

1. CONTENTS

Staron® joint adhesive is a two-component acrylic adhesive designed for discreet and seamless bonding to a Staron® solid surface sheet. It is available in either a cartridge or a tube.

1) Cartridge (50ml, 250ml)

The cartridge package contains 1 cartridge and 2 mixer tips. A cartridge dispenser is required for using the cartridge adhesive. Components A and B are separated in the cartridge chambers. The hardening begins when the A and B components are combined through the mixer tip.



< 50ml cartridge >



< 250ml cartridge >



2) Tube Package

The tube package contains 1 aluminum tube (component A) and 1 plastic tube (component B).

Mix by hand after pouring component A into plastic tube containing component B.



→ Component A, Main material in aluminum tube

→ Component B, Initiator in plastic tube

3) Ingredients Information

Chemical name	CAS No.	Wt %
Component A		
Acrylic polymer	9011-14-7	20~40
Methyl Methacrylate	80-62-6	30~60
Alumina Trihydrate	21645-51-2	0~40
Component B		
Benzoyl Peroxide	94-36-0	2~5

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2. HANDLING AND STORAGE

- Store in a cool and dark area (10°C - 21°C).
- Keep away from direct sunlight and heat.
- Store the cartridge adhesive in a horizontal position.
- Storing in a Styrofoam™ box or refrigerator may enhance storage efficacy.
- Use products in same order as stored: First product put into storage, should be first product used.
- Before using, warm up product to room temperature.

NOTICE

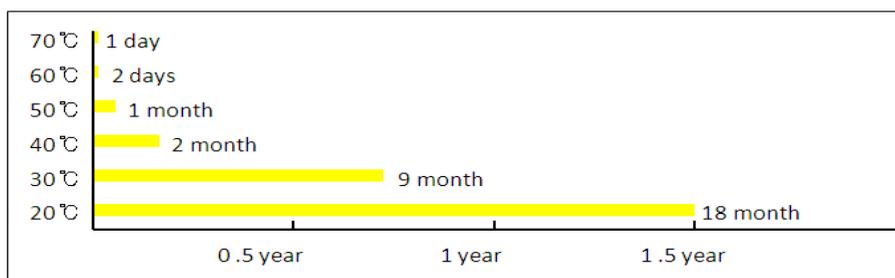
High temperature storage may cause leakage and reduce the expiration time.

SAFETY AND FIRST AID

- Keep out of reach of children.
- Do not use near flame, or flammable materials.
- Use in well ventilated area.
- Avoid contact with eyes, skin, and clothing.
- Ingestion: Wash out mouth with water. Do not induce vomiting. Keep body warm and at rest.
- If breathing stops or shows signs of failing, call 911 and perform CPR. (Do not use mouth-to-mouth)
- Eye Contact: Immediately flush open eye with water for at least 15 minutes. Seek medical attention.
- Skin Contact: Wash skin thoroughly with soap and water. Contaminated clothing should be washed or dry-cleaned before using again.
- Inhalation: Exit exposed area. Keep body warm and at rest. If breathing becomes difficult, administer oxygen. If breathing stops or shows signs of failing, call 911 and perform CPR. (Do not use mouth-to-mouth)

3. SHELF LIFE

- Printed expiration date may be reduced depending on storage conditions.
- Exposure to high temperatures for a long period of time may cause *BPO decomposition, such as delays in hardening time or non-hardening issues.
- Shelf life will be reduced under high temperature storage. (See below)
- * BPO is the ingredient in component B. It is the initiator of hardening chemical reaction.



< Temperature & Expiration date >

(For example: 10°C - 21°C → 18 months, 30°C → 9 months, 40°C → 2 months)

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4. USAGE DESCRIPTION

To achieve the best results, follow the Cartridge system (50ml, 250ml) steps below.

- 1) **Warm the cartridge :** If the cartridge is cold, warm to room temperature before use. Low temperatures will increase its viscosity and may cause dispensing or mixing problems.
- 2) **Vertical position :** Place the cartridge in vertical position for 30 minutes to let the inner vapor to be positioned on the up side of the cartridge.
- 3) **Purge :** After loading to the dispenser, dispense components together without the mixer tip. During purge, hold the cartridge upright.
- 4) **Discharge initial mixture :** After equipping the mixer tip, throw away any extra mixture before applying to project seam. This is a key step to get achieving the proper mixing ratio. If a bubbling occurs, return to vertical position.



Vertical position

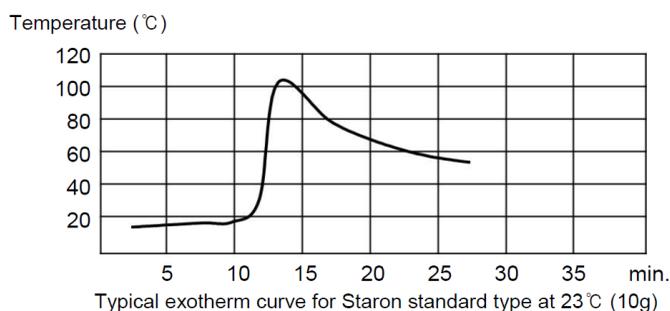


Purge



Discharge initial mixture

- 5) **Applying adhesive:** Apply adhesive to the desired area. Allow 1 hour for curing time. Curing time may vary depending on temperature and humidity exposure. During curing time, temperatures may reach over 100°C. Use caution while handling as the product may remain hot for some time after. Wearing protective gear while handling product is advisable.



- 6) **Re-use and mixer tip replacing:** If the cartridge is unused, replace mixer tip to original cap for storage. If the cartridge dispensing was paused more than 5 minutes, the mixer tip may need to be replaced due to the adhesive hardening in the tip.

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5. TROUBLESHOOTING

1) Curing Delay

- If the working temperature is too cold, curing reaction will delay. Warming up the work space can help to make curing reaction faster.
- Incorrect mixing ratio may cause delay. Follow usage instructions, then try purging again.
- If the storage temperature was over 21 °C, adhesive may not function properly. (See shelf life information)

2) Dispensing Error

- Dispensing may be stiff due to high viscosity or inner pressure.
- If the adhesive was stored in cool temperatures, warm it up to room temperature before use.
- Inner vapor might generate back pressure. If this happens, place cartridge in a vertical position for 30minutes at room temperature and try purging again.

3) Visible Seam Line

- Using the Staron® sheet guide, apply matching adhesive color.
- The adhesive color should create an inconspicuous seam when matched properly to the chip and base color of the sheet. Wide seam lines may visible. Be sure that the width of adhesive seam line does not exceed 0.12mm.
- Check the SHEET PREPARATION.

STARON® SHEET PREPARATION

For the best seam line application and appearance, remove all dust and contamination from seaming edge by wiping with an alcohol pad prior to application. Rough edges can be smoothed by cutting with sharp saw blade. (Mirror cutting recommended)

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