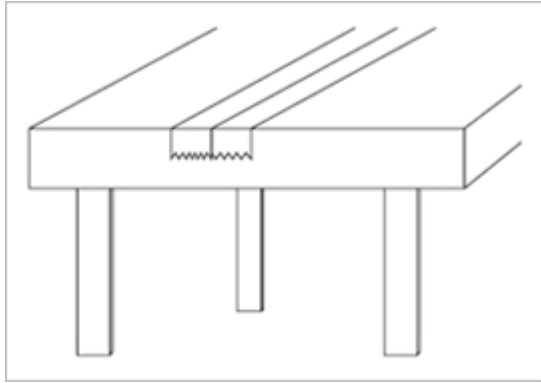


Seaming guide of solid surface

After cutting the pieces to be seamed and subsequent preparation of the cutting edges, you are recommended to apply the following procedures and methods.



1. Place some sort of release paper under the seam. Without a release paper under the seam, the seam adhesive will glue the top to the table.

2. Release paper can be anything from wax paper to Scotch Tape.

3. 2”(5cm) wide Scotch Tape seems to be enough, however, it is advisable to place another layer side by side to just in case the top moves.

4. Wipe the 2 seam pieces down with denatured alcohol.

5. Remember to wipe in one direction. This way, you will not contaminate the area you just wiped.

6. Remember, once you wipe the material down, do not touch the pieces. The seam adhesive could pick up the oils from your skin and discolor the seam. This happens most commonly on the light color materials.

7. Decide what kind of clamping method you will use to clamp the two pieces to be seamed. There are several ways to clamp the pieces together.



[9.6 - B]



[9.6 - C]



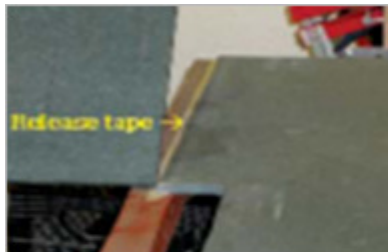
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- A. Wood block and clamps (useful to adjust seam width)
- B. Paralign or similar clamping system
- C. Suction cups and clamps

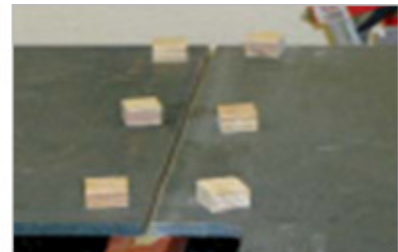
8. Once you decide on a clamping method, the seam adhesive can be applied.
9. Pull the 2 seam pieces apart about 1/8 inch(3mm).



[9.6 - E]



[9.6 - F]



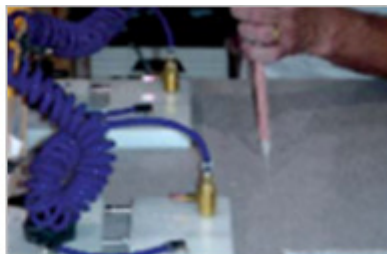
[9.6 - G]

10. Before placing the mixing tip on the adhesive cartridge, make sure to purge [squeeze] a small amount of seam adhesive out, to ensure both Adhesive and Activator are dispensing properly. Place the mixing tip and tighten with [locking nut] and once again purge [squeeze] the trigger twice to make sure you have good mixing at the tip.

11. After the seam adhesive is ready, start at one end and fill the 1/8 inch(3mm)gap. It should be about 1/2 full. Do not leave any air holes or lapses in the adhesive. If there are any air holes or lapses, go over the entire seam again with second bead.



[9.6 - H]



[9.6 - I]

12. Once the seam adhesive is placed in the seam, the 2 pieces can be pulled together with whatever method of clamping you have chosen 4mil(100 μ m) joint width.

13. Let the seam adhesive dry until it is as hard as the sheets themselves. This usually takes approximately 30-40 minutes, depending on the air temperature and sheet temperature. The seam will dry faster when it is warmer and take longer when the temperature is cooler.



[9.6 - J]



[9.6 - K]



[9.6 - L]

14. Once the seam adhesive is fully cured, it can be sanded down. Set the Ski router over the cured seam adhesive and route off any excess seam Material. Once the excess seam material is routed off you can finish up by sanding the area. Sand it with 150 grit (4 mil / 100 μm) sandpaper. Do not stay in one area too long while sanding. This will create a valley on the top. Use the same method front to back, side to side, and a clockwise circular motion.



[9.7 - A]



[9.7 - B]

*** TIP ***

1. Spray the seam area with water and look at the seam. It is at this point, you need to decide if the seam is acceptable or needs to be redone. If the seam needs to be redone, it is better to do now, rather than after all the work is done. This will save you time and material in the long run.

2. In the event that a gas or air bubble was trapped in the cartridge, upright storage should allow it to reach the top (outlet) of cartridge to be eliminated during the initial purge. Purge adhesive (1 teaspoon) immediately start to dispense adhesive. Apply smooth even strokes : maintain constant feed and pressure using the full stroke of the trigger. Do not stop and adhesive drivel out of the tip between strokes, quickly re-trigger the dispenser and continue until dispensing is completed.

3. The measurement of seam width :

- You can easily measure it by using "Peak" (wide stand micro, NO. 2054-60, Made in Japan)
- A4 paper / name card are second choice approximately 4mil (100 μm) / 8 mil (200 μm)