

WELDING INSTRUCTIONS

Fiberglass Framing



Introduction:

Special-Lite® Fiberglass Frames may be ordered Knock-Down for chemical welding with construction adhesive prior to installation. These instructions cover this process in the field. For more detailed instructions on painting the frames after welding, please refer to the instructions for Painting and Repair of Smooth Fiberglass Doors and Frames.

Please Note:

- These instructions are general guidelines provided to help prevent problems caused by the most common errors. They are strictly recommendations and are not intended to be a step-by-step, foolproof checklist suitable for every situation. There are many variations not covered in these instructions that Special-Lite assumes are general knowledge to an experienced installer.
- Selection of an experienced professional as well as consulting the instructions of the products used and their manufacturer's recommendations is the sole responsibility of the project owner or responsible party. Special-Lite makes no representations as to the proper use of other manufacturers' products.
- Due to the variability of supplies, application conditions, and techniques, all of which are beyond the control of Special-Lite, Special-Lite is not responsible for the performance of field applied adhesive, filler, paint, or individual application techniques.
- Failure to follow good practice in installation will void the warranty on Special-Lite products. Sanding, painting, or otherwise altering the original finish of the product will void any finish warranties that may apply to the product.
- If you have any questions, please call 1-800-821-6531 and ask for a Special-Lite Customer Service Representative. You can find these and other Instructions on Special-Lite's website at special-lite.com/installation-instructions.

Safety:

- Use proper personal protective equipment, such as goggles and gloves.
- Ensure proper ventilation in the area.
- Depending on the chemicals you choose, you may also need a face mask.
- Keep away from heat and open flame; Chemical products may be flammable.
- Materials used for mixing and application should be disposed of properly.

Installation
Resources:



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Recommended Supplies:

- Mild detergent, isopropyl alcohol, or MEK solvent
- Clean water
- Clean cloths or rags for cleaning and wiping
- Scotch-Brite™ 7447 General Purpose Hand Pads
- Fine-grit sandpaper (220-grit & 400-grit)
- Polyester/plastic body filler suitable for fiberglass such as Bondo and hardener
- Construction adhesive such as F-26 or Liquid Nails
- Clamps

Ensure you have all these supplies readily available before you start the process.

Step 1: Lightly sand or scuff any surfaces that will be welded, filled, or painted.

- A. Lightly sand any surfaces that will be welded, filled, or painted with Scotch-Brite™ 7447 General Purpose Hand Pads or 220-grit sandpaper to promote adhesion.

Step 2: Clean the frame and corner reinforcements.

- A. Clean the frame and reinforcements with a clean cloth or rag and mild detergent and water. You may also use isopropyl alcohol or MEK solvent. Avoid hydrocarbon solvents as they may leave a residue.
- B. Rinse well with water and allow to air dry.

Step 3: Apply adhesive and clamp the frame.

- A. Apply construction adhesive to the joining faces of the frame and corner reinforcements, following the adhesive manufacturer's instructions.
- B. Clamp the corner reinforcements and jamb legs in place while they set up for the manufacturer's recommended amount of curing time.

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Step 4: Fill miter crevices and screw holes, if desired.

- A. After the adhesive cures, if you wish to fill miter crevices and screw holes first ensure you have lightly sanded and cleaned the surface to be filled.
- B. Then, mix and apply an automotive body filler and coordinating hardener (such as Bondo, or other polyester/plastic body filler recommended for fiberglass) following the manufacturer's directions on how to apply the product.
- C. Sand smooth, completing your final sanding with 400-grit sandpaper.

Step 5: Prime and paint the frame, if desired.

- A. For priming and painting procedures for fiberglass frames, please refer to the Painting & Repair Instructions for Fiberglass Doors & Frames.