

# SPARKLING SINKS TECHNICAL BULLETIN

## CORIAN® SPARKLING SINK FABRICATION BULLETIN

This bulletin discusses the fabrication of Corian® solid surface Sparkling Sinks **021, 023 and 024**.

### OVERVIEW

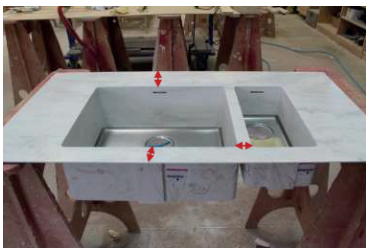
To facilitate the effective installation of high quality DuPont™ Corian® Sparkling Sinks it is very important that the correct installation process is followed to ensure the sinks are attractive and easy to clean. The installation technique discussed is the deep rebate with sub-mount technique using “hard” joint adhesive seams.

### DESIGN CONSIDERATIONS

**Router Grooves - Venaro White and Pearl** are slightly translucent - routed drainer grooves or drip plains are not recommended as the join may be visible when routed. To overcome translucent effect consider applying a slab of the same colour to the underside of the drainage deck.

### CLEARANCE MEASUREMENTS FOR CONSIDERATION

Minimum measurement between two sparkling sinks: otherwise termed “the bridge” can be as low as **37mm**. This reflects the size required for the two 12mm Corian® sink walls in addition to the 12mm square Corian® strap (act as reinforcement strap) between sinks and adhesive.



Clearance to front edge of benchtop: remember to account for the sink wall thickness being 24mm due to the strap on front of sink.

Clearance at rear:

- If Tap hole located in middle of two Sparkling Sink Models minimum clearance to the centre of the tap hole is 45mm.
- Tap hole located directly at rear of single sink minimum clearance is 60mm to allow for rear strap and overflow assembly.

**IMPORTANT:** Ensure that the overflow is placed at the back of the benchtop and pre-fitted prior to taking to site for installation.

## PRE-WORK

### CLAMPING BOXES

You will need to manufacture clamping boxes.



### TOOLS REQUIRED

- Masking tape
- Metal rule
- Large G clamps x 3
- Router – with 12.7mm bottom bearing router cutter
- Sanding blocks – 180 grit
- Sanding discs – 180 grit (for getting into the rebates)
- Pencil
- Methylated Spirits
- Clean White rags, Corian® Reinforcement Straps 12mm x 12mm x variable length (wall length less 40mm)
- Corian® adhesive – matching to Corian®
- Sanding table – 180 grit
- Plywood rails for clamping
- Trimming router – 1-2mm radius cutter with bottom bearing (ideally nylon bottom bearing)
- Clamping boxes – in the required sizes.

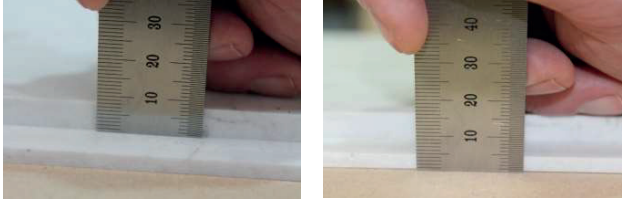
### STARTING THE JOB

Recommended “deep rebate” depth for the sink and for standard edges as shown have been cut using a CNC approximately 3mm has been left on top edge. i.e. the rebate is 9mm deep.



## 1. Deep Rebate

Ensure that depth of router cutter is set so 3mm remains in the seat.



## 2. Rebate “Seat”

Use correct sleeve guide with a straight cutting router bit – cut out the required shape in the Corian® benchtop corresponding with sink measurements. Seat should be a minimum of 14.5mm in width.



**NOTE** – cut-out needs to **have 1.5mm overhanging the inside edge of the sink**. This trim line of excess material (& adhesive) will be removed once the sink has been bonded to the benchtop. Ensure **an additional 12mm** is allowed both front and back for the support straps – approximately 28.5mm – 29mm in total.

## 3. Preparing the Rebate for the Sink

Sand the rebate area with a sanding block and 180grit (240grit for darker colours) to remove any router marks. Remove any pencil or print markings – **to avoid bleeding into join after adhesive added.**



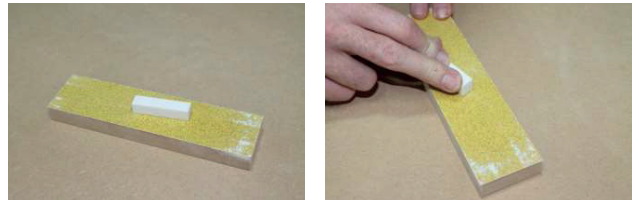
## 4. Pre-Preparation for Install

a) Sand the top edge of the sink using a sanding block to ensure the sink edge is level to allow uniform contact within rebate.

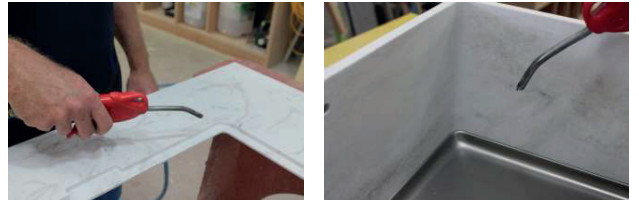
b) Ensure top of sink is completely free of contamination or router/machine marks using appropriate grit sandpaper and cleaner. Also ensure area where the blocking will be “attached” is free of contamination.



c) Sand all of the “blocks” on all sides.



d) Blow down all the edges of the rebate and the sink to remove any excess dust. Remove any excess dust from the area you are working in. **The cleaner the area, the better the chances of a great join.**



## 5. Dry Fit

Check to see that the sink fits the cut-out “seating rebate” correctly.



## 6. Clean using Methylated Spirits

Thoroughly clean the seating rebate, the top edge and the edge of the sink using **Methylated Spirits** and a clean white rag.

## 7. Seating the Sink into the Deep Rebate Cut-Out.

Ensure that the overflow is placed at the rear of the benchtop.



## 8. Adhesive Bead.

- a) Apply a generous bead of adhesive around the inside of the rebate – right around the edge of the cut-out.



- b) Ensure to apply additional adhesive to accommodate the front and rear vertical straps that are part of sinks (the rear contains the integrated overflow).



- c) Then apply a second generous adhesive bead on the outer edge of cut-out (approximately 5mm in from edge).

## 9. Placing the Sink

When sitting the sink into the rebate, adhesive squeeze should be visible on the rear of sink and inside around cut-out.

**IMPORTANT:** avoid dry joins on critical internal join by visually inspecting inside of cut-out and ensuring there is continual adhesive squeeze. If required apply additional adhesive ensuring there are no gaps or air bubbles present. Apply additional adhesive in any rear void also.

## 10. Clamping Box

Use the appropriately sized clamping box.



The bottom of the clamp uses a rail against the top edge of the sinks and the benchtop.



## 11. Corian® Reinforcement Straps:

- a) Thoroughly clean Corian® Reinforcement Straps using the **Methylated Spirits** and white rag.
- b) Apply a generous amount of adhesive to the reinforcement straps press into place ensuring good contact with rear of benchtop and side wall of sink.
- c) Corian® Reinforcement Straps are to be placed on all sides of sink within 30mm of the corners (before radius corners).

**IMPORTANT:** Two Sparkling Sink “Bridge”: A single Corian® Reinforcement Strap is acceptable in the centre of two sinks in order to achieve the minimum “bridge” width of 37mm.



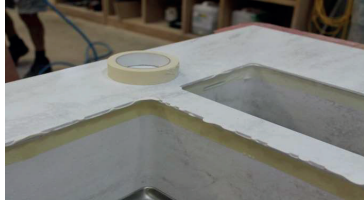
## 12. Trimming

- a) After adhesive has **cured**, remove excess adhesive on benchtop surface by sanding with a block or sander and 180 grit paper. Avoid contact with internal sink. This will ensure that the router travels evenly when trimming the overhang.



## SPARKLING SINKS TECHNICAL BULLETIN

- b) Prior to trimming apply 1 layer of masking tape to the inside perimeter of the sink to protect the sides of the sink from the bearing on the cutter.



- c) Ensure that the appropriate safety equipment is used – **earmuffs and safety glasses.**
- d) Use a 12.7mm bottom bearing router cutter to trim the inside of the sink – ideally using a **nylon bottom bearing.**



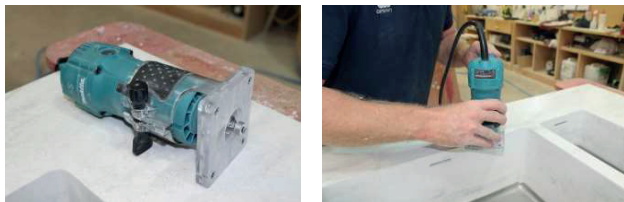
- e) Give the join a light sand using a palm sander.



- f) Then use a 180 grit sanding disc for the corners to remove the remaining edge.

### Edge Radius

Use your trimming router – 1-2mm radius cutter with bottom bearing – to apply the radius.

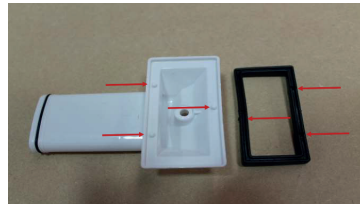


The recommended **radius around the sink is 1-2mm** – this blends the horizontal surface into the vertical and makes the deep rebate join **appear seamless.** Smooth off the radius using a 180 grit sanding disc.

### Overflow and Waste



Ensure that the basket waste is left onsite with the Sparkling sink.



Ensure that the rubber attachment for the overflow is connected properly.



Ensure that the overflow is properly connected before the benchtop is installed. **The overflow must be factory fitted – once the benchtop is installed on-site there is ordinarily nil access for fitting of overflow to rear of sink.**

**Your fabricated SPARKLING sink is now ready to go!**

This information is based on technical data that E.I. du Pont de Nemours and Company and its affiliates ("DuPont") believe to be reliable, and is intended for use by persons having technical skill and at their own discretion and risk. DuPont cannot and does not warrant that this information is absolutely current or accurate, although every effort is made to ensure that it is kept as current and accurate as possible. Because conditions of use are outside DuPont's control, DuPont makes no representations or warranties, express or implied, with respect to the information, or any part thereof, including any warranties of title, non-infringement of copyright or patent rights of others, merchantability, or fitness or suitability for any purpose and assumes no liability or responsibility for the accuracy, completeness, or usefulness of any information. This information should not be relied upon to create specifications, designs, or installation guidelines. The persons responsible for the use and handling of the product are responsible for ensuring the design, fabrication, or installation methods and process present no health or safety hazards. Do not attempt to perform specification, design, fabrication, or installation work without proper training or without the proper personal protection equipment. Nothing herein is to be taken as a license to operate under or a recommendation to infringe any patents. DuPont shall have no liability for the use of or results obtained from such information, whether or not based on DuPont's negligence. DuPont shall not be liable for (i) any damages, including claims relating to the specification, design, fabrication, installation, or combination of this product with any other product(s), and (ii) special, direct, indirect or consequential damages. DuPont reserves the right to make changes to this information and to this disclaimer. DuPont encourages you to review this information and this disclaimer periodically for any updates or changes. Your continued access or use of this information shall be deemed your acceptance of this disclaimer and any changes and the reasonableness of these standards for notice of changes.

© E.I. du Pont de Nemours and Company 2018. All rights reserved.

The DuPont Oval, DuPont™, The miracles of science™, and Corian® are trademarks or registered trademarks of E.I. du Pont de Nemours and Company ("DuPont") or its affiliates. Sparkling Sinks Technical Bulletin February 2018 version.