



PALIGHT® Trimboard

Foam PVC for Trim and Molding Applications





At Palram, we've manufactured high-performance PVC products since 1963. That's why, year after year, we're a world-leader in PVC building materials—and why other leading suppliers around the globe rely on us to engineer and manufacture their products.

Specializing in the production of PVC and Polycarbonate, Palram manufactures products used for construction, architecture, agriculture, graphics & display, and more.



Palram Ltd. is a global company with manufacturing and sales located around the world. Palram Americas is based in the USA, and manufactures Palight Trimboard in its Kutztown, PA production facility.



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WELCOME to the crossroads of old world craftsmanship and new world workability, durability, and uniformity. Palight Trimboard offers the centuries-old familiarity and workability of wood, but with none of the drawbacks. It won't rot, fade or split. And it holds its beautiful appearance for decades.

Available in typical wood profile sizes, architects and builders can easily incorporate Palight Trimboard into nearly any trim project for a beautiful and lasting finish.

Why Palight Trimboard?

- Reliable product from a world leader in PVC manufacturing
- Cut it, shape it, fasten and paint it easily
- Smooth edges and consistent, uniform dimensions
- Low maintenance—impervious to moisture, rot, or insects
- Long-lasting durability and beauty
- Available in standard and ProFinish™ profiles
- 30 year limited residential warranty



Competing Product



High-Density Free Foam™

Palram's HDF² PVC Technology™ creates a dense, uniform cell structure, which allows outstanding workability.



GET PROTECTION from dust, dirt and abrasion. It comes standard with Palight Trimboard. Simply remove the protective release film after installation and let your work shine. Palight Trimboard also features sealed edges, making it easy to wipe away dirt and dust before, during and after installation.

Sealed Edges & Protective Release Film. Standard.



SMOOTH OR WOOD GRAIN. Whether your job requires a smooth, clean finish or a more rustic wood grain appearance, we've got your choice covered. Our wood grain surface rivals that from Mother Nature herself. But ours holds up a little longer, and with less maintenance.

Smooth or Wood Grain. The choice is yours.



Leave the wood in the woodpile. Palight makes the job easier at every stage.

Before the Job Begins

Palight trimboard offers all the workability of wood, but with none of the drawbacks.

- Doesn't warp due to moisture – No searching through stacks looking for a straight piece.
- Comes in standard lumber sizes – No need to learn new math.
- Rain? Snow? – No problem. Waterproof.

Keep Your Job Flowing Smoothly

Split. Crack. Pop. Those are some sounds you won't hear using Palight Trimboard. But you'll be quite familiar with the sound of a nail gun, the buzz of a saw, and the whir of a drill or router.

- Use standard tools - Your trusty carbide tipped woodworking tools will serve you well.
- Uniformity - No twists, knots, or inconsistencies.



- Standard fastening methods - Rout it. Drill it. Saw it. Nail it. Glue it.
- Need to conform to a curve? Palight can be easily thermoformed in advance or on the job.
- Made white, stays white - Palight has a UV protected smooth finish that doesn't require painting.
- Want a top-notch finish, or need another color? Palight can easily be painted. Just use standard 100% acrylic latex paint.

After the Job is Done

The punch list will be shorter, and the callbacks fewer.

- Impervious to Insects - No insect damage, ever.
- 30 Year Transferable Warranty* - That's a lot better than the wood you've been using—and most other PVC Trimboard brands too.

Property	PALIGHT Trimboard	Wood
Rot, mold and insect resistant	★	X
Virtually waterproof	★	X
Direct contact with masonry	★	X
Resistant to splitting	★	X
No pre-drilling required to avoid splitting near edges when nailing	★	X
Self extinguishing	★	X
Does not require paint, stain, or varnish for weather protection	★	X

* See full warranty for details, page 12.

With so many profile dimensions available,
it's hard to call them standard.

Standard Profiles*									
Nominal Thickness	2"	3"	4"	5"	6"	8"	10"	12"	16"
1/2" (1/2" actual)	★		★		★	★	★	★	
5/8" (5/8" actual)	★		★		★	★	★	★	★
1" (3/4" actual)	★	★	★	★	★	★	★	★	★
5/4" (1" actual)	★	★	★	★	★	★	★	★	★
6/4" (1-1/4" actual)			★		★	★	★	★	

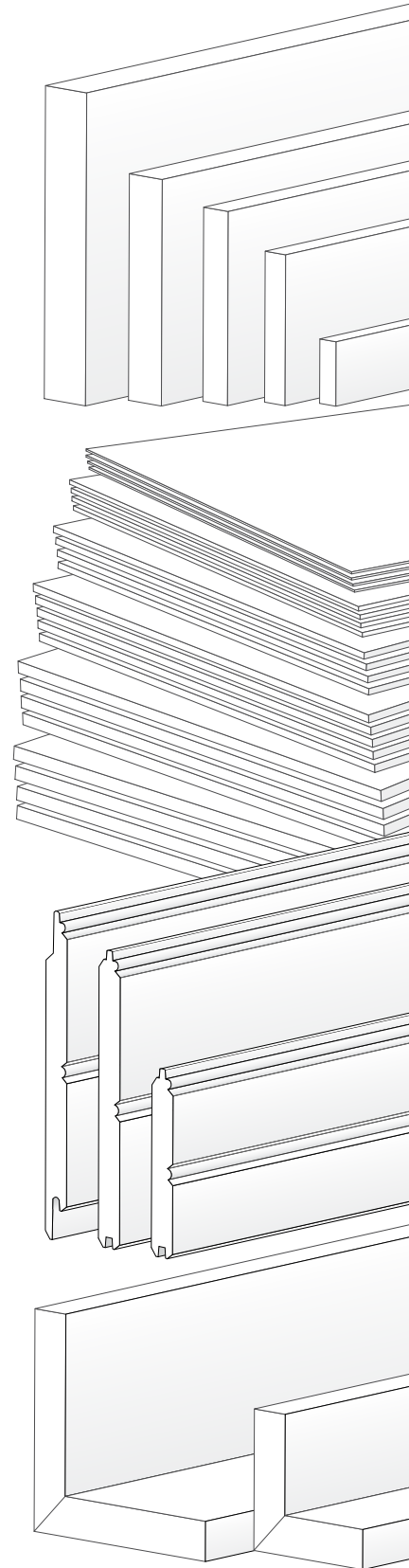
* Contact Dealer for stock lengths. Custom lengths available with minimum order.
Wood grain/smooth or smooth/smooth surfaces available.

Full Sheet					
Actual Thickness	4' x 8'	4' x 10'	4' x 12'	4' x 18'	4' x 20'
3/8"	★	★	★	★	★
1/2"	★	★	★	★	★
5/8"	★	★	★	★	★
3/4"	★	★	★	★	★
1"	★	★	★	★	★
1-1/4"	★	★	★	★	

Special dimensions available. Ask a Palram Representative for details.

Accessories			
	10'	18'	20'
Bead Boards*			
1/2" x 4"		★	
1/2" x 6"		★	
1/2" x 6 w/nailing strip		★	
Corner Boards (available in smooth or wood grain finish)			
5/4" x 4"	★		★
5/4" x 6"	★		★
5/4" x 8"	★		★

* Beaded sheet is available in 1/2" x 8' and 10' sizes

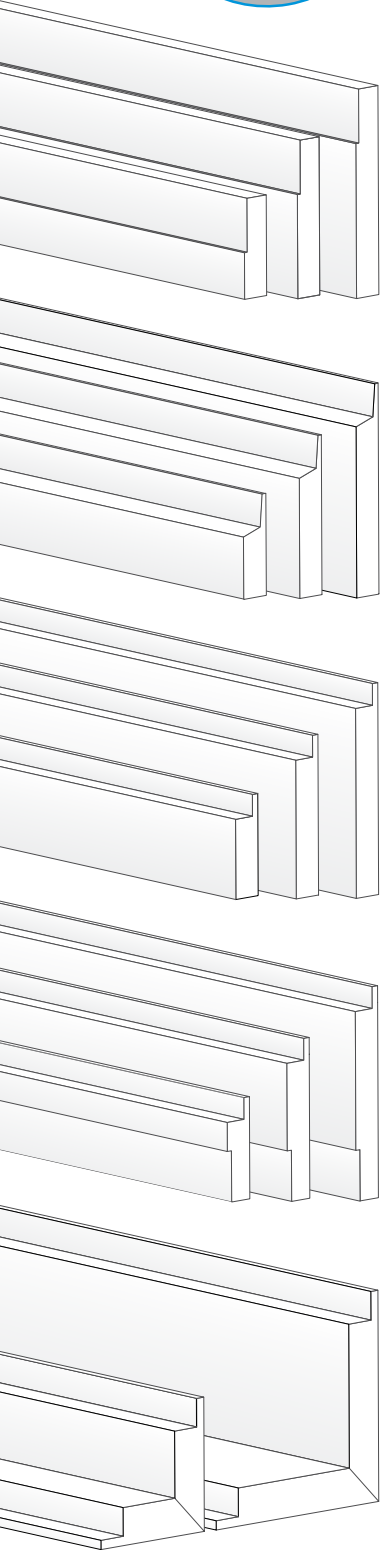




Finish the job like the Pro that you are. Faster.

As a professional, your primary goal is to end up with an excellent fit and finish. As a business person, you look for ways to save time while improving quality. With Palight ProFinish™ Profiles from Palram, you can do all of the above. Designed to accommodate the most popular finishing applications, ProFinish profiles are available in four main profile shapes.

All ProFinish Profiles are available in smooth or wood grain finish.



Trimboard with Window Fin Relief	10' Length	18' Length	20' Length
5/4" x 4", 6", 8"	●	★	●

Skirt Boards	10' Length	18' Length	20' Length
1" x 4", 6", 8"	●	★	●
5/4" x 4", 6", 8"	●	★	●

J-Channel – Standard	10' Length	18' Length	20' Length
5/4" x 4", 6", 8"	●	★	●

J-Channel – With Window Fin Relief	10' Length	18' Length	20' Length
5/4" x 4", 6", 8"	●	★	●

J-Channel – Corner	10' Length	18' Length	20' Length
5/4" x 4", 6", 8"	★	●	★

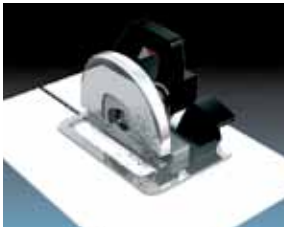
★ Stock Profile Length ● Available via special order. Minimum order required.

Working with Palight Trimboard

Storage and Handling

- Store Palight Trimboard on a flat and level surface.
- Since Palight Trimboard products are more flexible than wood, they may conform to uneven surfaces.
- Palight Trimboard has a density comparable to pine and should be handled in a fashion as pine would be handled to avoid damage.
- Units of Palight Trimboard are shipped from the manufacturer in a protective covering. If covering has been removed, take care to keep product free of dirt and debris at job site. If product gets dirty, clean after installation.

Cutting



Palight Trimboard can be cut using the same tools used to cut lumber. Carbide tipped blades designed to cut wood perform well. Avoid using fine tooth metal cutting blades. Rough edges from cutting

may be caused by excessive friction, inadequate board support, worn blades, or incorrect tools.

Circular Saws

Carbide-tipped, triple chip, ground type circular saws can be used to cut Palight Trimboard or Sheets. The following settings are recommended:

- **Rake angle:** 0 to 15
- **Clearance angle:** 10 to 20
- **Cutting speed:** 4,000 to 8,000 feet per minute
- **Feed:** 70 to 90 feet per minute
- **Tooth pitch:** 0.080" to 0.040"

Band Saws

High speed steel blades normally recommended for wood or plastic can be used for Palight material based the following guidelines.

- **Teeth per inch :** 6 to 8
- **Cutting speed:** 3,000 to 5,000 feet per minute
- **Feed:** up to 40 feet per minute

Saber Saws

Rough cut type blades ground for plastics can be used on Palight sheets. Smooth metal-cutting blades are not recommended.

Drilling



Palight can be drilled with carbide-tipped bits using twist drills recommended for metals.

The following settings are recommended:

- **Point angle:** between 90 to 110
- **Spiral angle:** 30
- **Relief angle:** 10
- **Cutting speed:** 150 to 1,300 feet per minute
- **Feed rate:** 0.01 to 0.02 inches per revolution

The minimum distance from the edge should be 2 times the hole diameter.

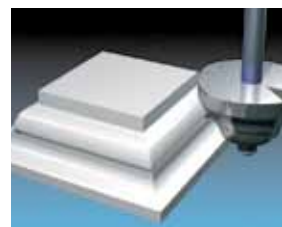
In an effort to reduce heat build up during drilling of thicker Palight sheets, it may be necessary to periodically remove the drill bit from the Palight material.

Milling

Palight can be milled by using standard milling machines of various types utilizing the following guidelines:

- **Relief angle:** 5 to 10
- **Rake angle:** -10 to 0
- **Cutting speed:** 3,000 to 3,500 feet per minute
- **Cutting feed:** 0.12 inches per revolution

Routing



Palight material can be easily routed using multi-fluted carbide tools on standard woodworking routers. Standard tools and machines can be utilized with no need to alter equipment. Adjust

feed and speed rates as needed to achieve the best edge finish on the Palight parts.

- Palight Trimboard can be routed using standard router bits and the same tools used to rout lumber.
- Carbide tipped router bits are recommended.
- Routing Palight Trimboard provides a crisp, clean edge.

Thermal Expansion & Contraction

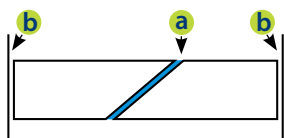
As with most plastics, Palight foamed PVC will expand and contract with an increase or reduction in temperature (*for comparison, wood expands and contracts due to moisture*). This material property is known as linear thermal expansion and contraction.

Since Palight Trimboard can be used in a wide variety of indoor and outdoor applications, linear thermal expansion and contraction may need to be considered during the fabrication and installation of the material. It is important to take in to account the temperature at which the Palight material was fabricated, as well as the temperature of the installation.

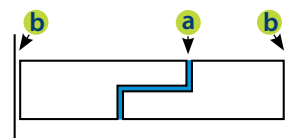
Palight should not be used in applications or climatic conditions that exceed 140° F (**ambient or surface temperature**), at which temperature the Palight will soften and permanently deform. Paint color selection must also be considered, as some colors absorb heat and can easily exceed the maximum allowable temperature of 140° F. See "Painting" section on page 10.

Temperature Dictates Gap Requirements

	a Scarf or Ship Lap Joint	b End
100°	Tight	Tight
50°	1/8"	1/16"
Below 50°	> 1/8"	> 1/16"



45° Miter / Scarf Joint



Ship Lap Joint

- When properly fastened, allow 1/8 inch per 18 foot of Palight product for expansion and contraction. Joints between pieces of Palight should be glued to eliminate joint separation. See "Gluing" section.
- When gaps are glued on a long run of Palight, allow space for expansion and contraction at ends of the run.

Fastening

- For best results, use fasteners designed for wood trim and wood siding (thinner shank, blunt point, full round head).
- Palight is made to last. Use a highly durable fastener such as hot dipped galvanized or stainless steel.
- Staples, small brads, and wire nails must not be used.
- The fasteners should be long enough to penetrate the solid wood substrate a minimum of 1½".
- Standard nail guns work well with Palight Trimboard products.
- Like wood, use 2 fasteners per every framing member for trimboard applications (See Figure 1 below). Trimboards 12" or wider, as well as sheets, will require additional fasteners.
- Fasteners must be installed no more than 2" from the end of each board (See Figure 2 below).
- Palight should be fastened into a flat, solid substrate. Fastening Palight into hollow or uneven areas must be avoided.
- Pre-drilling is typically not required unless a large fastener is used or product is installed in low temperatures (typically 40°F or lower).
- 3/8" and 1/2" sheet product is not intended to be ripped into trim pieces. These profiles must be glued to a substrate and mechanically fastened.

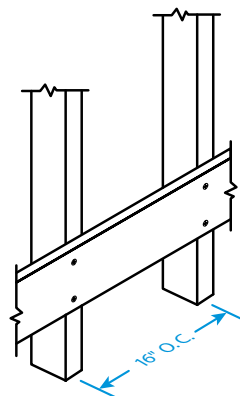


Figure 1

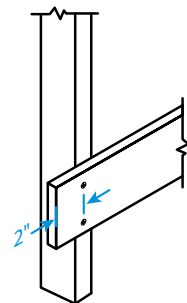


Figure 2

Spanning

- Palight products must not be used in load bearing applications, but may be used in spanned applications such as soffits and ceilings.

Soffit installations:

- For spans of 16" - 24", use a 1 x Palight product.
- When using Palight Beadboard, fasten every 12" or less.
- Install Palight Beadboard perpendicular to structure.

Ceiling installations:

- For spans of 16" - 24", use a 1 x product.
- When using Palight Beadboard or thinner Palight product, fasten every 12" or less.
- 16" spans are okay with Palight Beadboard with Nailing Strip only.
- Never span Palight products more than 24".

Gluing and Bonding of Palight

General Information

Palight material can readily be bonded to itself or other materials. Commercially available adhesives that are suitable for bonding rigid PVC materials can be used for this purpose (see Page 9 for more info).

There are several considerations when choosing an adhesive:

1. The material to be bonded with Palight
2. Strength required—structural vs. non-structural
3. Temperature range expected
4. Expansion/contraction
5. Ease of application methods, curing times
6. Cost effectiveness
7. Environmental and safety considerations—flammability, fumes, odors, etc.

General Gluing / Bonding Tips

- For best results, glue all Palight to Palight joints such as window surrounds, long fascia runs, etc., with adhesive approved for use with Palight to prevent joint separation.
- The glue joint should be secured with a fastener and/or fastened on each side of the joint to allow adequate bonding time.
- "Glue & screw" joints together (See Figures 3 and 4 below)
- Most adhesives approved for use with Palight have a working time of 10 minutes and will be fully cured in 24 hours.
- If standard PVC cements are used, keep in mind these products typically cure quickly which will result in limited working time and may reduce adhesive strength.
- For best results, surfaces to be glued should be smooth, clean and in complete contact with each other.
- To bond Palight to other substrates, various adhesives may be used. Consult adhesive manufacturer to determine suitability.
- See table "Adhesives and Manufacturers" on page 9.

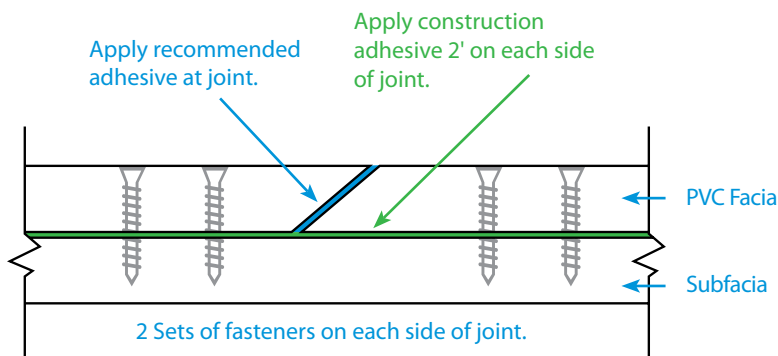


Figure 3: Scarf Joint

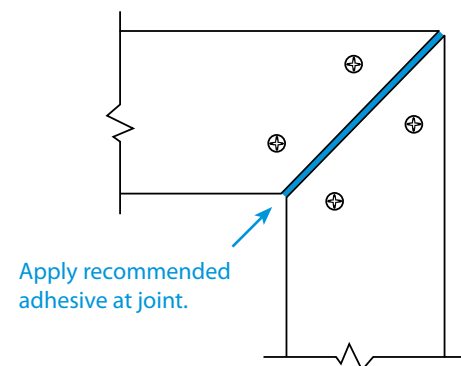


Figure 4: Miter Joint

Surface Preparation

In order to attain the optimum bond, the Palight material surfaces to be bonded must be cleaned and de-greased using a clean white cloth soaked in isopropyl alcohol.

Selection of Adhesives

The selection of the proper adhesive for a project depends on the materials to be joined, as well as the end use and other considerations mentioned previously.

The following suggestions serve as general guidelines:

A. Bonding Palight Material to Palight Material

1. For edge bonding and joining parts made of Palight material, use a PVC solvent such as (THF, MEK, cyclohexanone solvent systems).
2. For bonding large areas: If using PVC solvent such as pipe cement, spread with notched trowel and work rapidly.

B. Bonding Palight Material to Non-Porous Solid Material (such as PVC, other plastics or metal):

1. Contact adhesive with solvent:
 - a. Neoprene, nitrile, polyurethane or other synthetic rubber types.
 - b. Adhesive must be applied to both faces. Parallel beads of adhesive are often preferred because it allows evaporation of solvent providing faster cure.
 - c. Use a slow setting adhesive, when bonding large areas. This allows for more time to properly install the panels prior to the adhesive curing.
 - d. For bonding Palight material to flexible PVC sheets, only plasticizer-resistant types of adhesives should be used.

C. Bonding Palight Material to Porous Materials (such as paper, textiles, fabrics or wood).

1. Contact adhesive with solvent: Same systems as for non-porous materials.
2. Construction mastic, structural silicone adhesives.

Considerations such as expected temperature ranges (expansion/contraction), substrate and size of Palight material panels should be taken into consideration when deciding on a method of attachment.

Adhesives and Manufacturers

The table below lists several adhesives and their bonding applications for materials commonly used in fabricating Palight products. The listed adhesives and manufacturers are for informational purposes only. Please perform the appropriate tests to ensure that the materials will produce desired results.

Adhesive	Manufacturer	Phone / Website	Adhesive Type	Palight	Aluminum	Wood	Masonry	Acrylic	Plastics	Galv. Steel	Polystyrofoam
Tetrahydrofuran (THF)	ISP Technologies	973-628-4000	Solvent	★							
IPS Weld-on 2007	IPS Weld on	310-898-3300	Solvent Mixture	★				★	★		
PVC Pipe Cement	Multiple Mfgs.		Solvent Mixture	★					★		
TACC 15-165	TACC Intl.	781-878-7015	Synthetic Rubber								★
Scotch Grip Plastic Adhesive 4475	3M	800-362-3550	Solvent Mixture	★							
Liquid Nails LN 602	Liquid Nails	800-634-0015	Synthetic Rubber	★	★	★	★		★	★	
Parabond P28 Cement	Parabond	800-763-7272	Solvent Mixture	★				★	★		
DOW 795 Silicone	Dow Corning	dowcorning.com	Silicone	★	★	★					
Bostik 4045	Bostik Corp	bostik-us.com	Solvent Mixture	★							

Painting

- Palight Trimboard does not require paint for protection, but may be painted to achieve a desired color.
- Use paints that are 100% acrylic latex or acrylic latex with a urethane additive.
- It is recommended that you use only stock colors that are compatible with PVC trim. If you have a custom colors mixed, it is possible that incompatible materials may be added to the paint during the custom colors blending process.
- Follow the paint manufacturer's recommended procedures for preparation and application.
- No special surface preparations are required prior to painting—just ensure the Palight surfaces are clean, dry, and dust-free.
- Fine dust can collect on the surface of Palight due to static. To ensure a dust free surface that will promote good paint adhesion, leave the protective film in place and remove just prior to painting. If protective film has been removed, wipe trimboards with a rag moistened with isopropyl alcohol prior to painting, or mild detergent and water.
- Moisture cycling is a main reason for paint failure on wood. Since Palight absorbs no moisture paints last longer on Palight than wood (usually 3 to 4 times).
- Because Palight Trimboard does not absorb moisture, paint can take as long as 30 days to fully cure, depending on outdoor temperatures and humidity.
- **Palram is not liable for paint used on Palight Trimboard and/or the results of its use.**

Just peel and paint.



Palight Trimboard features a protective film mask that helps prevent fine dust from adhering to it, which can inhibit paint adhesion. The protective film is designed to be left on the trimboard until it's ready to be painted (up to 90 days after installation).

IMPORTANT: Selecting the right paint

PVC trimboard can become distorted as a result of heat absorption. To prevent this, be sure to select colors with a Light Reflectance Value (LRV) of 55 or higher.

If you use a color with an LRV of 54 or less, it must be specifically formulated by the paint manufacturer for use on vinyl/pvc products. For example, some colors within Sherwin-Williams' VinylSafe™ paints line have LRV's less than 55, but are designed to reduce excessive heat gain.



Manufacturers of PVC Compatible Paint

Company Name	Phone	Website
Blue River Coatings	888.420.2628	www.bluerivercoatings.com
Glidden Professional (AkzoNobel)	888.863.8424	www.gliddenprofessional.com
PPG	724.274.4500	www.ppg.com
Sherwin Williams	800.321.8194	www.sherwin-williams.com

Chemical Resistance

The mechanism of chemical attack on thermoplastics in general, and PALRAM PVC sheets in particular, differs significantly from the mechanism of corrosion of metals. Corrosion of metals results in a gradual loss of surface material as a result of electrolytic action by the relevant chemicals. Chemical attack on PALRAM PVC sheet, where it occurs, consists generally of absorption of the chemical by the PVC sheet and its subsequent swelling. The chemical resistance behavior of PALRAM PVC sheets is therefore simple to determine. The chemical resistance is expressed in terms of weight change (usually an increase) and volume change.

Palram maintains a chemical compatibility list on its web site. To download the most up-to-date version of the following Chemical Resistance list, please visit the following URL:

http://www.palram.com/Media/Doc/Chemical_Resistance_PVC.pdf

PSDS Sheet

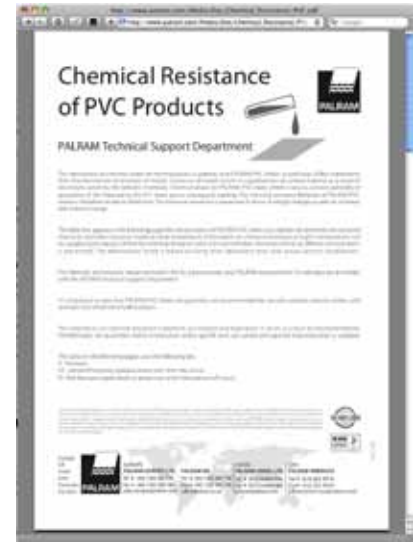
Download a detailed copy of the PSDS (use in place of MSDS Sheet) for PALIGHT at the following URL:

http://www.palram.com/Media/Doc/PALRAM_PSDS_Foamed_PVC.pdf

Physical Properties

Download a detailed Physical Properties Table for Palight Trimboard at the following URL:

<http://www.PalightTrimboard.com>



PALIGHT® Trimboard

Express Transferable 30 Year Limited Warranty

PALRAM Americas ("PALRAM") hereby warrants that the PALIGHT Trimboard Product ("Product") will be free from manufacturing defects that cause the Product to delaminate, corrode, rot, or excessively swell for thirty (30) years from the date of original purchase.

PALRAM's liability under this express Limited Warranty ("Warranty") is limited to replacement of the defective Product or, if PALRAM so chooses, a refund of what you paid for the Product, as verified by the applicable receipt. This is your SOLE AND EXCLUSIVE REMEDY for claims under this Warranty.

This Warranty is subject to the following limitations and conditions:

- (1) You must be the owner of the property where and when the Product is first installed, but this Warranty will transfer automatically from owner to owner of the property when legal title to the property is transferred within the Warranty period provided above. When that happens, the term "you" as used in this Warranty means the new owner. This Warranty will be void if the Product is moved to a different property.
- (2) The Product must have been purchased from an authorized PALRAM dealer.
- (3) This warranty does not cover damage to the Product as a result of:
 - (a) intentional or accidental misuse, abuse or other damage, including vandalism, impact of foreign objects, improper maintenance, use of incompatible accessories or application of harmful chemicals;
 - (b) installation of the Product or its structural supports in violation of PALRAM's instructions and guidelines, including use of the Product to bear excessive loads;
 - (c) damage to the structural supports or accessories used with the structural supports (including, but not limited to, settlement, movement, distortion, warping or cracking);
 - (d) ordinary and expected weathering due to exposure to the elements (which may include fading, darkening or chalking);
 - (e) weather events and other Acts of God (including, but not limited to, earthquakes, hurricanes, floods, tornadoes, ice, snow, hailstorms, fire, windstorm and lightning); or
 - (f) acid rain, industrial emissions, air pollution or other harsh atmospheric or environmental conditions.
- (4) This warranty does not cover any paint or other coatings applied by you or anyone else. Failure to follow PALRAM's recommendations regarding paints and other coatings may void this Warranty.
- (5) This warranty only applies to non-commercial use of the Product.
- (6) This Warranty is the only warranty made by PALRAM to you or anybody, including subsequent owners with regard to the Product.

ALL IMPLIED WARRANTIES, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, ARE LIMITED IN DURATION TO THE LENGTH OF THE WARRANTY PERIOD PROVIDED ABOVE OR ON THE APPLICABLE WARRANTY CERTIFICATE. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATIONS MAY NOT APPLY TO YOU. You are solely responsible for determining whether this Product is suitable, effective or safe for your intended use(s) or application(s) and whether your use(s) or application(s) comply with local governmental codes or restrictions.

- (7) PALRAM will not be responsible for the cost of any labor, installation, re-installation, loss of time, inconvenience, damage to other property or persons, loss of use of the property, freight, taxes, shipping or any other costs related to the defective Product.
- (8) PALRAM ALSO WILL NOT BE RESPONSIBLE FOR ANY SPECIAL, DIRECT, INDIRECT, INCIDENTAL, EXEMPLARY OR CONSEQUENTIAL DAMAGES UNDER ANY THEORY OF RECOVERY, WHETHER BASED IN CONTRACT OR TORT (INCLUDING NEGLIGENCE AND STRICT LIABILITY), UNDER THIS WARRANTY OR OTHERWISE. Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation or exclusion may not apply to you.

Making a Warranty Claim

To make a claim under this Warranty, within ninety (90) days from your discovery of the defective Product, you must send: (1) your proof of purchase; (2) photo(s) of the defective Product; and (3) a written description of the defects to:

PALRAM Americas, 9735 Commerce Circle, Kutztown, PA 19530

The defective Product must remain installed until PALRAM makes a determination regarding the defective Product. PALRAM may investigate any claim made by you under this Warranty and test the defective Product. Your failure to keep the defective Product installed and permit such investigation and testing may void PALRAM's Warranty.

No representative, agent or dealer has any authority to change the terms of this Warranty, give any other warranties, or make any statements or representations regarding the Product except for those specifically contained in this Warranty or PALRAM's Product documents. This Warranty may not be amended or altered except by a written statement signed by PALRAM's authorized representative and you. PALRAM will not be bound by any statements or representations made to you that go beyond the terms of this Warranty.

Some states may not permit the limitations stated above. This warranty gives you specific legal rights. You may also have other rights which vary from state to state.



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Authorized Distributor

FI303 1.04.2012 SCS

In as much as PALRAM Industries has no control over the use to which others may put the material, it does not guarantee that the same results as those described herein will be obtained. Each user of the material should make his own tests to determine the material's suitability for his own particular use. Statements concerning possible or suggested uses of the materials described herein are not to be construed as constituting a license under any PALRAM Industries patent covering such use or as recommendations for use of such materials in the infringement of any patent. PALRAM Industries or its distributors cannot be held responsible for any losses incurred through incorrect installation of the material. In accordance with our company policy of continual product development you are advised to check with your local PALRAM Industries supplier to ensure that you have obtained the most up to date information.

