHESIVES NEEDED

- 3M Primer 94. 3form part #3-05-0072 (1 can for every 25ea. 4x8 sheets of material)
- 3M VHB 4496 (Double sided foam tape) 3form part # 3-20-313 (1 roll for every 2 sheets)
- Momentive SCS 1201 Structural silicone 3form part # 3-05-0070 (1 tube for every 2 sheets).
- Extruded aluminum support angle (part# 3-15-1320) This angle must be used for any material over 1/4" thick. See example diagram on next page.

## Installation Process

### ATTACHING THE ALUMINUM SUPPORT ANGLE (3/8" - 1" GAUGE)

All 3form materials that are 3/8" - 1" thick MUST be supported at the bottom of the panel. For thinner gauges, angle support not required. Support must be attached structurally and level to the wall. Make sure to countersink screws into the angle so they do not stick out and damage the sheet.

- Determine location of studs in the wall where sheet will be adhered.
- Predrill and countersink the aluminum to line up with the studs.
- Screw the angle to the wall making sure it remains level.
- This angle will help support the material as well as give you a ledge to rest the sheet on to aid in alignment when gluing panels to the wall.

### GLUING AND ADHERING PROCESS

3/16" and 1/4" Varia can be adhered to vertical surfaces without bottom support.

- Lay sheet face down on a clean, dry, supported surface. Make sure you do not scratch or scuff the sheet.
- Determine the layout of the VHB tape and use the foam brush and Primer 94 to lightly seal only the area where the VHB tape will bond to the Varia.

- Apply the VHB tape over the areas that you primed and use a J-roller to roll the VHB tape down which will make it bond instantly.
- Use Momentive silicone to place dabs on the back of the panel per the sketch
- RECOMMENDED: For best possible adhesion to the wall, also determine where the vhb tape will bond to the wall and apply a thin layer of Primer 94 to the wall and let flash off. Be careful when applying the sheet to the wall as once it sticks, it will not come back off.
- For full sheets, it will be important to have 2 people to help attach the sheets to the wall. Rest the bottom of the sheet on the aluminum angle and then as you raise the sheet up, make sure it is plumb before it sticks.
- Use your hand or a J-roller to apply pressure to the areas where the VHB is placed to assure the best bond.
- Repeat process on subsequent sheets.

### LARGE INSTALLATIONS

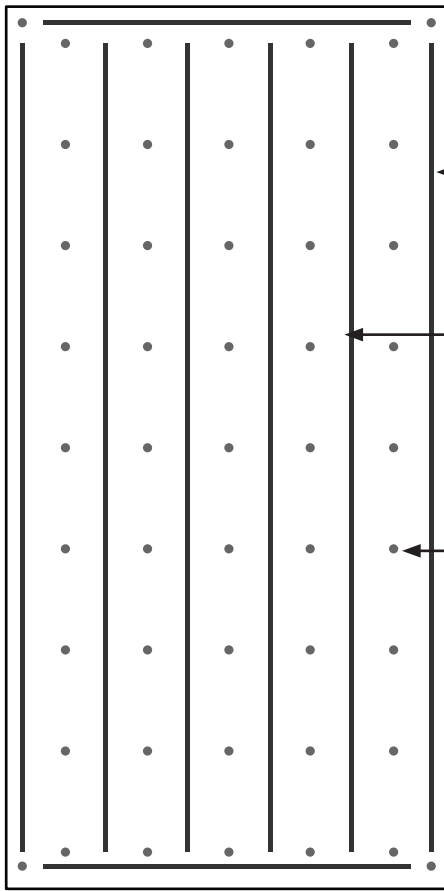
When adhering multiple panels on vertical surfaces, it is critical to follow instructions below:

- For installations 8' - 16' wide, standard Direct glue methods can be used as long as there will be at least a 1/4" space on both sides of the installation. Panels can butt tight together with standard 3form 1/8" x 1/8" quirk between panels.
- For installations 20'-40' wide, it is required to have a 1/8" gap between panels and a 1/2" space on both sides of the installation. The wall can be painted a complimentary color where the reveals are located.

### LARGE INSTALLATIONS (STACKING PANELS VERTICALLY)

When adhering multiple panels on vertical surfaces, it is critical to follow instructions below:

- For installations 16' - 40' tall, 3form recommends using 1/4" Vaira with 1/8" reveals between panel both horizontally and vertically and at least 1/2" space on both sides and top and bottom of overall installation. The wall can be painted a complimentary color where the reveals are located.



Typ. keep vhb tape 4"  
away from corners

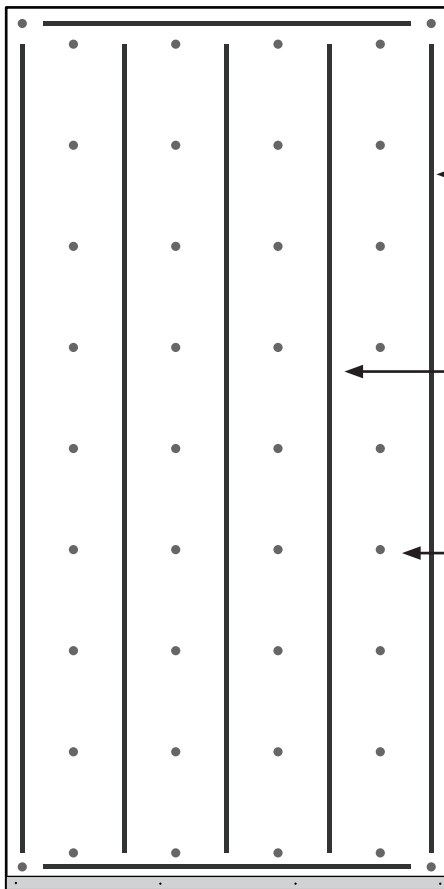
Use single strip of VHB  
tape around perimeter

Space intermediate VHB  
tape ~8" O.C.

Typ. apply silicone as  
secondary adhesive

### 3/16" & 1/4" GAUGE SHEETS

Sheets 1/4" gauge or less can be  
adhered directly to wall without  
bottom support angle



Typ. keep vhb tape 4"  
away from corners

Use single strip of VHB  
tape around perimeter

Space intermediate VHB  
tape ~12" O.C.

Typ. apply silicone as  
secondary adhesive

For gauges 3/8" or greater,  
install aluminum support  
angle to carry panel weight  
(part# 3-15-1320)

### 3/8" - 1" GAUGE SHEETS

Sheets 3/8" in gauge and above  
require bottom support angle  
(part# 3-15-1320) when adhering  
panel to wall