

## ADAMASFACET DAMS™ Dopping Adhesive Microflake System

The DAMS™ kit consists of two containers: A oval tube filled with amber colored DAMS™ pavilion microflakes and a small jar containing the same amber colored microflakes with a small amount of a mineral filler. These materials are non-toxic, however, like sugar, these will burn when heated directly in a flame. The microflake adhesive in DAMS™ forms a relatively rigid, tough bond compared to pitch and rosin based formulations. A professional faceter developed this system for fast, secure dopping of stones that are not heat sensitive.

### Preparation instructions:

To the flake mixture in the jar, add ½ teaspoon (2.5 ml.) of denatured alcohol. Do not use any other type of alcohol. Replace and tighten the closure cap and allow the flakes to dissolve for an hour. Write the date of preparation on the top of the jar cap with a permanent marker. Bear in mind that denatured alcohol is toxic and flammable. Keep this liquid mixture away from children.

### Usage instructions:

With a fresh toothpick, stir the amber liquid in the jar. You will notice some tiny particles in suspension. After stirring, employing the toothpick, coat the clean surface of the stone to be dopped and the surface of the dop to mate to the stone, with the amber liquid. Allow the liquid on both surfaces to gel for a couple minutes. If you are dopping to the stone table, simply mate the flat dop to the table, then place the mated piece at a vertical position in the stationary side of a transfer jig. In the sliding side of the jig, place a suitable pavilion dop, then clamp the dops together and fasten. Gently heat the pavilion dop with a butane flame to slowly heat the stone, causing bubbling in the gelled DAMS™. Then, gently heat the flat dop with the flame to gradually drive out the alcohol and water from the DAMS™ adhesive. When your applied heat creates a just few very tiny bubbles in the hot, thickened adhesive, turn off the flame and allow the dop to cool. After it reaches room temperature, you may remove the dop from the transfer jig. It is now ready to mount in the faceting quill.

If you are dopping the stone pavilion, after surface coating on the pavilion dop has gelled, fill the dop recess approximately ½ full with the amber microflake from the oval tube, gently tapping and pouring from the narrow side that acts as a spout. Place the stone pavilion that has a coating of gelled adhesive into the dop, positioning if necessary. Place this assembly vertically in the stationary side of a transfer jig, then clamp it with a flat dop on the sliding side of the jig. Similar to dopping the table, gently heat the flat dop with a butane torch until the gelled adhesive begins to bubble, then heating the pavilion dop. You may need to re-clamp the stone as the microflake adhesive in the pavilion dop melts. Gently heat the pavilion dop until you observe very tiny bubbles in the hot, thickened adhesive. Allow the dop to cool to room temperature and it will be ready for mounting into the faceting quill.

When necessary, you may add a few drops of denatured alcohol to the DAMS™ amber liquid to compensate for evaporation over time. Please dispose of any batch of DAMS™ amber liquid remaining longer than a year after preparation.

After faceting, Adamas recommends that you release the bonded stone from the dop by soaking it in a plastic jar containing denatured alcohol for up to one hour. You may also heat the dop to soften the adhesive and pull the stone off, but you would still have to soak both dop and stone in denatured alcohol for up to an hour to remove the remaining adhesive.