

FORMICA® SOLID SURFACING



UNDER-MOUNTING SINKS TECHNICAL BRIEF

MOUNTING INSTRUCTIONS FOR THE FOLLOWING KITCHEN SINKS: K080, 2716US, L075, V065, L080, 1812VO

MOUNTING INSTRUCTIONS FOR THE FOLLOWING VANITY BOWLS: L075, V065 & L080

GETTING STARTED

TOOLS REQUIRED

- Safety glasses
- Dust mask
- 11/2 HP (or larger) router with 1/2" collet
- Formica®Solid Surfacing seaming adhesive (9 oz.)
- Formica®Solid Surfacing seaming gun
- Denatured alcohol
- Clean white rags
- 4–6 adjustable, deep-throated 8" –12" bar clamps or 4–6 Vise-Grip® Model 18R or 18DR clamps
- Saw horses or other suitable support
- Hot melt glue gun and adhesive sticks
- Small wood blocks (about 6–8, 1" x 3/4" x 3/4")
- Sanding block with #60 grit sandpaper
- 5" diameter 120, 180 and 220 grit sanding discs
- 5" random, orbital, right angle, electric sander or 5" random orbital air sander
- Miscellaneous tools: Awl, measuring tape, straight edge, pencil, framing square, abrasive pads

COLOR MATCHING

Many installations combine a particular color or pattern for the deck with a contrasting or complementary colored sink. These do not require close attention to color matching between the deck and sink. Installations, however, involving a sheet and sink of the same solid color or the placement of two separate sinks next to each other will require close inspection for acceptable color match before fabrication.

Formica Corporation does not guarantee an exact color match between individual sinks or sinks and sheets of the same color.

SEAM PLACEMENT AND SUPPORT REQUIREMENTS

Sink flanges must be at least 3" (7.62cm) away from deck seams, cooktop cutouts and stoves. Do not locate seams within sink cutouts. Provide structural support within 3" (7.62cm) of the sink area. (See Figures 1 & 2)

MULTIPLE SINK INSTALLATIONS

Formica® Solid Surfacing kitchen sinks can be installed in a variety of multiple sink positions and combinations. Sinks can be placed as close as flange-to-flange or at a greater distance apart. When locating the faucet on multiple sink installation be sure it has sufficient reach.

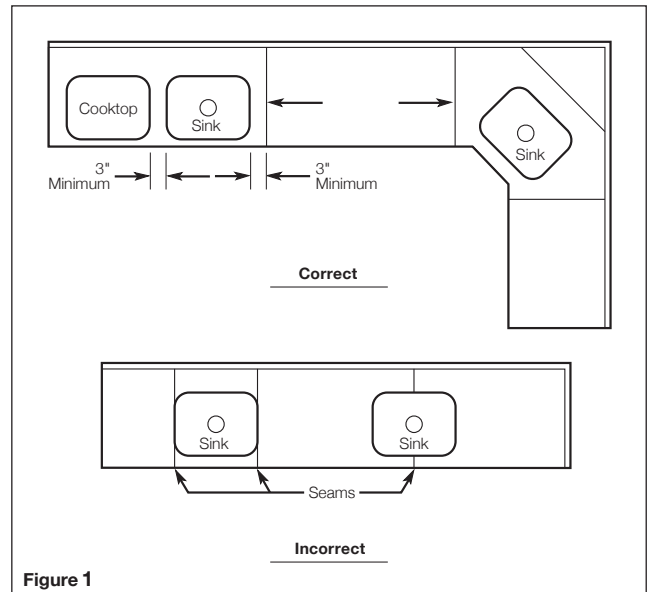


Figure 1

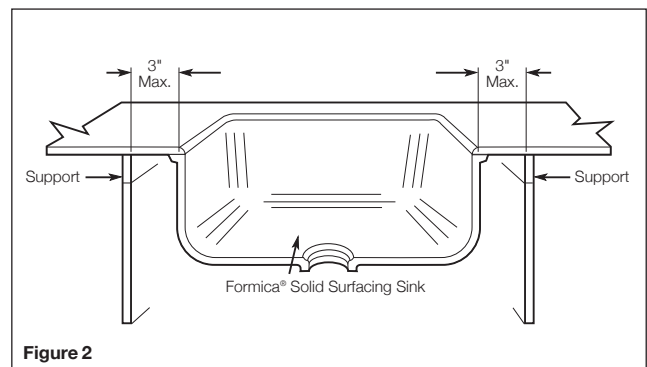


Figure 2

UNDER-MOUNT FABRICATION SHEET AND SINK PREPARATION

- Support top, bottom side up, in a flat position.
- Determine sink location and scratch in center lines using a straight edge with an awl. (See Figure 3)

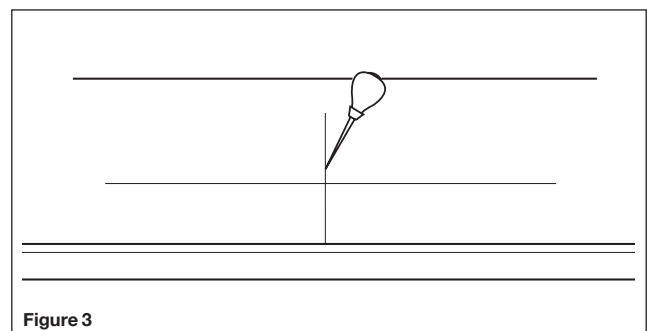


Figure 3

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- Align the molded-in alignment marks on the outside rim of the sink with the scratched-in lines on the sheet. Scratch the outside perimeter of the sink onto the backside of the top. Remove the sink. (See Figure 4)

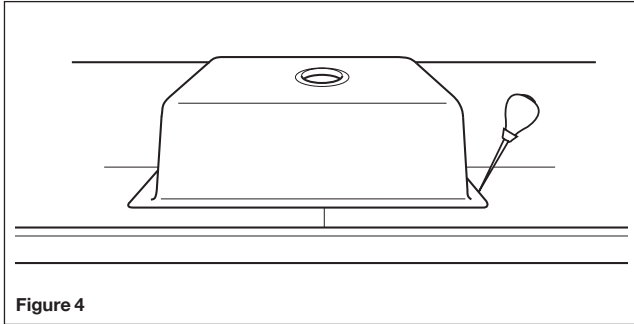


Figure 4

- Aggressively scuff sand the bonding area on the sheet and sink flange with #60 grit sandpaper on a hand block. Note: Do not use a random or random orbital sander. (See Figure 5)

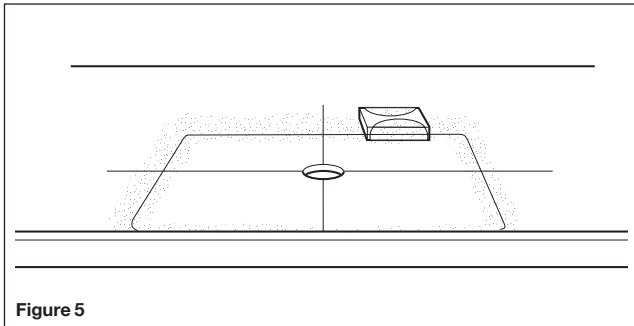


Figure 5

- Plunge route a 2" –3" ventilation/access hole in the sheet within the cutout area. Note: If clamping through the drain, the ventilation hole(s) should be routed directly under the drain opening(s).
- Remove excess dust and clean all bonding areas on the sheet and sink with denatured alcohol.
- Adhere hot melt glue blocks in strategic locations around the outside perimeter of the scratched-in sink profile to keep the sink from moving off-center when bonding. (See Figure 6)

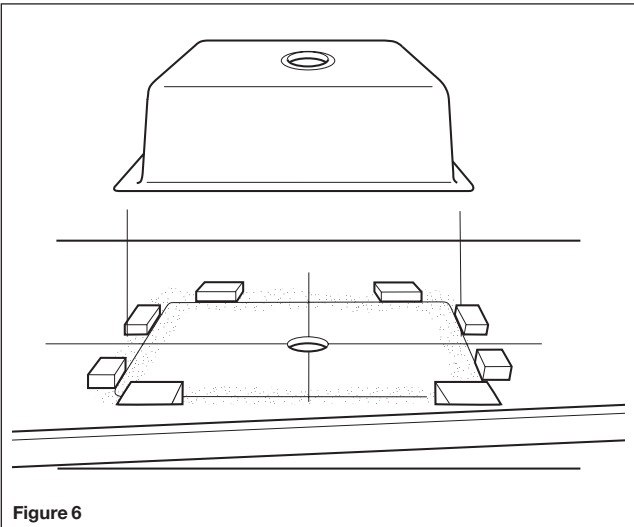


Figure 6

SEAMING ADHESIVE

Choose the adhesive color that is the same as the sink color.

• 9 oz. (266ml) Seaming Cartridge

One 9 oz. seaming cartridge is sufficient for mounting about six single bowls or three double bowl sinks. Choose the adhesive color that is the same as the sink color.

When using 9 oz. Seaming Cartridge

- Mix or dispense according to the directions.
- Apply a ¼", or larger, bead to the sink flange. Do not spread.
- Invert the sink and lower into place between the hot melt glue blocks used for positioning.

CLAMPING

Formica® Solid Surfacing kitchen sinks can be clamped to the sheet using various techniques to hold the sink in position while the adhesive cures. If an access hole is positioned directly under the drain opening, a pipe or bar clamp can be used to apply pressure. Additional clamps should also be placed at each corner and in any other area requiring additional pressure to assure a tight joint and good adhesive squeeze-out.

For this, deep-throated adjustable clamps with or without stand-off blocks can be used. (See Figure 7)

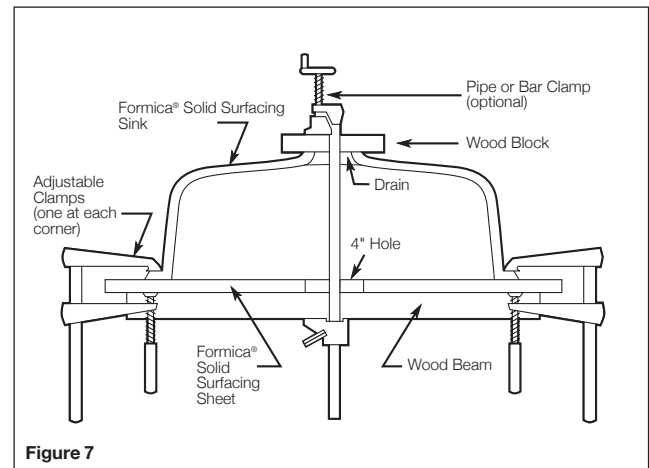


Figure 7

Another clamping alternative is to use deep-throated Vise Grip® welder's clamps with stationary faces. Welder's clamps can be easier and quicker to use than other types of clamps. These should be attached to the four corners for smaller sink sizes, and also at the front and back mid-sections for mounting the double sink or larger single sink models.

After clamping, check for proper alignment and adhesive squeeze-out before the adhesive gels.

Allow the adhesive to cure before removing the clamps.

With the 9 oz. Formica® Solid Surfacing seaming adhesive, this will take approximately 45 minutes.

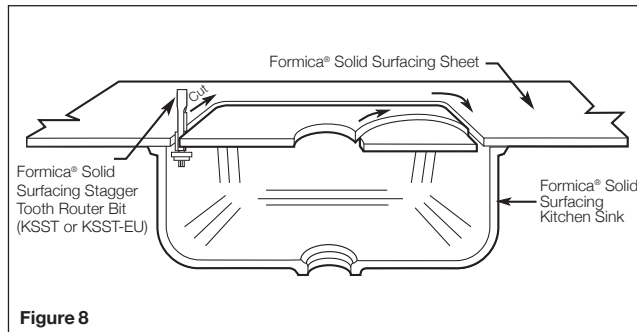
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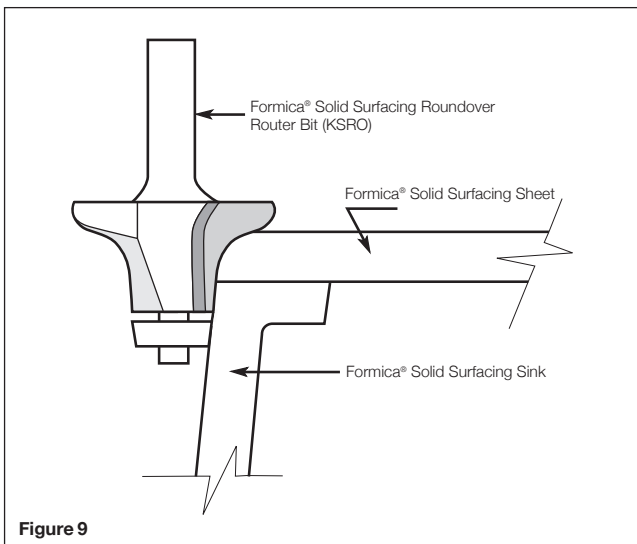
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ROUTING AND SHAPING THE EDGE

- Remove the clamps and rotate the top to position it right side up on suitable supports. Avoid flexing the top.
- Remove the sheet material from the center of the sink area with the router bit. To avoid edge damage, cut clockwise and hold the cutout section steady. A variable speed router, set to the highest RPM setting, is recommended for this procedure.
(See Figure 8)



- Profile the sink edge with a round over bit. Run at 22,000 RPM.
(See Figure 9)



- Sand the profiled sink edge with 100, 120, 180 and 220 grit sandpaper. Then use abrasive pads, etc., for final finishing. Refer to *Formica® Solid Surfacing Fabrication Guide*

PLUMBING

Attach plumbing fixtures according to manufacturer's directions. Cut holes with a router or a hole saw and drill. Check faucet reach before drilling or routing holes.

See back for specific product information charts.

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