



On-Site Joining and Repairs

Equipment requirements for on-site joining Kymira

- Dust extraction vacuum unit with 150mm random orbital sander
- Dremel motor tool and Dremel 9931 bit

- * **Warm the containers of Kymira if it is cold. Don't get it too hot or it will harden too quickly.**
- * **Ideally it should be about 24°C.**

Either: When Installing Kymira Tops...

1. Sand both surfaces of the join with 120-grit sand paper.
2. Clean both surfaces with clean dry rag and position tops about 5mm apart. Make sure they are clean of any dirt, dust or finger oils.
3. Apply 2 strips of masking tape on top of each other, along both top edges of the join about 3mm out from the join. Screw fix one of the tops to base cabinets.
4. Protect any cabinets under the join from spills.
5. Cut a small 5mm hole in the end of the plastic piping bag, open the bag and place the cut end, folded over, into a paper cup. Fold the excess bag over the edge of the cup so that it is easy to pour the mix into the bag.
6. Use the pottle of *thickened Kymira* - or thicken the mix using aerosil powder - and mix thoroughly with the catalyst, as supplied. Try not to mix in air bubbles. Mix ratio is 50:1; or 100gms **Kymira** (30mm high in paper cup) to 30 drops of catalyst. (60mm to 1 teaspoon of catalyst)
7. Fill the piping bag with the catalyzed thickened mix. Gently twist the bag closed without forcing out any mixture.
8. Insert the tip of the piping bag as far into the gap as possible and fill without trapping air, ensuring good penetration.
9. Bring the tops tight together, until most of the mix is pushed out of the join.
10. Check the alignment of the tops. **They must be flush across the top and edges.** Screw fix firmly across the length of the join. Use this thickened mix to fill the vertical edge as well.

Or: After Kymira Tops Have Been Installed

1. Position the tops and glue and screw them into place. Get the join as close as possible but it does not have to be a mirror finish, 0-3mm apart is ok. Check the alignment of the tops. **They must be flush across the top and edges.**
2. When the glue is dry, grind out the join with a dremel 9931 bit using a vacuum cleaner to suck up the dust as you go.
3. Make sure dremeled edges are clean of dust or fingerprint oils. If not, re dremel or sand both surfaces thoroughly to remove.
4. Apply two strips of masking tape high, along both top edges of the join about 3mm out from the join.
5. Protect any cabinets under the join from spills.
6. Cut a small 5mm hole in the end of the plastic piping bag, open the bag and place the cut end, folded over, into a paper cup. Fold the excess bag over the edge of the cup so that it is easy to pour the mix into the bag.
1. Use the pottle of *thickened Kymira* - or thicken the mix using aerosil powder - and mix thoroughly with the catalyst, as supplied. Try not to mix in air bubbles. Mix ratio is 50:1; or 100gms **Kymira** (30mm high in paper cup) to 30 drops of catalyst or 1 drop of catalyst to every 1 mm of Kymira in the cup.
7. Fill the piping bag with the catalyzed thickened mix. Gently twist the top of the bag closed and tie, without forcing out any mixture.
8. Insert the tip of the piping bag as far into the gap as possible and overfill without trapping air, ensuring good penetration. Use this thickened mix to fill the vertical edge as well.

Then:

2. Use the curved end of the ice cream stick to remove any excess thickened mix from the join by dragging it a few times up and down the length of the join. This will ensure that the edges are wetted out and will leave a concave groove along the length of the join that is free of air bubbles.
3. Open the pottle of *thin Kymira* and mix thoroughly with the catalyst, as supplied. Try not to mix in air bubbles. Mix ratio is 50:1; or 100gms **Kymira** (30mm high in paper cup) to 30 drops of catalyst. 1 drop of catalyst to every 1 mm of Kymira in the cup.
4. Fill the piping bag with the catalyzed thin mix. Gently twist the bag closed and tie, without forcing out any mixture. Squeeze a bead of mix along the length of the join.
5. Use the plastic piping bag to refill any areas of the join that may need it. Level off with the wooden spatula and then peel off the top strip of masking tape. There should be a continuous 3-5 mm high bead of mix along the whole join. Check that there are no air bubbles in the mix.

Caution: Left over mix will get very hot in the container. Put it in a safe place.

The join needs to be left to cure for *at least* 24 hours before being sanded or it may sink back a little.

When Fully Cured:

1. Remove the masking tape and mark along both sides of the fill with a pencil. This will show you as soon as you are flat.
2. Sand with 80-grit sandpaper on a random orbital sander until just flush (Pencil line has almost disappeared). Keep the sander moving across the width of the join so as not to produce a groove in the top.
3. If there are any air holes, they will need to be dremelled out, cleaned and refilled.
4. Sand over a slightly wider area, using progressively 120-grit, then 320-grit, then 500-grit sandpaper until flush. If you squiggle a pencil line over the previously sanded area, you will be able to see as soon as you have removed all previous sand marks and will not over sand.
5. Finish with a grey Scotchbrite pad on the random orbital sander, going over a wider area of the top in a circular motion. Take time with this.
6. Leave the grey Scotchbrite on the sander and place the sander on a clean cloth, polish the area in a circular motion.

Repairs

To fix any small chips in **Kymira**, you will first need to roughen the edges of the repair area with either a dremel and a 9931 bit or some sandpaper, to aid adhesion. Clean well, make sure there is no dust in the repair, fill with the catalyzed mix (mixed at 50 :1 ... or 1 drop of catalyst to every 1mm of Kymira in the paper cup) making sure you get good wet out around the edges but don't trap any air in the mix. When cured, proceed to step 3 of the "When Fully Cured" process above.

If it is a small repair you may wish to start with P120 or P320 grit sandpaper.

Kymira will continue to develop depth and lustre with further cleaning over time.

Wright Marble Ltd will provide:

- Thin Kymira mix
- Thick Kymira mix (only if a vertical repair is needed)
- Catalyst (MEKP)
- Latex gloves
- Piping bags
- wooden stirring sticks
- Paper cups
- P80, p120, p320, p500 sanding discs
- Grey Scotchbrite pad