



## **Instructions for Bonding Metal Fasteners To Natural Stone/Quartz Surfaces/Solid Surface**

**Composite Bonder RTP-01**, properly applied, provides impact resistant bonds **350lbs (+/-) per fastener!!** on Natural Stone, Quartz and Solid Surfaces

The following instructions will ensure that you achieve the highest possible bond strength and performance when using Composite Bonder to fasten bolts for under mount applications.

### **Natural Stone-Area Preparation**

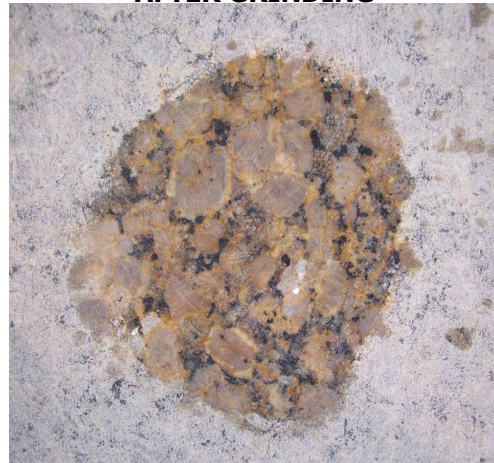
**It is critical that the bonding area be free of moisture and any slurry or other contamination. For Natural Stone applications, a diamond cup wheel should be used to grind the bond area. It is not enough to simply wipe away dust with alcohol or acetone. To remove moisture, a weed burner, torch or heat gun may be used on porous stones. A final wipe with acetone or denatured alcohol will ensure a clean surface and the best performance.**

**BEFORE GRINDING**



**SLURRY/DUST/CONTAMINANTS  
WILL RESULT IN DRASTICALLY  
REDUCED BOND STRENGTH**

**AFTER GRINDING**



**ADHESIVE BONDS  
DIRECTLY TO STONE  
FAR SUPERIOR STRENGTH**

### **Solid Surface, Quartz and Composites-Area Preparation**

**The bonding area must be free of moisture and any contamination. To increase adhesion, scuff the area with a medium grit paper before cleaning with acetone or denatured alcohol. Always ensure that the area is clean before proceeding.**

**Note: When using Zinc plated fasteners, a light sanding of the plate surface will provide increased bond strength.**

- 1** Once the area has been properly cleaned, determine the location for the fastener and mark with a pencil.
- 2** Place cartridge in dispensing gun and remove cap. Before attaching the tip, purge a small amount of adhesive to ensure both components are present. This should be done with the cartridge outlets elevated to allow any trapped air to escape.
- 3** Attach mixing tip and dispense adhesive using the appropriate dispenser. (Note: The adhesive will form a thick gel when properly mixed.)  
At 70 degrees F ( 20. C ) you will have approximately 10 minutes working time.
- 4** Apply a liberal amount of adhesive to the area to be bonded- completely cover the pencil outlines. (Approximately 5ml per fastener is sufficient.)



- 5** Place the fastener into the adhesive and apply pressure until adhesive is forced through the holes.



- 6 Further increase the bond strength by working the adhesive around the base of the fastener and smoothing out the excess adhesive that has pushed through the holes.



- 7 Cure time varies with temperature. Surface and room temperature must be above 55 degrees F.  
**Allow to cure before applying load. (Approximately 30 min. at 70 degrees F).**

