

# medex<sup>®</sup>

## Finishing Guidelines



### SDF

sustainable design fiberboard

Exterior grade Medex MDF panels have a fine surface that takes paint, vinyl and other high-tech decorative surfaces exceptionally well and when properly sealed, provide you with a versatile substrate for your signage needs.

For best results, the characteristics of Medex must be given serious consideration and properly incorporated into the design of the end product. To ensure the best results, follow these step-by-step finishing instructions.



FSC Certified  
(Mixed Credit)  
Cert no. SCS-COC-001409  
© 1996 FSC



EPP Certified  
Composite Panel Association  
Environmentally  
Preferable Product



Potential of 6 LEED<sup>®</sup>  
Credits Supported  
Materials & Resources:  
4.1, 4.2, 5.1, 5.2, 7  
Indoor Environmental  
Quality: 4.4



SCS Certified  
Post-Industrial Recycled  
Wood Fiber  
No-Added  
Formaldehyde

### Finishing Steps

Routing

Sanding

Sealing

Priming

Top Coating

Mounting

Fasteners

# SierraPine

COMPOSITE SOLUTIONS

Delivering **innovation,**  
**quality & value** with pride.

[www.sierrapine.com](http://www.sierrapine.com)

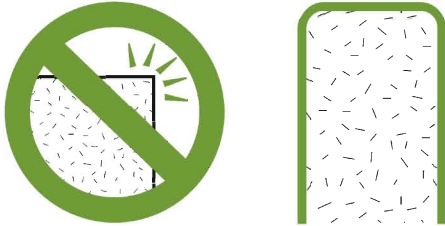
800.676.3339

# Finishing Guidelines

NOT TO BE USED FOR EXTERIOR SIDING OR TRIM

## Routing

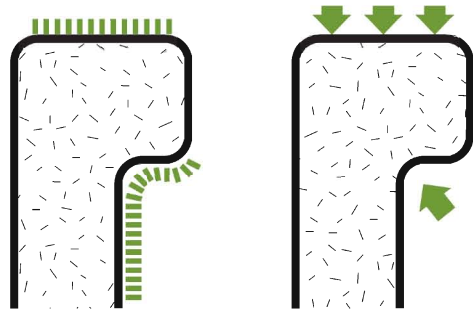
1



Radius or rout all 90 degree edges to a minimum 3/16" radius in order to improve paint film build up over this area.

## Sanding

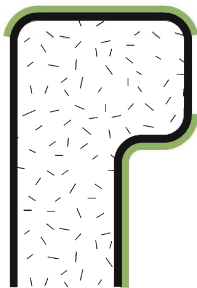
2



Sand all edges and/or machined areas to reduce the amount of raised wood fibers which prevent proper sealing on the unsanded surfaces.

## Seal Coat

3



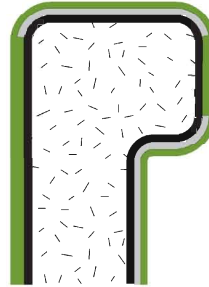
This seal coat is for all edges and those areas where the lower density core area is exposed. Sand lightly after drying.

### PRODUCTS TO USE

- a) 2-part epoxy
  - b) Solvent based polyurethanes
- NOTE: Lumber (e.g. deck) sealers are not recommended.

## Prime Coat (all surfaces)

4

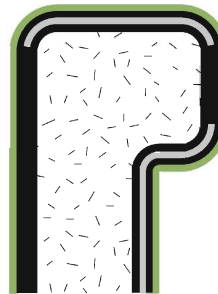


Use a solvent-based prime coat to a minimum 1.5 mils dry film build. Latex prime or top coats NOT RECOMMENDED.

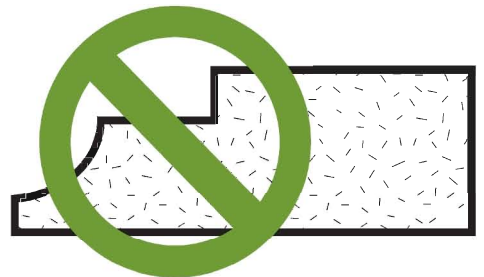
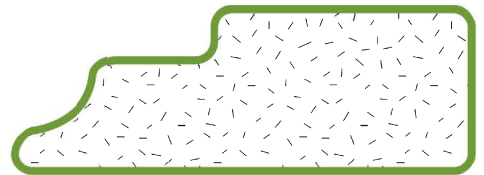
NOTE: A prime coat is not a substitute for sealing or topcoating.

## Top Coat (all surfaces)

5



IMPORTANT: Automotive type paints are not to be used unless the sign has already been sealed as described.



Dry film build of top coat - minimum 2.5 mils.

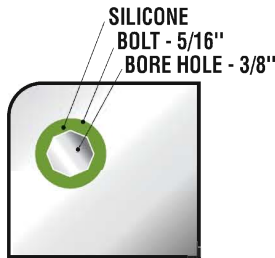
Reminder: All paints will draw away from a sharp edge or corner, regardless of what is being painted: metal, plastic, lumber, plywood and Medex. Because the paint is very thin on this area, any expansion and contraction resulting from ambient changes will cause the paint to crack.

# Attachments & Mounting

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## Mounting

With the potential for lineal expansion over the life of the sign, mounting holes should be made oversized. Fill excess area with silicone and cap with a washer large enough to cover the area. Do not tighten so that washer is pulled through the paint.



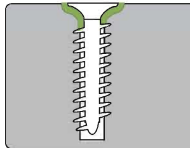
Do not use wood screws or nails to attach edge capping to Medex.



### Screws to use:

DECK SCREW

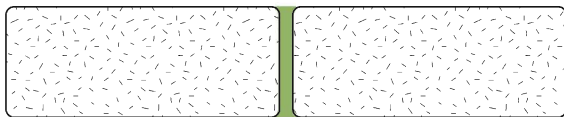
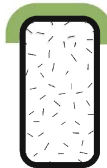
Drill pilot hole at 85-90% of the root diameter of the selected screw. Apply bead of silicone in counter sink area to seal hole.



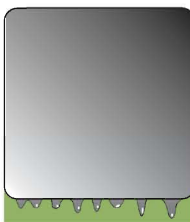
NOTE: Drill hole 1/16" deeper than length of screw. Lag bolts are not recommended.

## Edge Protection

When attaching edge protection to Medex do not penetrate the edge. Use silicone to attach any edge cap to the perimeter of the sign.

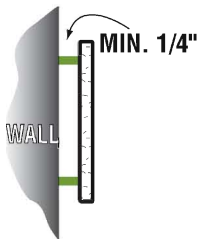


When butt-fitting Medex, always coat adjoining edges with silicone after finishing steps have been completed.



Moisture will form a drip-line on the bottom of vertical panels. Be sure to seal bottom edges to prevent moisture absorption.

Do not flush mount to any wall. There should be a minimum of 1/4" spacing using furring strips or galvanized washers.

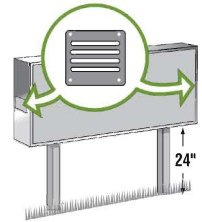


## Frame-Mounted Signs

Frame-mounted signs must be vented on sides and bottom for moisture drainage and evaporation.

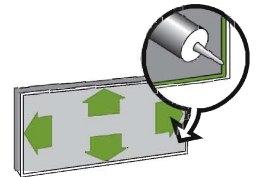


Enclosed-type signs must be vented (2 sides) to prevent humidity/moisture buildup on the inside.



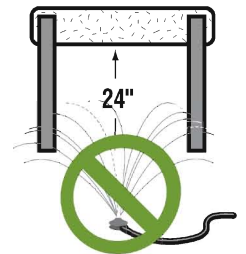
NOTE: Medex must be sealed on all sides in this type of application.

Framed perimeter signs must be sealed with silicone caulk where the panel meets the frame.



## Post Mounting

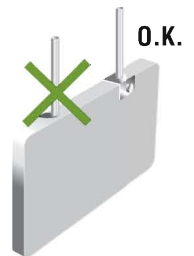
Medex must be supported at both ends with at least 24" between the sign bottom and the ground. Do not mount where there will be direct contact with water from ground or irrigation systems.



Because Medex is a non-structural panel, do not use cantilevered mounting. Minimum height above ground — 24 .



For hanging signs, use a clevis and pin attachment. Do not use mounting bolts into the edge.



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## LIMITATIONS

Medex is not suitable for structural applications.

- No average value of a single panel in a multi-panel sampling shall be more than ten percent out of compliance with the requirement in ANSI A208.2.
- Medex is manufactured with no added formaldehyde and recognized as exempt from emission testing requirements under ANSI A208.2 and CARB ATCM 93120. The listed emissions are due to formaldehyde naturally present in all wood fiber.
- Stock panel size is 49" x 97" in thicknesses of 3/8" - 1+1/4". Custom sizes (up to 5' x 18' and cut-to-size are also available. Non-stock items may be subject to mill run and/or minimum order quantities. Please ask your SierraPine sales representative.
- The word "exterior" as used in this context indicates compliance with ASTM D1037 six-cycle accelerated aging test. When painting Medex for exterior use, the paint application should be sufficient to achieve a total dry film build through the sign face of 4.0 to 4.5 mils.
- Medex will readily accept most exterior coatings formulated for application over wood and wood products. A minimum prime coat film thickness of 1.5 mils (dry) is recommended for exterior applications. Topcoats used over properly primed Medex should be applied to achieve a dry film build of 2.5 to 3.0 mils, creating a total dry film build through the sign face of 4.0 to 4.5 mils. Edge sealing is critical to long-term product performance in exterior applications.

NOTE: Wood, wood products and many paints are susceptible to degradation from fungal growth and ultraviolet radiation. Many commercially available primers contain an antifungal ingredient. If your prime coat does not contain such an ingredient, it is recommended that one be included. Translucent and clear primers generally offer unsatisfactory protection against ultraviolet radiation.

# medex®

Technical Date	Imperial	Metric
Density	48 lb/ft <sup>3</sup>	769 kg/m <sup>3</sup>
Internal Bond	200 lb/in <sup>2</sup>	138 N/mm <sup>2</sup>
Modulus of Rupture	6,000 lb/in <sup>2</sup>	41.34 N/mm <sup>2</sup>
Modulus of Elasticity	600,000 lb/in <sup>2</sup>	4,134 N/mm <sup>2</sup>
Modulus of Hardness	1,200 lbs, Janka ball	5,338 N
Screw Holding, Face	350 lbs	1,557 N
Screw Holding, Edge	275 lbs	1,223 N
Thickness Tolerance	+/- 0.005 inch	+/- 0.127 mm
Thickness Swell	3%	
Linear Expansion	0.30%	
Water Absorption	5%	
Flame Spread Rating	Class C (3)	
Moisture Content	4 - 6%	
Formaldehyde Emissions	as low as 0.01 ppm	

Average physical properties for 3/4" panel when tested in accordance with ASTM D1037. Specific design applications and technical data are available upon request.

Board Thickness	Maximum Span
3/8	12"
1/2"	16"
5/8"	24"
3/4" and thicker	36"

### Limited Warranty Provided to Distributors as Follows:

SierraPine warrants to the distributor or original equipment manufacturer (collectively Distributor), that as of the date of shipment, the product shipped is free of defects in materials and workmanship. Any product found to be defective by the distributor (and so noted to SierraPine in writing within thirty (30) days of the receipt of the shipment) will be repaired or replaced by SierraPine. The repair or replacement of these products is in lieu of all liabilities or obligations of SierraPine for damages, including consequential damages, in connection with the sale or use of these products. This warranty constitutes the sole and entire warranty pertaining to these products. SierraPine makes no other warranty, guarantee or representation of any kind whatsoever. All other warranties, including but not limited to, merchantability and fitness purpose, whether express or implied, are hereby disclaimed.

## SierraPine

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