



Any fabrication procedure or technique not contained within the Wilsonart® Solid Surface Fabrication Manual will not be recognized by Wilsonart, LLC as an approved method of fabrication. Deviations from these techniques must be approved in writing by a Wilsonart Representative.



General Safety:

Safety is a critical concern for any shop and key to a successful business. The following safety rules should be incorporated into your safety program to help prevent an accident. Safety training, knowledge, product use and environment are the responsibility of the facility owner and the shop employees.

CAUTION: Always follow product, equipment and/or tool manufacturer's recommendations and instructions carefully.

- Read directions carefully before fabricating/installing Wilsonart® Solid Surface.
- Read and follow the instruction manual before operating the different tools.
- Keep all guards in place and in working order.
- Ensure all tools are properly grounded. Never remove the third prong.
- Keep work area clean, uncluttered and well lit.
- Don't use electric power tools in a damp or wet work area.
- Keep visitors at a safe distance from the work area.
- Use the right tools. Don't force a tool or attachment to do a job it was not designed to perform.
- Always use safety glasses or approved eye protection and/or face shield, ear/noise protectors and safety shoes. (FIG. 3A & 3B)
- Wear the proper apparel, no loose clothing or jewelry.
- Secure all work with the proper clamp or vise to a stable work surface.
- Don't overreach. Keep proper footing and balance at all times.
- Maintain tools in top condition. Disconnect tools before servicing and when changing accessories such as blades, bits, cutters, etc.
- Keep and use denatured alcohol, adhesives and materials in a safe, ventilated place.
- Dust collection should be used when cutting, routing and sanding. Tools should be used with dust collection at all times.



Figure 3A



Figure 3B

Wilsonart® Hard Surface Adhesive:

- Wilsonart® Hard Surface Adhesive is for professional use only. Always follow the manufacturer's recommendations and instructions carefully. (FIG. 1A)
- Warning: This seam kit contains the following hazardous ingredients: Methyl Methacrylate, Benzoyl Peroxide, and Dibutyl Pathlate. Avoid prolonged breathing of vapors. Use only in a well ventilated area. Keep out of reach of children. Eye protection is always recommended. Motors and other equipment used in the fabrication and installation process must be UL labeled explosion proof.
- For further information refer to Wilsonart® Hard Surface Adhesive Material Safety Data Sheet available on request. Contact your local distributor or call 1-800-433-3222 for immediate response.

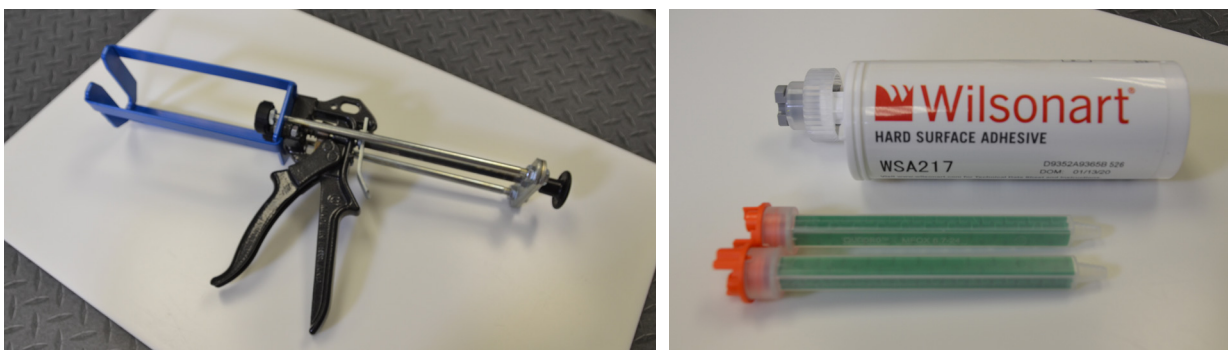


Figure 1A

FAB TIP:

- For Wilsonart Solid Surface hard seam design color chart, refer to www.wilsonart.com

HARD SEAM ADHESIVES

Wilsonart® Hard Surface Adhesive:

Wilsonart's Seam Adhesive is the latest generation of color matched adhesives for the surfacing industry. Developed to provide an inconspicuous seamless design look when seaming Wilsonart® Solid Surface components. Available in many pre-mixed colors; developed for modern demanding fabrication methods such as laminating, mitering, integral mounted sinks and bowls, and applications subject to dynamic loads. Wilsonart's Seam Adhesive produces improved bond strength over competitor products. Fabricators benefit from increased color choices and match quality. The cartridge based system is based on color consistency, low waste mixing tips, improved cartridges, and low cost dispensers.

Wilsonart® Hard Surface Adhesive is a two-part methacrylate recommended for bonding Wilsonart® Solid Surface, Wilsonart® Quartz, and other solid surface, engineered stone and natural stone products. Wilsonart Hard Surface Adhesive has an average set time (open time) of 8 to 12 minutes and achieves up to 90% of its ultimate strength in approximately 18 to 22 minutes at ideal room temperature (77°F or 25°C).

Storage

Refrigeration storage is recommended and will extend the shelf-life. DO NOT FREEZE. Store in tightly closed containers in a cool, dry, well ventilated place between 40°F - 60°F (4.4°C - 15.4°C) preferably at 50°F (9.9°C).

Shelf Life

The shelf life for a properly stored unused cartridge of Wilsonart® Hard Surface Adhesive is 18 months from date of manufacture based upon continuous storage at room temperature (77°F or 25°C).

Preparation:

- When using a NEW cartridge, place the cartridge in the gun and pull the trigger back 1 or 2 strokes to insure both A and B parts are flowing. If both parts are flowing place the static mixer on the cartridge. (FIG. 6A & 6B)
- Dispense a bead of adhesive approximately 1 to 2 inches and discard before applying to the material. (FIG. 6C)
- Always clean the material to be seamed with a clean white cloth dampened with denatured alcohol or other approved cleaner. DO NOT USE lacquer thinner, acetone, or other solvents. NOTE: Acetone is approved cleaner to be used in regions where denatured alcohol is prohibited. NOTE: Colored cloth or paper towels of any type can leave residue which contaminates the seam material.



Figure 6A



Figure 6B

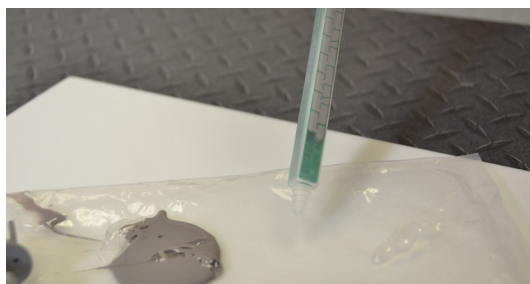


Figure 6C

HARD SEAM ADHESIVES

Static Mixer

It is very important to use the recommended static mixer and attach it firmly to the cartridge. Be sure that the static mixer is free of cured material. If material is semi-cured on the outer wall of the static mixer, it will adversely affect the mixture. Do not cut off any part of the static mixer tip, this may result in an inconsistent mixture.

Cartridge

If using a USED cartridge or partially dispensed and then stored, make sure the material flows freely from both sides of the cartridge (the dispensing holes must be clear) prior to use. Wipe clean with a rag, and then put on a new static mixer.

Coverage

Typically, you should be able to seam 50 to 60 lineal feet per 250ml cartridge. Your actual transfer efficiency may vary according to bead size. Optimum performance of the dispensing system can be achieved by following these dispensing techniques: Squeeze the trigger in long strokes; do not "pump". Let the trigger travel the full range of motion before releasing and starting the next stroke.

Availability

Wilsonart® Hard Surface Adhesive is available in 250ml cartridges, and may be available from your Wilsonart Distributor in less than case quantities. Always check with your Wilsonart Distributor for availability.

Dispensing/Packaging

Wilsonart's Seam Adhesive is packaged in dual component cartridges as part of a meter/mix/dispense system utilising specialised dispensing guns and static mixing tips. Wilsonart's Seam Adhesive is available in 10:1 ratio cartridges which fit most industry standard dispensers.

For additional information refer to Wilsonart® Solid Surface Fabrication Manual for removal and finishing of hard seam components or countertops.

