

FrameSaver Stapling

Technical Bulletin Date – 9/17/08

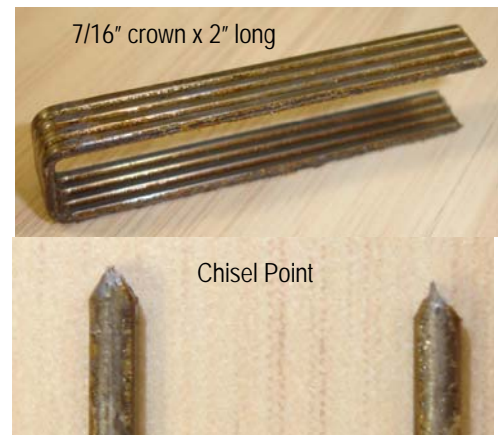
Endura Product Inc's FrameSaver jambs are comprised of composite material finger-jointed at the bottom of each leg. This composite material is approximately 2.9 times the density of pine, and thus requires some specific considerations when being stapled to a sill.

However, in Endura's experience, FrameSaver composite material can be assembled using staples and equipment normally found in a pre-hanging operation. Details are described below.

Staple Recommendations

Pneumatically driven staples are compatible with FrameSaver jambs. In particular, Endura recommends the following:

7/16" crown x 2" long
16 gauge, coated steel
Chisel point



Further Recommendations

Additionally, Endura recommends the following conditions when driving staples through FrameSaver into sills:

- Air line pressure into the pneumatic stapler should be 80 psi.
- The staple gun requires sufficient back force by the operator/ assembler to ensure gun kick-back does not occur. (Kick back will reduce the energy into the staple, and result in the staple being incompletely driven into the sill, or bunched-up at the surface.)

Example & Conditions of Properly Driven Staples

80 psi
Pneumatic staple gun held firmly
Staples 1/32" ~ 1/16" below surface



FrameSaver Stapling (continued)

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Examples and Conditions of Improperly Driven Staples

80 psi
Pneumatic staple gun held loosely
Staples 0" ~ 1/32" below surface



70 psi
Pneumatic staple gun held firmly
Staples 0" ~ 1/32" above surface



70 psi
Pneumatic staple gun held loosely
Staples 0" ~ 1/32" above surface



70psi
Pneumatic staple gun held loosely
Staples bunched up



60psi
Pneumatic staple gun held loosely
Staples ~ 1/4" above surface

