

The following process for seaming 3form Chroma® was developed to mimic the solid surface seaming process. However, all 3form seaming steps must be followed systematically to achieve an aesthetically desirable seam. The following materials necessary for the seaming process are available for purchase from 3form as a complete kit.

## Required Materials

### Included in 3form Seaming Kit

- (×1) Integra Surface Bonder 250ml
- (×1) 250ml Co-axial Applicator Gun
- (×4) Mixing Tips
- (×16) Custom Clamping Blocks
- (×1) Roll 3M™ 355 Tape
- (×5) Quick Grip Clamps
- (×1) Hot Glue Gun
- (×3) Hot Glue Sticks
- (×1) 16oz Invisible Shield Glass Surface Protectant

### NOT Included in 3form Seaming Kit

- Nitrile Gloves*
- Putty Knife*
- Hammer*
- Razor Blade*
- 100, 150 and 220-grit Dry Sandpaper*
- Dry Cotton Rags*
- Small Flashlight*

## Identifying Colored Side of 3form Chroma®

The face side of Chroma will always be masked with a clear protective layer and a sticker. The back side will be masked with a paper protective coat. If the protective films have been removed, identify the colored side by looking into the edge of the panel. View the edge of the panel at an angle so that you are looking through the top face into a light source. Flip the panel over and repeat. The colored side will appear darker than the non-colored side. The non-colored side will appear colored due to the reflection of the light from the colored side. To identify a panel properly, always look at both sides. Colored side should always be situated on the second surface (bottom surface) of a finished Chroma panel (See Figure 1).

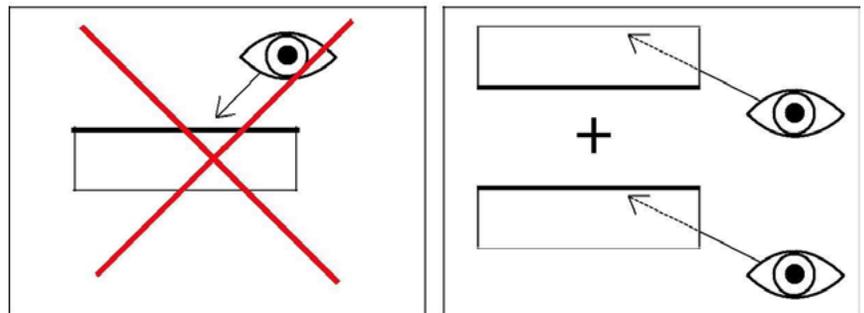


Figure 1

## Seaming Instructions

### 1 Practice

It is always best to practice on a piece of scrap if possible, before trying to seam the product. Store Integra Surface Bonder adhesive in an upright position. This allows air in the cartridge to rise to the tip. Store cartridge between 55–75°F. Shelf Life of Integra Surface Bonder adhesive is 6 months. Always check for the expiration date on the cartridge.

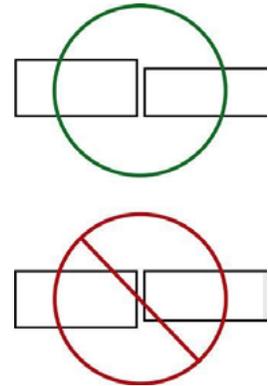
## Seaming Instructions

### 2 Prep

- a** To prep the edges of the Chroma panel for seaming start by sanding away all visible saw or machine markings. Sand using a flat block to assure that the seam is square and flat. Continue sanding using finer grit papers until finishing with 220 grit paper. (The edges may have been prepped if field seam prep was ordered).



- b** Set-up Chroma sheets to ensure that they are level and square at the joint to be seamed together. This can be done on the sub-top of the countertop itself or on leveled sawhorses. Bottom surfaces of the seam should be aligned. Make sure that the colored side of the panel is facing down. If possible excess glue and tape should be removed from the bottom, after adhesive has cured.



- c** Begin by pre-taping the bottom of each Chroma panel using the 2" 3M tape. Place the tape over the edge to be seamed. Make sure to roll or burnish tape using moderate pressure and then trim flush with a razor blade. The tape will keep the excess adhesive from adhering to the bottom of the Chroma panel. Mask the top by holding the tape 1/32" away from the seam. **Do not hang the tape over the seam on the top side.**



## Seaming Instructions

### 2 Prep cont...

- d** Place clamping blocks approximately ½" to 1" (1.3 to 2.5 cm) back from the seam and 6 to 8" (15.2 to 20.2 cm) apart while also aligning across the seam. Cut tape with a razor knife and remove from under each block (see picture). Scuff the area under the block as well as the bottom of the block with 100 grit sandpaper so that the block bonds firmly to the hot glue. Repeat for the opposite side of the joint.



- e** Clamping blocks should be applied using the hot glue gun (included in kit). Apply hot glue to the bottom of the clamping block, apply block to Chroma surface and hold in place for 15 seconds to ensure proper fixture and then place a bead of hot glue to the backside of the block. The resulting blocks should be paired across the joint.



- f** Place Chroma panels approximately 2" (5 cm) apart to prep for adhesive application.

***Make sure surfaces to be seamed are completely free of debris.***

## Seaming Instructions

### 3 Seam

- a** Load the Integra Surface Bonder adhesive cartridge into the dispense gun, always keeping the cartridge in a vertical position. Next “burp” the cartridge: while still pointing the gun upwards squeeze out 1-2 oz of adhesive until no more air bubbles are seen. Clean nozzle tip area with a dry rag. Attach and secure the mixing nozzle to the cartridge with the retaining nut. Run mixed product through the nozzle and “purge” a small amount as waste (approximately a quarter-sized puddle). Then apply a liberal amount of adhesive on both sides of the joint. Spread the adhesive evenly with your finger (Use nitrile gloves). The spreading of the adhesive is critical to ensure air bubbles are minimized in the finished seam.



- d** Slide sheets together until adhesive starts to ooze out slightly. Line up the panels at the edges and bottom surface. Begin to place Quick grip clamps on the clamping blocks beginning at the center and working outwards. Apply the clamps quickly before the glue sets up. Apply just enough pressure on the clamps to evacuate air bubbles. Shine a flashlight into the seam to check if all air bubbles are removed. **Do not over-tighten clamp.** Dry spots may appear with over-tightening. Integra Surface Bonder adhesive has a working time of 3-5 minutes at 75°F. Warmer temperatures will accelerate the cure speed of the adhesive. It is essential that one work in a brisk manner when applying the adhesive and mating/clamping the parts. Once again, check that sheets are flush on the edges and bottom surface. Let glue fully harden.



## Seaming Instructions

### 4 Finish

Remove excess glue and tape with a sharp chisel. Sand seam with an orbital sander in a random pattern starting with 100 grit sandpaper, feathering it out 20" from the seam. After you have flushed up the seam and removed all scratches, graduate to 220 grit sandpaper.

***Be careful to sand the surface evenly to not leave a dish effect.***

Clean with water and a cotton rag. You may be required to sand the entire top to get the finish to match. If necessary, wipe with Invisible Shield until you get the desired effect.

