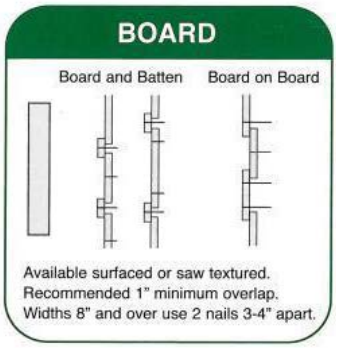
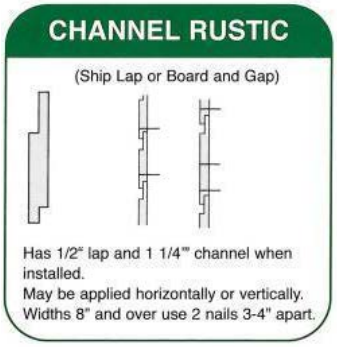
INSTALLATION INSTRUCTIONS

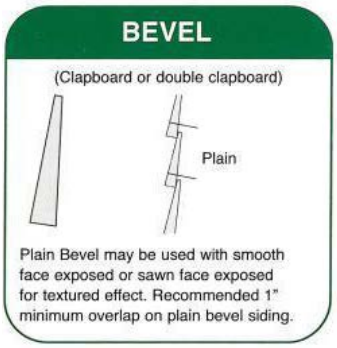
Acclimation: By storing Eastern White Pine (EWP) boards for a short period in the right climate, they become "seasoned" and will settle in to the dimension they'll hold for many decades to come. The boards should be stored, stickered, and protected for one week to ten days prior to application. Keep in mind that you are striving for an average moisture content for that region. During extremely dry or wet weather, you may want to wait for a period of average humidity to achieve the desired moisture content.

Nailing Requirements: The following requirements are essential for nails used on EWP siding:

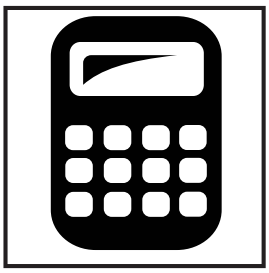
1. Rust-resistant, preferably rustproof.
2. Should not cause splitting even when driven near end or edge of siding.
3. Should have adequate strength to avoid the need for pre-drilling.
4. Nails should be able to be driven easily and rapidly.
5. A nail should not emerge or "pop" at any time after being driven flush with siding.
6. The nail head should not cause an unsightly visible pattern on the sidewall.
7. Nail butt joints at the stud or blocking.
8. Nailing is preferred over stapling.







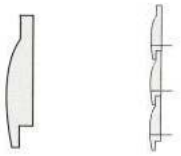
Installation and nailing instruction guides created by NELMA (Northeastern Lumber Manufacturers Association). NELMA is the rules-writing agency for Eastern White Pine lumber and the grading authority for the SPFs grouping of species that includes Eastern Spruce, Balsam Fir, Red Pine, and other commercially important softwood lumber species grown in the northeast and great lakes regions. In addition, NELMA is a leading agency for export wood packaging certification and the marketing voice for the regions' wood products industry.



Coverage: The following estimator provides factors for determining the exact amount of material needed for basic types of wood siding. ***Multiply square footage to be covered by factor (length x width x factor).***

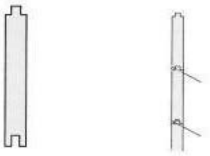
	Nominal Size	WIDTH Dress	Face	AREA FACTOR*
SHIPLAP	1 x 6	5 ½	5 1/8	1.17
	1 x 8	7 ¼	6 7/8	1.16
	1 x 10	9 ¼	8 7/8	1.13
	1 x 12	11 ¼	10 7/8	1.10
TONGUE AND GROOVE	1 x 4	3 3/8	3 1/8	1.28
	1 x 6	5 3/8	5 1/8	1.17
	1 x 8	7 1/8	6 7/8	1.16
	1 x 10	9 1/8	8 7/8	1.13
	1 x 12	11 1/8	10 7/8	1.10
S4S	1 x 4	3 ½	3 ½	1.14
	1 x 6	5 ½	5 ½	1.09
	1 x 8	7 ¼	7 ¼	1.10
	1 x 10	9 ¼	9 ¼	1.08
	1 x 12	11 ¼	11 ¼	1.07
PANELING PATTERNS	1 x 6	5 7/16	5 1/16	1.19
	1 x 8	7 1/8	6 ¾	1.19
	1 x 10	9 1/8	8 ¾	1.14
	1 x 12	11 1/8	10 ¾	1.12
BEVEL SIDING (1" lap)	1 x 4	3 ½	3 ½	1.60
	1 x 6	5 ½	5 ½	1.33
	1 x 8	7 ¼	7 ¼	1.28
	1 x 10	9 ¼	9 ¼	1.21
	1 x 12	11 ¼	11 ¼	1.17

LOG CABIN



1 1/2"' at thickest point.
Nail 1-1/ 2" up from lower edge of piece.

TONGUE & GROOVE



Available in smooth surface or rough surface. Use single Finish nail as shown for 6" widths or less. Wider widths, face nail twice per bearing.

Finishing: The planks should be finished with a clear sealer, wood stain, or penetrating oil, which will protect and enhance their natural beauty. For details about Hancock ProFinish primed boards, see pages 3–4.

For high traffic areas or high moisture conditions, a non-yellowing urethane topcoat is recommended. Always test the finish on a, sample piece before you apply. Consult with your retailer for finishing product selection.

More pine resources online: www.HancockLumber.com/PineFacts

NOTES:

1. Some patterns allow for greater dimensional change than others. Patterns such as bevel siding and channel rustic have the capability for greater joint movement than patterns such as tongue and groove.
2. Apply siding over building paper.

HANCOCK PROFINISH FACILITY

HANCOCK HPF PROFINISH

Finishing Done Right

Enjoy Less Prep + Faster Finishing!

We've leveraged state-of-the-art technology and cutting edge science to create the right coating formulations for eastern white pine boards, for both interior and exterior uses.

HANCOCK PROFINISH PRIMING ADVANTAGES

QUALITY ASSURANCE

- State-of-the-art equipment
- Coatings engineered specifically for eastern white pine
- Consistent application/mil thickness of both the UV seal and water-borne primer coatings
- QA testing for various factors, including: adhesion, holdout against pitch/resin migration through the film, proper UV cure, film continuity and integrity, inter-coat adhesion of UV sealer to the primer, and stack testing.
- HPF team inspects all boards throughout the process

THE RIGHT PARTNERS

- **Makor Group:** The market-leading manufacturer of wood-finishing machinery
- **Stiles Machinery:** The nation's largest team of service and support specialists for manufacturing solutions
- **AkzoNobel:** Bringing surfaces and finishing to life for over 200 years, they're experts in creating performance coatings for various substrates

TOP PERFORMANCE

- Initial acrylic sealer coat is a linkage layer with exceptional bonding properties (adhesion) between the wood and subsequent coatings, and also provides a highly moisture-resistant surface
- UV primer coat provides protection against pitch bleed from knots and resin pockets on all four sides and seals the lumber
- Final latex primer coat provides superior appearance, weather-resistance and top-coat adhesion that outperforms other primed products in the marketplace
- Three coats on face and edges work as a system for excellent durability and performance
- Rated for both interior and exterior use

CUSTOMER BENEFITS

- Environmentally friendly, with no VOCs
- Grown, milled, and finished in Maine
- Primed face is the grade face
- Improved quality and shorter supply lead-times
- Superior coating performance
- Enhanced overall appearance on primed side
- Direct distribution throughout Maine + New Hampshire to Hancock Lumber locations and on to jobsites

IN-HOUSE FINISHING

Taking the process in house costs more, but Hancock's commitment to quality makes it the right decision for us, our customers, and the environment.

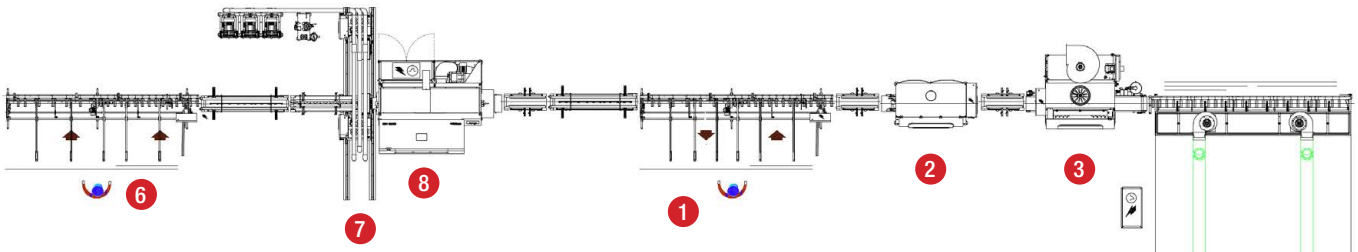
- Superior coating appearance and performance
- Tighter quality control means boards leave the HPF facility when they are perfect
- Custom-formulated coatings created for top performance on Eastern White Pine
- Consistent quality saves customers from picking through the bins to find good boards
- On-site finishing, no VOCs, and no trucking of products to a finishing facilitiy greatly reduces the carbon footprint and handling damage
- No hazardous waste is used or created in the process
- Custom formulations eliminate the oil-based coatings typically needed for Eastern White Pine
- Shorter and more predictable lead times to get product into the market

OPTIMAL PERFORMANCE

Following the steps below will help ensure that you get the best possible performance from our primed pine products.

- Store the product off the ground
- Field-prime all cut ends with high-quality primer
- Top coat within 90 days with high-quality, water- or solvent-based paint
- Custom-formulated coatings created for top performance on Eastern White Pine
- Shorter and more predictable lead times to get product into the market
- Back face is labelled for clarity when installing

THE PRIMING PROCESS



1. Semi-Automatic Profile Loader/Unloader: Material is loaded onto the line here with the best face oriented up.

2. Profile Denibb/Brush Machine: Boards are given a light sanding on all four sides, followed by vacuuming to remove all debris prior to coating being applied.

3. Profile Spray Machine: Boards are coated on three sides with water-borne acrylic sealer.*

4. Oven System with 180 Transfer: Temperature, humidity and feed rate are totally controlled to ensure proper slow drying and curing of the first sealer coat.

5. Oven System with 90 Transfer: Fans blow ambient air over the material to bring the wood temperature down in preparation for the next coating operations.

6. Semi-Automatic Profile Loader: Material is loaded back onto the line, again with the best face oriented up.

7. Double-Head Vacuum Coater: Six spray heads evenly and precisely flood coat UV-cured sealer on all four sides of the board, while the vacuum system pulls off all overspray for an optimal finish.*

8. Ultraviolet Lineal Oven System: The sealer coating is completely cured and dried via nine, custom-controlled UV light heads.

9. White Primer Coating: After the UV-cured sealer coat, boards go back through steps 2–5 for the white primer top-coat, resulting in ~8 dry-mil overall, protective coating thickness.

**All overspray is collected, filtered, and reused, minimizing material waste.*

"Our team is going to get the last look at every board before it's packaged. We're going to control the quality of the paint and make sure that every board that's in a pack belongs in that pack."

—Mike Shane, Casco Sawmill General Manager

Scan the Code to See a Video About the Priming Process.