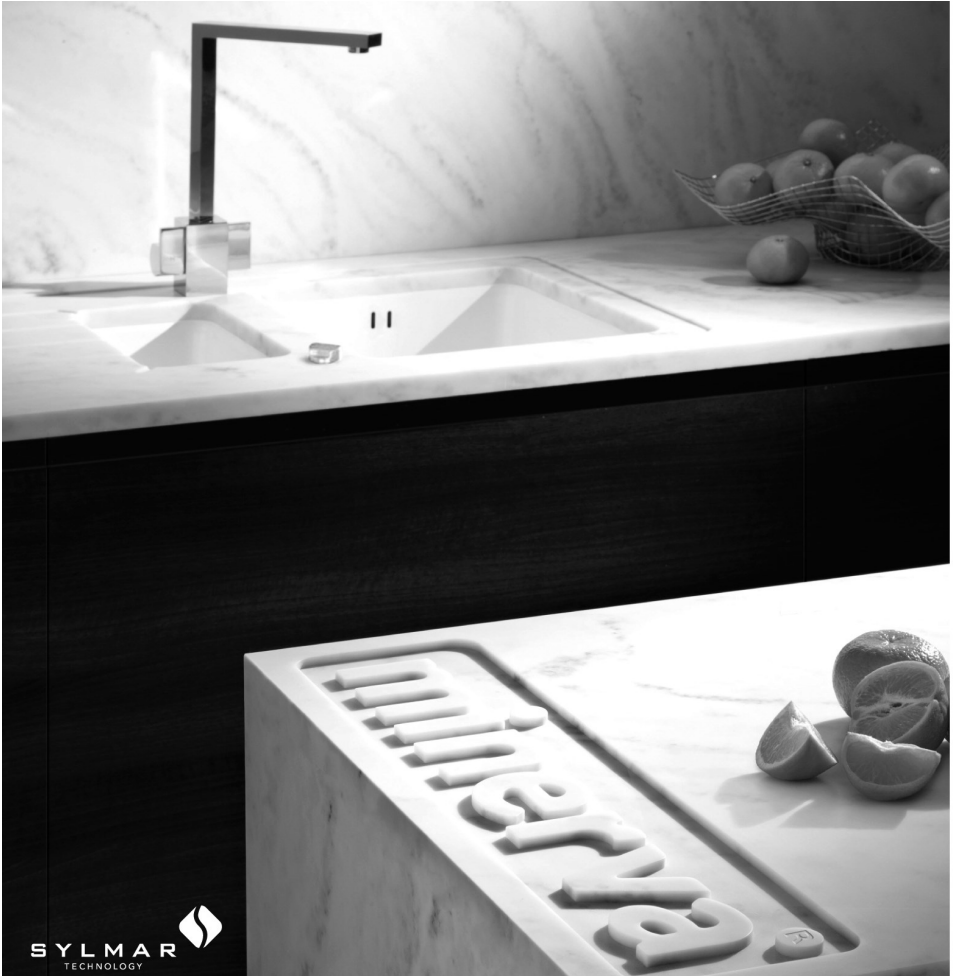


minerva[®]

FITTING PERFECTION

Jointing Instructions



All aspects of the installation of minerva are also covered in a DVD that is available to view on-line at www.minervaworksurfaces.co.uk

Jointing instructions

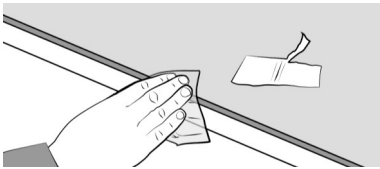
These instructions should be used in conjunction with the full care & maintenance manual which is supplied with your worksurfaces and can also be downloaded at www.minervaworksurfaces.co.uk

Jointing the worksurface

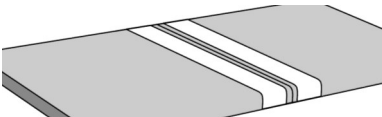
1. Use a router and 12mm cutter with a straight edge to cut the female worksurface to the desired length.
2. To prepare the cut faces for jointing, each side of the joint needs to be square cut. The broken/profiled edge of the surface edge needs to be removed and a small matching radius sanded on the 'dog-leg' of the male side of the joint to ensure seamless effect is achieved.

To ensure the best fit of these faces, one should be cut face up and the other cut face down

3. Using the isopropyl alcohol wipe supplied in the jointing kit, clean the cut edges of the worksurface. Ensure all surfaces are clean, dry and free of debris and dirt including the surrounding areas before proceeding to the next stage

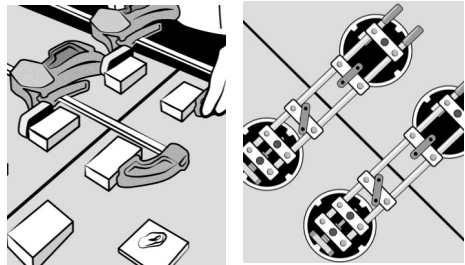


4. Position two layers of masking tape approx. 3mm from the edge of each joint line.



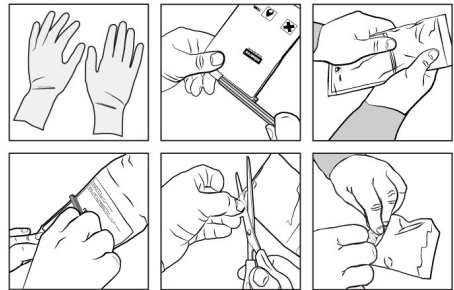
5. It is essential that the joint is dry fitted before bonding, to check it has been machined correctly. The joint surfaces may require block sanding to ensure the cut edge is true. This will ensure that the two machined edges will draw together flush.

6. If not using the Optional Joint pulling tools then using the Hot Melt adhesive bond and position the 6 blocks (3 each side of the joint) just outside the masked area and lined up so a clamp can be positioned at either side to pull the joint together.



7. Ensure that the appropriate adhesive colour cartridge for the worksurface décor is being used.

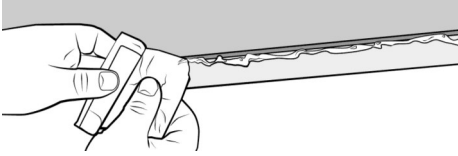
It is recommended that disposable gloves are worn when handling adhesive.



Mix the adhesive as per the instructions with the pack.

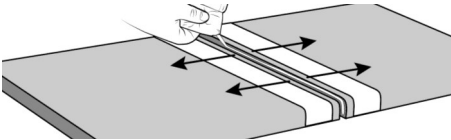
8. Position the first worksurface onto the base units and apply a coating of the 2-part acrylic adhesive onto the cut edge of the first board.

9. Apply adhesive to the cut edge of the second board



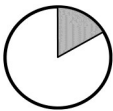
- The hardening can be checked with a fingernail or by checking the adhesive in the sachet.
- Tapping the MDF blocks with a sideways motion will normally remove them quite easily. If not, lever them off or carefully use a sharp chisel to break the bond with the surface.

10. Using either the Seaming Tool or clamps on the glued blocks pull worksurfaces together leaving a gap of approximately 5mm and apply a further bead of adhesive along the gap and into the front edge of the joint.



14. Once cured, the bead of adhesive can be removed by sanding with a random orbital sander with the following order of sandpaper grades: P120 to remove the adhesive bead, P240, P320, P500 grit and then finish with a grey abrasive pad and a light mist of water. All stages must be carried out with the random orbital sander.

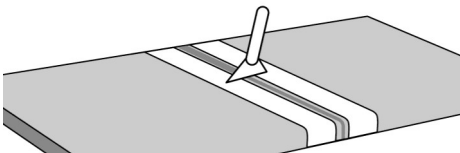
11. Ensure the surfaces are level and tighten together.



NB The working time of the adhesive once mixed is around 8-10 minutes depending on ambient temperature.



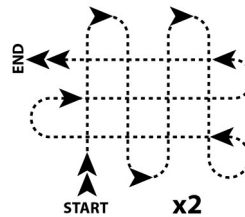
12. Before the adhesive starts to cure, bridge the strips of masking tape lightly with a spatula or scraper and remove excess adhesive.



- Ensure that dust is removed between sanding processes.
- Sand across, up and down then across, up and down in a north—south, east—west style.

13. Ensure masking tape is removed before adhesive cures leaving a small bead line.

- The hardening time of the adhesive depends on the ambient temperature and the amount of adhesive applied.



- When changing the sandpaper grade, increase the sanding area slightly to blend in.



Scan QR code to view our on-line video instruction.

www.minervawarranty.co.uk

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