

## Applications

Fabrication of Lamniations and seams  
for:

Quartz Surfacing  
Silestone, Casesarstone, Italstone,  
Okite, etc...

Natural Stone  
Granite, Soapstone, etc...

Solid Surfaces  
Corian, Staron, HiMacs, Avonite, etc...

## Advantages

Auto-dispense System  
Eliminates Hand Mixing  
Invisible Seams  
200+ Pre-mixed Colors  
High Strength  
Fast Curing

## Characteristics

Working Time 10/15 Minutes  
Fixture Time 20/30 Minutes  
*Temperature Dependent*

**Surface Bonder Xi** is the latest generation of color matched adhesives for the surfacing industry. Available in more than 200 pre-mixed colors. Higher impact resistance compared to earlier formulations. Developed for modern demanding fabrication methods such as V-grooving, integral mounted sinks and bowls, and applications subject to dynamic loads.

**Surface Bonder Xi** has reduced VOC content, shrinks less during the cure process and produces less odor. The new formula retains the fast cure properties of the original formula, and offers increased shelf life; up to 2 years when stored correctly.

**Surface Bonder Xi** produces improved bond strength over competitor products and earlier formulations. Fabricators benefit from increased color choices as **Xi** is used universally on Acrylic and Polyester Solid Surface materials as well as Granite, Marble, Engineered Stone, and Quartz Surfaces.

Integra's reputation for innovation and product development continues with the first color matched adhesives cartridge system specifically designed for the stone industry. The system includes a special coloration system, low waste mixing tips, improved cartridges, and low cost dispensers.



## **Color Matching**

Integra is known industry wide for it's excellence in matching colors. The lab uses a combination of new color technology and years of experience to produce unrivalled color matches for every surface. **Cross reference charts** are updated regularly on the website to reflect the current offerings of the sheet manufacturers and changing trends in the Natural stone industry. While most surfaces can be matched using the top **20-30 adhesive colors**, Integra customers have access to a pallet of over **200 colors**. Beyond that custom colors can be formulated upon request.

## **Dispensing**

**Surface Bonder Xi** is packaged in dual component cartridges as part of a meter/mix/dispense system utilizing specialized dispensing guns and static mixing tips.

The 250ml cartridge is complemented by Integra's **Model 18-260 Dispensing Gun** and **7.4/18 Spiral Bayonet mixer tips**.

The 50ml cartridge is complemented by Integra's

**Model 50 IA Dispensing Gun** and **5/15 Spiral Bayonet mixer tip**.

*A special 90 degree small orifice tip is available for extra fine detail work.*

## **Packaging**

**Surface Bonder Xi** is available in 250ml and 50 ml cartridges in over 70 stock colors matching Solid Surfaces, Engineered Stone, Granite and Quartz Surfaces. Factory direct purchasing allows for *Mixed colors and products in the case*.

### **Case sizes**

*250ml Cartridge = 20 Cartridges*

*50ml Cartridge = 40 Cartridges*

*250 ml cartridge - Total volume is approximately 260/265 ml*

## **Shipping Options**

Integra's adhesives are stocked at several locations in North America and Europe. A 2 to 3 day lead time can generally be expected for ground delivery within the continental US and Canada.

Flammable adhesives require specialized packaging and documentation for air transport. Please contact Integra for information on overnight air shipping.

## **Order Processing-North America**

Email: [contact@integra-adhesives.com](mailto:contact@integra-adhesives.com)

Orders processed by email, fax or phone.

Integra Main number 1 (604) 850-1321

Toll free 1 (800) 862-6665

Fax 1 (604) 850-1354

Updated information can be found at  
[www.integra-adhesives.com/contact.html](http://www.integra-adhesives.com/contact.html)

## **Order Processing - European Union**

Email: [contact@integra-adhesives.com](mailto:contact@integra-adhesives.com)

Orders processed by email, fax or phone.

Integra International Phone 1 (604) 850-1321

Integra International Fax 1 (604) 850-1354

UK Toll Free Phone 0800.756.9949

UK Toll Free Fax 0800.756.9974

Updated information can be found at  
[www.integra-adhesives.com/contact.html](http://www.integra-adhesives.com/contact.html)

**Distributor Information** - Please contact us for the names and location of distributors in your area.

## Performance Characteristics– Surface Bonder Xi

<b>Appearance - Component A</b>	<b>Clear or colored - viscous liquid</b>
<b>Appearance - Component B</b>	<b>Clear to white - viscous liquid</b>
<b>Viscosity A</b>	<b>35,000 / 150,000CPS</b>
<b>Viscosity B</b>	<b>20,000 / 25,000 CPS</b>
<b>S.G. Combined (Density)</b>	<b>1.11</b>
<b>Working Time</b>	<b>10 / 15 minutes</b>
<b>Fixture Time</b>	<b>20 to 30 minutes</b>
<b>Recommended Bond Line</b>	<b>.002/.040 inch - .05/1.0 mm</b>
<b>Bond Strength (Solid Surface)</b>	<b>4000 / 6000 PSI - 280 / 420 kg/cm Flexural Strength (ASTM D- 790)</b>
<b>Bond Strength (Quartz Surfaces)</b>	<b>3000 / 4000 PSI - 210 / 281 Kg/cm Flexural Strength (ASTM D- 790)</b>
<b>Impact Resistance ISSFA method</b>	<b>Pass</b>
<b>Stain Resistance ISSFA method</b>	<b>Pass</b>
<b>Water Resistance ISSFA method</b>	<b>Pass</b>
<b>Heat Resistance ISSFA method</b>	<b>Pass</b>
<b>UV Stability ISSFA method</b>	<b>Pass</b>
<b>Shelf Life Component A</b>	<b>1 to 2 years</b>
<b>Shelf Life Component B</b>	<b>1 year (Temperature Dependent)</b>
<b>Mix Ratio (Volume) A/B</b>	<b>10/1 optimum</b>

### Storage and handling:

Methacrylate Adhesives and Activators are flammable and can be dangerous if used improperly. Avoid skin and eye contact. In case of eye contact flush with water for 15 minutes and get medical attention. Keep away from sources of ignition. Before use or handling, consult the appropriate Material Safety Data Sheet. Information is supplied at time of initial purchase and may be requested from the manufacturer or downloaded from the web sight at- [www.integra-adhesives.com](http://www.integra-adhesives.com) Store the adhesive in a cool area away from direct sunlight. High temperatures will reduce the shelf life of the adhesive and activator. Exposure of activators, including cartridges, which contain activators, above 100 F. rapidly diminishes the product's reactivity and must be avoided. Refrigeration is an acceptable means to increase storage life, however freezing should be prevented. Shelf life results are based on constant temperature storage between 55 and 75 f - (12/23 c).

### Dispensing:

Integra adhesives are supplied in kit form at the appropriate mix ratio. Always maintain this ratio when mixing. Excess activator will cause higher than normal exothermic temperatures. Avoid mixing large quantities or creating thick cross sections (over 1/4 inch) as high temperatures may cause damage, skin burns and create the release of volatile vapors. To assure maximum bond strength, surfaces must be mated within the specified working time. Use sufficient material to ensure the joint is completely filled when parts are mated and lamped. All adhesive application and part positioning should occur before the working time of the mix has expired. After indicated working time, parts must remain undisturbed until the fixture time is reached. Automated equipment should be constructed of stainless steel. Avoid contact with copper or brass containing alloys in fittings. Seals and gaskets should be made of Teflon, ethylene/propylene or polyethylene. Clean-up is easiest *before* the adhesive has cured. If the adhesive is already cured, careful scraping, followed by a solvent wipe may be the most effective method of clean up.

### Working time:

The working time information is provided as an estimate of the time between mixing and set up of the adhesive. The working time is effected by the mixing ratio, air temperature, adhesive temperature, and the substrate temperature as well as the shelf life condition of the adhesive. For best results, use the adhesive at temperatures between 60 and 85 f. - (15/30 c). High temperatures increase the cure rate while lower temperatures slow the cure. Use at temperatures below 55 f - (12 c). may cause incomplete cure.

### Disclaimer:

The Information provided, is based on laboratory testing under controlled conditions. It is the responsibility of the end user to test the adhesive on the intended substrates under the conditions which they will be used, and to determine the suitability of the adhesive for the intended purpose. Integra Adhesives makes no representations or warranties of any kind with respect to the data on this form or the suitability for any specific application.