FLEX TRIM

Manufacturer of Architectural Flexible Molding and Poly Resin Decor

FLEXIBLE MOLDING

IMPORTANT ORDERING INFORMATION

I. **FIRST**, determine the specifics of your Flex Trim product order application:

STANDARD		CUSTOM
TRUE RADIUS FLEX CASING		IRREGULAR RADIUS CASING
STRAIGHT FLEX CASING		RADIUS CROWN MOLDING
STRAIGHT FLEX BASE MOLDING		ELLIPTICAL CASING
STRAIGHT FLEX CROWN MOLDING		OVAL CASING
STRAIGHT FLEX PANEL MOLDING		ROUND COLUMN BASE MOLDING
STRAIGHT FLEX CHAIR RAIL		ODD IRREGULAR RADIUS SHAPES
SMALL SQUARE MOLDING PROFILE		LARGE MOLDING PROFILE

II. **IF YOUR APPLICATION IS STANDARD**, determine if it requires the product to be ordered as pre-formed or straight. Typically, molding profiles that are to be bent in the direction according to the wider width dimension (sideways) are ordered pre-formed, and if bent according to the thinner thickness dimension are ordered as straight. We can pre-form and bend the molding lengths in our factory into shapes that straight lengths on a job site cannot bend to fit. Pre-forming guarantees a perfect fit. *(see inside for detailed ordering information)*

III. **IF YOUR APPLICATION IS CUSTOM**, determine if it is a true radius or irregular radius requiring a template to be provided to us. Some elliptical casings can be pre-formed with only shop drawings and measurements. If a template is required, make it out of paper to the exact inside radius shape edge and send it to us via mail or ups. *(see back for detailed ordering information)*

IV. **DETERMINE THE PRICE YOU PAY** by simply multiplying our quoted price per linear foot times even numbered footage amount needed for standard product order applications, and add 20% for custom orders that require special handling of templates, or custom forming of some molding profiles for complex radius applications. Some custom applications may incur additional set-up cost. We do not make molding length pieces less than 4 foot or longer than 12 foot. Dealer, distributor and professional trade discounts available.

V. **IF YOUR PRODUCT APPLICATION** cannot be accommodated, as either standard or custom, or according to our limitations specified, we may be able to hand make it. Consult an Inside Sales Representative for further information and possibly a custom set-up quotation.

HOW TO ORDER GUIDE

In General...

HANDLING: Our flexible molding does not have to be warmed up to avoid cracking or breakage, although heating the material does make it more flexible. No special storage precautions are required.

GRADES: We have both paint grade and stain grade.
smooth (paint grade), pine grain (stain grade), and oak grain (stain grade), occasionally we have other wood grains (refer to the flex trim catalog or our web site www.flextrim.com) not every profile comes in a stain grade, if you need stain grade and we don't have it, consider our Custom Profile Set Up (see below).

STAINING: Our stain grade products do not require special fake glaze coatings. No primer is necessary and there for no primer paint coating to crack and show through when stained. Our product is porous and will accept most stain brand products.

Installation...

FASTENING: All Flex Trim Molding products are made to be cut, fitted, and fastened in the same manner as with real wood. Nails and panel adhesive glue are used (wood glue does not bond material well). The fastening of moldings in general (as with real wood), requires care when nails are placed near edges. Splitting may occur and pre-drilling of nail hole is suggested. When fitting molding into position, center and trim cut both ends of molding length section equally.

PAINTING AND STAINING: Most brands of paint or stain have been found to work well. When staining, best results are obtained by removing excess stain with a clean and dry soft bristle paint brush. This dry brush technique will remove excess stain in molding profile design areas that are difficult to reach and wipe off with a cloth, and it will distribute stain evenly on the surface and allow highlighting of dark and light color areas. Stain color results may vary from real wood. So, test color match prior to staining, and always clean material first with solvent or paint thinner to remove any foreign residue. Seal stain afterwards preferably by spraying lacquer or polyurethane clear coat.

STRAIGHT FLEX

"Base molding and profiles that are dimensionally square"

SOLD PER LINEAR FOOT

In General...

WALL BASE, PANEL, CHAIR RAIL FLEXIBILITY AND LIMITATIONS

Minimum 12" radius unless ordered as a tendency to cup when bent. Straight flex base molding will not flex to fit a 3/4" radius bullnose corner (corner blocks are available)

STRAIGHT FLEX CASING FLEXIBILITY AND LIMITATIONS

1. Min 60" radius for profiles up to 2-1/2" wide
2. Min 120" radius for profiles is 2-1/2" to 4" wide

CROWN MOLDING FLEX LIMITS

1. Minimum 96" radius for profiles 3" to 4" wide
2. Minimum 120" radius for profiles 4" to 6" wide
3. Minimum 144" radius for profiles 6" to 8" wide
4. Minimum 168" radius for profiles 8" to 9" wide
5. Minimum 192" radius for profiles 9" to 10" wide

CUSTOM PROFILE SET UPS

"We Tool To Match Your Profile"

To order simply:

1. Submit a full size drawing of the molding profile shape and specify the application.

2. To place an order we may require that you ship to us, freight pre-paid, a minimum 13 foot long piece of the actual molding (stain grade requires a full 13 foot long piece) for us to use as a model for tooling set up duplication. Short multiple pieces can be sent via UPS, but can be used for paint grade tooling set ups only. Do not ship molding models without placing an order first.

3. The surface quality of the molding you furnish is what you will receive. Stain grade requires quality raw wood grain texture free of defects, and one continuous length.

4. In some instances shrinkage may occur from the original model size provided.

5. Tooling set up models become property belonging to Flex Trim , Inc., unless otherwise agreed and any proprietary profile pattern claims are null and void if lack of purchasing activity by customer during a 6 month period following last date of sale.

STRAIGHT FLEX WALL BASE, CASING, CROWN, PANEL, AND CHAIR RAIL

To order these types of products simply choose a material length from 4-12 feet and:

1. Mulitply length times molding profile price per linear foot to calculate price
2. Provide our order entry part number description when ordering as shown below:

Denotes Product
F = FLEX TRIM
Z= ZzzzFLEX

Denotes Grade

F-XXXXX-X-SXX/X STRAIGHT FLEX MOLDING

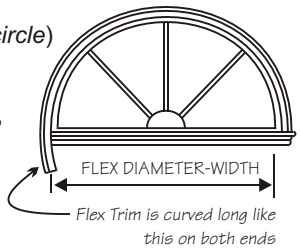
5 Digit Profile Number
Example: WM356

Denotes Straight
Length. Example: S12/0

TRUE RADIUS ROUND TOP HALF CIRCLE CASING

To order this type of product simply:

1. Determine diameter dimension (*distance across inside width of circle*)
2. Determine radius dimension (*half of diameter dimension*)
3. Multiply diameter dimension times 2 to calculate length
4. Round length up or down to nearest even footage 4-12 feet long,
   FOR EXAMPLE: *diameter 2'/4" (28") X 2 = 56" rounded up to 5 feet*
5. Multiply even footage length times our molding profile price per linear foot to calculate price
6. Larger than 6'/0" diameter requires 2 quarter circles, or multiple arc segments (*circumference exceeds 12' long*)
7. Provide our order entry part number item description when ordering as shown below:



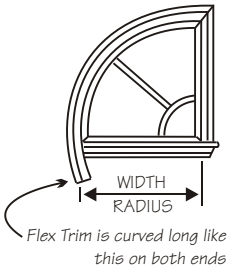
Denotes Product F = FLEX TRIM Z= ZzzzFLEX → **F-XXXXX-X-PXX/X XX RAD 1/2 CIR DX/XX XXX** ← Specify TEO,TEI,NEO,or NEI

- 5 Digit Profile Number Example: WM356
- Denotes Grade
- Denotes Pre-Formed Length. Example: P12/0
- Radius of 1/2 Circle. Example: 36
- Diameter. Example: D6/0

TRUE RADIUS QUARTER CIRCLE CASING

To order this type of product simply:

1. Determine inside width and radius of 1/4 circle portion
2. Verify radius is same as width or height
3. Multiply radius dimension times 2 to calculate length
4. Round length up or down to nearest even footage 4-12 feet long
   FOR EXAMPLE: *radius 18" X 2 = 36" rounded up to 4 feet (minimum)*
5. Mulitply even footage length times molding profile price per linear foot to calculate price
6. Provide our order entry part number item description when ordering as shown below:



Denotes Product F = FLEX TRIM Z= ZzzzFLEX → **F-XXXXX-X-PXX/X XXX RAD 1/4 CIR XXX** ← Specify TEO,TEI,NEO,or NEI

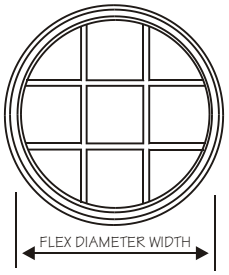
- 5 Digit Profile Number Example: WM356
- Denotes Grade
- Denotes Pre-Formed Length. Example: P06/0
- Radius Of 1/4 Circle. Example: 36

TRUE RADIUS FULL CIRCLE CASING

To order this type of product simply:

(continuous length up to 3'/0" diameter only)

1. Determine diameter dimension (*distance across inside width of circle*)
2. Verify that half of the diameter dimension is the radius dimension
3. Multiply diameter dimension times 4 to calculate length
4. Round length up or down to nearest even footage 4-12 feet long,
   FOR EXAMPLE: *diameter 26" X 4 = 104" rounded up to 9 feet*
5. Multiply even footage length times molding profile price per linear foot to calculate price
6. Order 2 true radius 1/2 circles or multiple radius arc segments for full circles larger than 3'/0" diameter
7. Provide our order entry part number item description when ordering as shown below:



1 piece Flex Trim all the way around up to 3 feet diameter with 1 splice joint

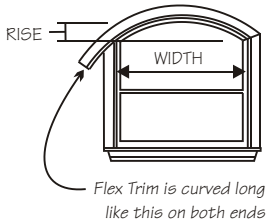
Denotes Product F = FLEX TRIM Z= ZzzzFLEX → **F-XXXXX-X-PXX/X XX RAD FULL CIR DX/XX XXX** ← Specify TEO,TEI,NEO,or NEI

- 5 Digit Profile Number Example: WM356
- Denotes Grade
- Denotes Pre-Formed Length. Example: P12/0
- Radius of Full Circle. Example: 18
- Diameter: Example: D3/0

ARC EYEBROW SEGMENT CIRCLE

To order this type of product simply:

1. Determine arc radius using inside rise and width dimension of arc segment circle
2. Divide width dimension by 2 and multiply it times itself (squared)
3. Mulitply height dimension times itself (squared)
4. Add new width sum and new height sum together
5. Divide sum total by height dimension first mulitplied times 2 to calculate radius dimension
6. Determine material length by multiplying rise times 3 and adding sum to width
7. Round length up or down to nearest even footage 4-12 feet long,
   FOR EXAMPLE: 7" R X 3 = 21" + 60" W = 81" rounded up to 7 feet
8. Mulitply even footage length times molding profile price per linear foot to calculate price
9. Provide our order entry part number item description when ordering as shown below:

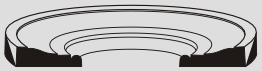


Denotes Product F = FLEX TRIM Z= ZzzzFLEX → **F-XXXXX-X-PXX/X XXX RAD ARC SEG HXW XXX** ← Specify TEO,TEI,NEO,or NEI

- 5 Digit Profile Number Example: WM356
- Denotes Grade
- Denotes Pre-Formed Length. Example: C12/0
- Radius of Arc Segment. Example: 50
- Rise Height and Width Of Arc

STANDARD TRUE RADIUS PRE-FORMED FLEX

"Casing and all other moldings that will lay flat and curve sideways in a true radius arc circle fashion"



SOLD PER LINEAR FOOT

In General...

TRUE RADIUS CASING FLEXIBILITY RANGE

1. Diameters 1'/6" - 3'/0" will expand 4" and contract 2" if the profile is not larger than 3/4" X 3-1/2" (larger size profiles will restrict flexibility for diameters within this range)
2. Diameters 4'/0" and larger will expand 10" and contract 6" if the molding profile is not larger than 3/4" X 3-1/2" (larger profiles will restrict flexibility for diameters within this range)

PRE-FORMING LIMITATIONS

1. **Minimum** D4'/0" (24" radius) if the profile is 6" to 8" wide
2. **Minimum** D3'/0" (18" radius) if the profile is 5" to 6" wide
3. **Minimum** D2'/4" (14" radius) if the profile is 3'/2" to 5" wide
4. **Minimum** D1'/6" (9" radius) if the profile is 2" to 3'/2" wide

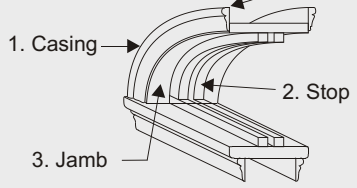
SPECIAL INSTRUCTIONS

1. Provide a molding placement drawing if application is not typical as shown below
2. To order true radius casing with straight legs, refer to how to order "Odd Casing" Specials

TYPICAL PROFILE APPLICATION

Normally we place thicker edge of molding profile to outside of radius. Provide a drawing if otherwise, or specify when ordering:

TEO=Thick Edge Outside
TEI=Thick Edge Inside
NEO=Notch Edge Outside
NEI=Notch Edge Inside



Note:
1. Casing is ordered pre-formed
2. Jamb is ordered as straight flex
3. Stop is ordered as straight flex

CUSTOM PRE-FORMED FLEX SPECIALS

"Products that require special pre-forming or handling, such as any radius with two or more curves"

SOLD PER LINEAR FOOT
PLUS 20% ADD ON

In General...

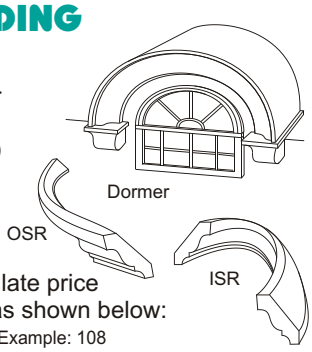
CROWN AND BASE MOLDING LIMITATIONS

1. **Minimum** 36" radius for profiles 8" to 10" wide and no restricted flexibility because of the molding width
2. **Minimum** 24" radius for profiles 6" to 8" wide, and the profile will flex 2" larger or smaller
3. **Minimum** 18" radius for profiles 5" to 6" wide, and the profile will flex 3" larger or smaller
4. **Minimum** 12" radius for profiles 4" to 5" wide, and the profile will flex 4" larger or smaller
5. **Minimum** 8" radius for profiles 3" to 4" wide, and the profile will flex 5" larger or smaller
6. **Minimum** 6" radius for profiles 2" to 3" wide, and the profile will flex 6" larger or smaller

ELLIPTICAL OUTBOARD RADIUS LIMITATIONS

1. **Minimum** 16" radius if the profile is 6" to 8" wide
2. **Minimum** 12" radius if the profile is 5" to 6" wide
3. **Minimum** 10" radius if the profile is 4" to 5" wide
4. **Minimum** 8" radius if the profile is 3" to 4" wide
5. **Minimum** 6" radius if the profile is 2" to 3" wide

TRUE RADIUS CROWN AND DORMER MOLDING



To order this type of product simply:

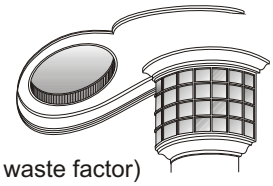
1. Determine radius dimension of wall or to outside edge of dormer
2. Convert any curved segment dimensions to radius
3. If the wall curves in and away from you its an **ISR** (*inside radius*)
4. If the wall curves out towards you its an **OSR** (*outside radius*)
5. *All crown dormer molding is ISR (inside radius)*
6. Supply a drawing of which way the crown is to be positioned
7. Determine length needed and add 2 feet (our waste factor)
8. Multiply length times molding profile price per linear foot to calculate price
9. Provide our order entry part number description when ordering as shown below:

Denotes Product: F = FLEX TRIM, Z= ZzzzFLEX
Denotes Grade
Radius Of Crown. Example: 108

F-XXXXX-X-CXX/X XXX RAD XXX CROWN

5 Digit Profile Number Example: WM356
Denotes Custom Length. Example: C12/0
Write ISR or OSR Here

IRREGULAR RADIUS CROWN AND DORMER MOLDING



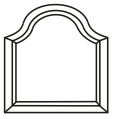
To order this type of product simply:

1. Make a template that fits against wall curve or to outside edge of dormer, and mark template with molding position information
2. Send us the template along with a drawing of which way the crown molding is going to be positioned relative to the template
3. Determine even footage length 4-12 feet needed and add 2 feet (our waste factor)
4. Multiply length times molding profile price per linear foot to calculate price
5. Provide our order entry part number description when ordering as shown below:

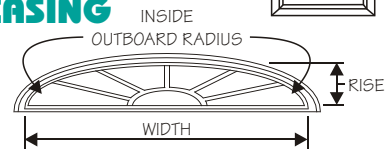
Denotes Product: F = FLEX TRIM, Z= ZzzzFLEX
Denotes Grade
Write ISR or OSR Here

F-XXXXX-X-CXX/X XXX PER TEMP CROWN

5 Digit Profile Number Example: WM356
Denotes Custom Length. Example: C12/0

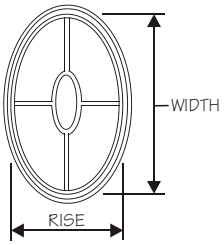


ELLIPTICAL, OVAL, AND ODD RADIUS CASING



To order this type of product simply:

1. Make a template that fits exact inside radius edge
2. Multiply rise times 3, add width, and round up to nearest even footage length 4-12 feet to calculate length
3. Multiply length times molding profile price per linear foot to calculate price
4. Provide our order entry part number description as shown below:



Denotes Product: F = FLEX TRIM, Z= ZzzzFLEX
Denotes Grade
Rise Height and Width

F-XXXXX-X-CXX/X WXH PER TEMP XXX ← Specify TEO, TEI,NEO,or NEI

5 Digit Profile Number Example: WM356
Denotes Custom Length. Example: C12/0

ROUND COLUMN CROWN AND BASE MOLDING

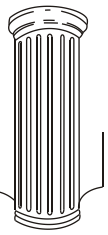
To order this type of product simply:

1. Determine exact diameter width of column and if 1/2, 3/4, or FULL coverage
2. Determine length needed, add 2 feet, and round up to even 4-12 feet (min-max)
3. Multiply length times molding profile price per linear foot to calculate price
4. Provide our order entry part number description when ordering as shown below:

Denotes Product: F = FLEX TRIM, Z= ZzzzFLEX
Denotes Grade
Diameter Of Column. Example: 13 3/4

F-XXXXX-X-CXX/X XXXXXX DIA XXX COL BASE

5 Digit Profile Number Example: WM356
Denotes Custom Length. Example: C04/0
Denotes 1/2, 3/4, or FULL



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