

## **WALL CLADDING**

**Important! Expansion gaps must be provided for wall cladding.**

### **Procedure for General Interior Cladding (13 mm thick sheets)**

It is not necessary to fix MDF batons on the wall if the wall is fairly level.

1. Cut the sheets to the required panel sizes.
2. Spray Silicone or paste silicone paper tape on the wall at the Velstone seam locations.
3. Drill and counter bore holes through the all the panels using drill/countersink/counter bore combination drill bit. The holes should be approximately 50 mm from the corners and no more than 1000 mm diagonally apart. Choose the drill bit diameter at least 3-5 mm larger than the screw diameter. The selected screws must never be tight in the hole. Apply 3 heavy zigzag lines of silicone on the back of the first panel and fix it in position.
4. “Dry fix” the second panel. Gap should not be seen between the two panels. Remove the second panel.
5. Apply 3 heavy zigzag lines of silicone on the back of the second panel. Mix and apply Velstone Adhesive the edges of the first and second panel. Press the second panel firmly against the first panel and then screw the second panel to the wall. Align the edges and surfaces of both panels. The Adhesive from the joint must be squeezed out from the entire length and the general principles of butt joining will apply with the exception of the reinforcing strip.
6. Repeat step 4 until all the panels are installed.
7. Select the “Plug Maker” cutting tool, matching to the combination drill bit used earlier. Cut out plugs from a surplus piece of Velstone leftover from first step. Clean the counter bore and the plugs. Apply Adhesive to the counter bore and firmly press in the plug. The plugs will project out of the panel surface dependent on the depth of the counter bore.
8. Allow the Adhesive to harden then sand off the joints and projecting plugs.
9. Finish the entire cladding as required.

### **Procedure for Secure Units/Cells Cladding (13 mm thick sheets)**

1. Nail WBP - Weather and Boil Proof plywood on the wall using Hilti fasteners.
2. Cut 13 mm Velstone sheets to size and prepare the edges for tongue and groove joint.
3. Fix 1st 13 mm Velstone sheet using the Silicone adhesive\*.
4. Drill and counterbore, no more than 1000 mm apart, through Velstone sheet.
5. Screw Velstone to WBP.
6. Apply Velstone Adhesive to the tongue and groove joint and start installing the 2<sup>nd</sup> sheet.
7. Repeat steps 3~6 until complete area is covered.
8. Use plug cutter to prepare Velstone plugs out of surplus material.
9. Glue the plugs with Velstone Adhesive and tap fit in the counterbore. Allow the glue to dry and harden.
10. Sand off excess plug and glue and finish the surface using random orbital sander.

#### **\*Silicone Adhesive:**

Use water based mastic adhesive from reputed manufacturer. Carefully read safety and application instructions on the pack. The surface should be clean, dry and free from dust, oil, grease or any other contamination. Apply approximately 400 grams adhesive per square metre of the substrate (WPB) using notched spreader. Velstone should be bonded to the substrate when the adhesive is still tacky (approximately 20~40 minutes depending upon the adhesive, the substrate and the temperature). Press Velstone firmly on substrate and hold approximately for two hours. Remove the clamps or weights. A good bond now will be in place. Allow at least 24 hours for the bond to fully cure.