



SURFACE BONDER ULTRA SPECIAL FABRICATION INSTRUCTIONS PLEASE READ

General info.

Surface Bonder Ultra is an ultra-versatile adhesive manufactured by Integra Adhesives. Designed for indoor and outdoor applications, it can be fabricated to provide a gloss or matte finish. It won't yellow, stain or bleed on white marble, stone and granite, and provides a very strong bond to quartz, stone, ceramic, glass and more.

For best results, the grinding time or time before polishing is **approx. 90 minutes in the Summer months, 120 minutes in the Winter months**. The polishing should be done "wet" with standard diamond pads.

1 - Lamination or Miter on Natural Stone, Quartz, Sintered materials and Marble

Surface Bonder Ultra works very well for Laminating and Miter applications.

It produces a high strength, gloss or matte finish with the following techniques.

1. Use standard techniques to apply adhesive.
2. Wipe excess from surface while wet, or slice off when partially cured (approx. 25 minutes) or trim off excess with saw or router finger bit when trimming the edge flush.
3. After the adhesive cures (**approx. 90 minutes in the Summer months, 120 minutes in the Winter months**), remove residual adhesive from the surface with a segmented diamond wheel (not a carborundum abrasive wheel as they may plug up).
4. Polish to the desired finish using standard flexible segmented diamond pads (WET).
 - a. Using #1-3 pads will produce a matte finish to the adhesive
 - b. Using #1 to 6 pads in sequence will produce a glossy finish to the adhesive

2 - Deck Seam for matte finish

1. Apply a double layer of masking tape to the surface just back from any chips or defects caused by the cutting process. Press tape firmly.
2. Use standard techniques to apply adhesive.
3. Immediately wipe the excess adhesive from the surface. Float the blade lightly to make sure that sufficient adhesive is left on the surface.
4. Immediately remove tape.
5. Let adhesive set until cured (**approx. 90 minutes**).
6. Using the cutting edge of the razor blade, scrape until the adhesive is flush to the surface.
7. Blend the adhesive into the surrounding shapes by wiping with Acetone. Don't over apply acetone as excess can degrade the surface.

3 - Deck Seam for high gloss finish

1. Apply a single layer of masking tape to the surface just back from any chips or defects caused by the cutting process. Press tape firmly.
2. Use standard techniques to apply adhesive.
3. Immediately wipe the excess adhesive from the surface. Float the blade lightly to make sure that sufficient adhesive is left on the surface.
4. Immediately remove tape.
5. Excess adhesive in the seam must be removed between 10 and 20 minutes. Use a sharp blade angled tight against the surface and slowly slice away all surface adhesive. Slice until the adhesive is flush to the surface. At this stage, the adhesive in the seam can be left untouched and will fully cure with a gloss finish.
6. If necessary, any additional adhesive on the surface around the seam can then be removed with a razor blade after cure (approx. 80 and 90 minutes).
7. If the adhesive is too glossy, it can be slightly dulled with acetone or lacquer thinner to match the surface. Apply conservatively as gloss can only be regained by polishing.

4 - Deck seam for textured finish

Surface Bonder Ultra works very well for heavily textured surfaces.

1. Apply a single layer of masking tape to the surface just back from any chips or defects caused by the cutting process. Press tape firmly in to the textured surface.
2. Use standard techniques to apply adhesive.
3. Immediately wipe the excess adhesive from the surface. Float the blade lightly to make sure that sufficient adhesive is left on the surface.
4. Immediately remove tape.
5. Let adhesive set until it's cured enough to be trimmed without smearing (approx. 25 minutes). To test the cure, use a new razor blade (held flush with the surface) to cut away excess adhesive. This should be done gently in multiple passes held 45° to the seam line. (If gummy and tearing, wait longer)
6. Trim the adhesive until it's mostly flush with the surface. Since the surface you are working is textured, there will be areas with high adhesive spots. Leave these for the next step.
7. Using the cutting edge of the razor blade, cut away excess adhesive from the low spots until the adhesive is flush to most of the surface.
8. Blend the adhesive into the surrounding shapes by wiping with Acetone. Don't over apply acetone as excess can degrade the surface.

5 - Special notes on Dekton

Surface Bonder Ultra performs well with Dekton, although special attention needs to be paid in order to create a near invisible deck seam. Follow the instructions in point 4. If desired, the top edge of the seam may be micro chamfered to remove chips and create a definite grout line type joint.

Visit www.integra-adhesives.com for more details on the product.