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Durasein
Seam Adhesive



Durasein

Fabrication and Installation Seam Adhesive

BULLETIN NO.
Seam Adhesive_0525

TECH INFO
Seam Adhesive

Product Overview & Description

Durasein® Seam Adhesive is a methacrylate-based adhesive that produces strong, durable bonds for Durasein® Solid Surfaces. Specially formulated for professional use, it is intended for seaming countertops, backsplashes, wall panels, integral sinks and bowls in commercial and residential settings. The adhesive is available in a variety of colors matched to Durasein sheets.

Packaging

Durasein® Seam Adhesive is pre-measured in 250 ml cartridge that fits most hand-held and pneumatic dispensing equipment available on the market. Refer to the dispenser manufacturer for guidelines of use. Its 10:1 mix ratio delivers the right proportion and provides a uniform cure and bond strength.

Storage and Handling

Durasein® Seam Adhesive is flammable. Keep away from heat, hot surfaces, sparks, open flames and other ignition sources. No smoking. The recommended storage temperature range for Durasein® Seam Adhesive cartridges is 50-70°F (10°-21°C) and should not exceed 77°F (25°C). For the best results, store cartridges on their sides. For long term storage, keep cartridges cool, dry setting away from direct sunlight. Store in a well-ventilated place. Keep the container tightly closed. Shelf life of unopened cartridges, when properly stored, is 18 months from the date of manufacture. Review the product Safety Data Sheet for hazard and precautionary information. Do not use it if the product has been exposed to high temperatures for an extended period of time. The cartridge should be stored standing upright and purged immediately after removing the nose plug to eliminate any air

that might be trapped in the cartridge. Use within 24 months of date of manufacture.

Static Mixers

Only use the recommended and supplied mixer tips that have been engineered for the supplied cartridge. Use mixer tips that are clean and free of any blockage. If the material has started to gel in between jobs then discard and reuse a new mixer tip.

Dispensing Guns

Use a recommended dispenser that is in good working order and free of broken parts. Dispensers with a higher mechanical advantage can cause problems of off ratio mixing. To minimize off ratio mixing use light constant pressure on the trigger and do not force the adhesives out of the cartridge.

Cold Sheet Goods

Bring the sheet goods to a temperature of 60°F-70°F (16°C-21°C) before fabrication. Adhesives that are dispensed and used on cold sheet goods may not fully cure causing bonds of lower strength.

Cold Adhesives

Adhesives that have been stored in a refrigerator must be brought up to room temperature before use. The product may not mix correctly if it is too thick to pass through a mixer tip or may not achieve enough heat to trigger the chemical reaction. To avoid damage do not heat past 100°F (38°C).



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Fabricator Action

Use the correct trigger action to achieve on ratio mixing. Apply and maintain constant pressure on the trigger, do not stop and let the adhesive run-on in between strokes. Once you come to the end of a stroke, rapidly re-trigger the dispenser and maintain the constant pressure once again until either the job or cartridge is completed. If the dispenser is set down for any amount of time purge the contents of the mixing tip.

Deck Seams

- Seams should fit tightly when dry fitted.
- Place a release material (clear packing tape) under the seam to prevent contamination of deck seam.
- Thoroughly clean areas to be seamed with denatured alcohol using clean white shop rag.
- Position sheets to be seamed 3/16" (5mm) to 1/4" (6 mm) apart.
- Prepare clamping materials (Attach glue blocks if using this technique).
- Prepare seam kits. Purge cartridge before installation of mixer tip, then attach mixer tip and purge the tip to ensure proper mixture of adhesive.
- Fill the seam to 1/2 full.
- Slide the sheets together. Make sure there is adhesive squeeze out along entire seam.
- Clamp the seam together.

- DO NOT OVERTIGHTEN clams. Over tightening will cause starved, weak seams.
- Remove cured adhesive squeeze out with router on "skis," surface leveler, or random orbital sander. Do not scrape, chisel or use a belt sander on a seam.

Edge Assemblies

- Sand the backside of areas to be seamed to remove any backside printing.
- Dry fit edge strips and fasten hot melt blocks.
- Clean surfaces to be seamed thoroughly with denatured alcohol and clean white shop rag.
- Purge cartridge and tip to ensure proper mixture of adhesive.
- Apply adhesive and clamp with spring clamps at 2" (50 mm) – 3" (76 mm) intervals.
- Make sure there is adequate glue squeeze out along the entire seam. Check carefully for voids.
- Do not sandwich other materials (wood, metal, laminate, etc.) between edges. Use these types of inlays in a routed groove.
- When cured, it is ready for routing.



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V-Grooved (Miterfold) Edges

Place sheet material face down on a solid, flat work surface. Clean the seam area.

- Apply a 1/16" (1.6 mm) bead of adhesive in the entire length of the mitre fold seam. Also apply a 1/16" (1.6 mm) bead at one corner to be folded.
- Fold up the mitered edge and clamp into place. Clamps should be within 2" (50 mm) from each corner and located every 12" (305 mm). Place clamps 1/4" (6 mm) above the face of the panel to ensure proper pressure. NOTE: Once the edge is folded into place, do not allow the edge to separate from the deck.
- Fold up the end caps and secure in place with spring clamps or 3 way clamps. Clamps should be placed every 2" (50 mm). Place 3 way clamps 1/4" (6 mm) above the face of the panel.
- Adhesive squeeze out is required along the entire length of seam and at all corners.
- Allow seam adhesive to cure completely before machining.

Sink Fabrication Techniques

Place wooden blocks with hot melt glue to position sink securely during glue up.

- Thoroughly clean areas to be seamed with denatured alcohol using clean white shop rags.
- Apply an ample amount of Durasein® Seam Adhesive to the sink rim.
- Clamp sinks in place
- Check for seam adhesive squeeze out around the entire sink area.
- Remove clamps after seam adhesive hardens.

Thermoforming and Adhesives

All seaming must be completed after the thermoforming process



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