



Instruction Manual

Handling and Application:

Artisan™ Adhesive (Part A) is flammable, containing methacrylate esters. Keep containers closed after use. Avoid eye and skin contact. Wash with soap and water after skin contact. In case of eye contact, flush with water for 15 minutes and get immediate medical attention. Harmful if swallowed. Keep out of the reach of children. Keep away from heat, sparks, and open flames. NOTE: Because of the rapid curing features of this product, large amounts of heat are generated when large masses of material are mixed at one time (bond joints and thicknesses greater than 0.125 inches (3 mm) should be avoided). The heat generated by the exotherm resulting from the mixing of large masses of adhesive can result in the release of entrapped air and volatile components as evidenced by gassing. To prevent this, use only enough material as needed for use within the working time for the product and confine the gap thicknesses to no more than 0.125 inches (3 mm).

Dispensing Adhesive:

Artisan™ Adhesive is generally applied using pre-measured cartridges or A-Paks. Hand held guns (manual or pneumatic) are generally used with the pre-measured cartridges. To assure maximum bond strength, clean surfaces must be mated within the specific open time. Use sufficient material to insure 100% joint fill when parts are mated and clamped. Avoid over tightening of seam. Use spring-activated clamps. All adhesive application, part positioning, and fixturing must occur before the assembly time of the mix has expired. After indicated assembly time, parts must remain undisturbed until the fixture cure is reached. Avoid contact with copper, brass, or copper alloys in all fittings, pumps, etc. Seals and gaskets should be made of Teflon, Teflon coated PVC foam or polyethylene. Avoid the use of Vitron, BUNA-N, Neoprene or other elastomers for seals or gaskets. Cleanup is best performed before the adhesive has cured. If the adhesive is already cured, careful scraping, followed by a solvent wipe may be the most effective method of cleanup. Application of adhesive at temperatures between 60o F (15o C) and 90o F (32o C) will insure proper cure speeds. Temperatures below 65o F (18o C) will (slow cure) dramatically reduce the cure rate; above 90o F (32o C) will speed cure.

The information has been compiled to provide support to ensure proper performance of Artisan Adhesive™ products. Artisan Adhesive and its affiliates believe the information to be accurate and intended for person or persons having knowledge of the technical data. Note, Artisan Adhesive and its affiliates assume no legal liability of any kind. All information, including but not limited to recommendations, pictures, techniques, and or instructions are for reference purpose only and the user should take all necessary measures and precautions in order to confirm and test the adequacy for specific needs and applications.



Storage and Shelf Life:

Store all Artisan™ Adhesives in a cool, dry place if they are not being used for an extended period of time. The adhesives have a shelf of 12 months or more if stored at room temperature (72 degrees Fahrenheit / 22 degrees Celsius) in their original, unopened containers. The expiration date is printed on each cartridge. The adhesives can have longer shelf lives if they are stored in the correct temperature.

Using Artisan Adhesive on Solid Surface:

With many of the Solid Surfaces in the Market, "Inconspicuous Seams" are a must. Having the right cut is a must to achieve seams that are strong and inconspicuous. These are some of the techniques that are used in the industry and are highly recommended

- Mirror cut
- Panel saw
- CNC router

Mirror Cut

One of the most widely used method to cut the materials with exact matches along the seam line is the "Mirror Cut" technique. To accomplish this, cut the two pieces (which will be seamed together) at the same time. You will then have a mirror image of the cut on the opposite side, which will create a perfect match when the two pieces are seamed together.

- Layout the pieces that will be seamed together.
- Separate the pieces 3/8" apart from each other. The pieces have to be exactly 3/8" apart throughout the seam line.
- Clamp the two pieces down to prevent any movement.
- Prepare a router with 1/2" bit.
- Place the straight edge onto the left hand piece that will be cut. The straight edges have to be perfectly parallel to the gap.
- Check that the distance of the straight edge is set so the router bit cuts about 1/16" from both pieces.
- Clamp the straight edge so it does not move.
- Set the depth of the router to cut through the material.
- Run the router in one continuous motion from left to right.

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Panel Saws and CNC Routers

- With special cutting equipment, use the specific blades and bits with it. If the correct blades and bits are not used, the material will have rough edges and chatter marks which will be visible in the seam and may cause other problems.

Seam Preparation

- After correctly cutting and matching the joints, make sure the fabrication table is set up correctly. The table top should be flat and leveled. Put the release tape along the seam line. The release tape will prevent the Surfacing Material from adhering to the fabrication table.
- Scuff the bottom portion of the seaming edge for better bonding. Use a 80 grit or coarser sandpaper to scuff. Make sure you do not round off the top edges. Leave 1/16" on the top of the edge.
- Clean all pieces with denatured alcohol.

Application

- Do not change or alter connection to fix irregular fits.
- During Dry Fit, make sure the seams are aligned and placed correctly without the use of adhesives.
- Lay out all pieces and separate them in order to apply the adhesive by using the Seaming Kit.
- Make a 1/8" gap to apply the Seaming Kit.
- Clean the area of application with denatured alcohol.
- Preparing the Seaming Kit:
 - o Put the cartridge in the applicator.
 - o Open the cap and attach the mixing tip.
 - o Use the applicator trigger and squeeze out some of the adhesive to improve the flow.
- Apply the adhesive in the gap.
- Make sure there are no gaps and grooves.
- As the adhesive is applied, pull the seam together for the best outcome.
- Once the seam is pulled together, you may see excess adhesive on the surface.
- The seam should be leveled and have a clean surface
- Sand the surface after the glue is dry.
- Preparation and correctly applying Artisan Adhesive is an important part in having successful seams. In addition, it is equally important to pull and tighten the seam together to complete the process.