

- **Under Counter Vanity Sink**
- **Under Counter Double Bowl Sink**
- **Under Counter Sink with Laminate Countertop**
- **European Solid Surface Countertop Seam**
- **Stacked Edge Buildup**
- **Drop Edge Buildup**
- **Solid Surface Removal (disassembly)**
- **Solid Surface Repairs**



**Read and Understand  
Before Installing**

# Safety Guidelines

## IMPORTANT NOTICE

**IMPORTANT NOTICE:** Indicates that equipment or property damage can result if instructions are not followed.



### Read and Understand the Manual

It is the responsibility of any individual who installs or maintains this product to fully understand and follow proper installation and maintenance procedures. Be aware of the inherent dangers in the use of power tools when installing this product. Read and understand all Warnings, Cautions, and Important Notices in this manual.



### Work Safely

DO NOT proceed if any doubt arises about the correct or safe method of performing anything found in this or other Swan manuals. The installation of this product can require using power tools. Do not use power tools without adequate training. If necessary, hire or consult a trained professional for expert assistance before continuing.



### Use Proper Tools

Always use proper tools which are in good, working condition during the installation of Swan products. Using tools other than those listed could adversely affect the integrity of floors, pipes, walls, or this product and could result in water damage or other damage to floors, pipes, walls, or other portions of your building or home.



### Use Proper Adhesives and Hardware

Only use the recommended Swanstone Surfacing Adhesive to bond this product. Only use approved screws and hardware when bonding Swanstone components. Never use nails or unapproved screws that could adversely affect the integrity of this product.

## CAUTION

**CAUTION:** Indicates a potentially hazardous situation which, if not avoided, may result in injury. It may also be used to alert against unsafe practices.



### Use Proper Fabrication Methods

Follow all instructions related to Swanstone fabrication. Failure to follow such instructions could cause the components to separate after installation, resulting in personal injury. Failure to follow these instructions could also result in water damage.



### Slipping Hazard

Do not install this product in the presence of water. Installing this product without drying all surfaces, or in the presence of water, could cause you to slip and fall due to wet floors or spilled fluids. Personal injury can result from slips or falls. Before installation, dry all surfaces, including the floor, with a cloth or paper towel. Clean up all water or spilled fluids immediately.



### Tripping Hazard

Personal injury can result from tripping over power cords, tools, or other items. DO NOT leave items laying around the work area.



### Personal Protection

Be sure to use all personal protective equipment, such as dust mask, safety eyewear or goggles, and sturdy work boots, preferably with steel toes, if necessary, to ensure your own safety. To prevent possible damage to your hearing, always wear ear protection, such as earmuffs or earplugs, when working around power tools.



### Cutting Hazard

The installation of Swan fabrication product will require using power tools. Keep hands away from the cutting edge of any tool used in the installation of our product. Placing fingers in or around the cutting blades could result in serious personal injury.



## Room Temperature

Allow Swanstone panels and silicone sealants to adjust to room temperature for at least six hours before installation.

The panels should be installed at temperatures not less than 65°F. Panels should not be installed in areas where the temperature may drop below freezing (32°F). Failure to follow this recommendation could adversely affect the silicone sealants, which holds the panels to the wall. If the panels are not correctly adhered to the walls, they may fall off, causing possible injury to someone in or around the shower or bathtub enclosure.

## WARNING

**WARNING:** Indicates a potentially hazardous situation which, if not avoided, could result in serious injury or death.



## Eye Protection

Be sure to use all personal protective equipment to ensure your own safety. To avoid eye injury, always wear protective glasses with side shields when using power tools. Also, make sure no one else can be injured by flying particles when using power tools.



## Fire Hazard

Personal injury or death can result from a fire caused by flammable liquids, vapors, or acrylic adhesives. Cleaners or solvents can be highly explosive, resulting in personal injury or even death, when not used properly. Clean up any flammable substance immediately. Sparks or open flames can cause flammable substances to ignite. **DO NOT** smoke while working on or near any flammable substance.



## Solvents Hazard

Follow all manufacturer's safety instructions for denatured alcohol. Vapors are both flammable and hazardous to breathe. Vapors may irritate eyes and nose. Direct contact with the skin can cause irritation, itching and pain. Personal injury can result from improperly handling or use of solvents such as denatured alcohol. Always follow the manufacturer's recommendations for the safe use of these products.



## Fumes Hazard

The fumes from solvents and the acrylic adhesives used by the installer can be harmful if used in an unventilated room. Always work in a well-ventilated area. To keep the area well-ventilated, open windows and use exhaust fans. If adequate ventilation is not achievable or practical, use protective respiratory equipment.

## Dust Hazard



When cutting or drilling Swanstone product, use a dust collection method which prevents dust particles from going into the air. Always work in a well-ventilated area. Always use an OSHA approved dust mask when cutting, drilling, or sanding Swan Surfaces products.

## Power Tool Hazard



To prevent personal injury or possible death, always follow the electrical safety recommendations of the power tool's manufacturer. Do not use power tools in an unsafe manner. Power tools should only be connected to a circuit protected by a ground-fault circuit interrupter (GFI).



## Shock Hazard

Never use electric power tools around water, condensation, or other liquids. Electric shock can cause severe burns, significant injuries, and even death. If an extension cord is required, always use an OSHA approved extension cord. Power cords should only be connected to a circuit protected by a ground-fault circuit interrupter (GFI).



## Electrical Shock Hazard

Contacting live electrical wiring with power tools or hand tools can cause serious injury or death. Make sure all related circuit breakers are turned OFF. Test for live circuits or wiring inside any wall where installation of Swan Surfaces product requires cutting into a wall.



## Electrocution Hazard

Water and other liquids conduct electric current and can create a short circuit, resulting in injury or death. Keep all liquids away from electrical cords and power tools. **DO NOT** create a short circuit between a source of electricity and a liquid by being in contact with both simultaneously.



# General Information

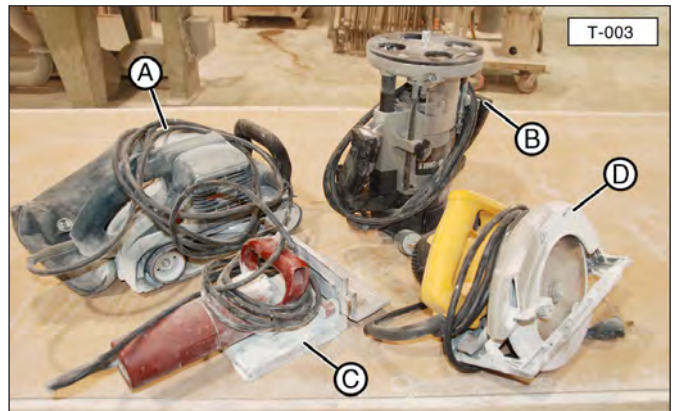
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## General Tools



Saber saw (such as DeWalt DW317K Variable-Speed Orbital Action Saber Saw).



(A) Belt sander (such as Bosch 1276D, 4 inch).  
 (B) 2-1/2 hp Router (such as Porter Cable 7539).  
 (C) Biscuit joiner (such as Lamello Classic C2).  
 (D) Circular saw (such as DeWalt DW364 7-1/4 inch).



Drill or cordless drill (such as DeWalt DCD940KX 18V Variable Speed Reversible Driver Drill).



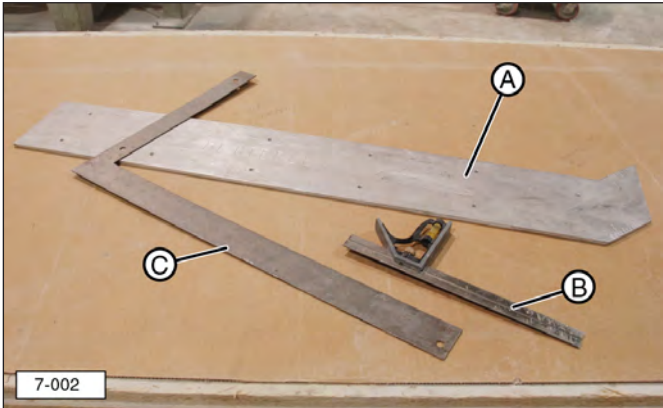
Rotary tool (such as Dremel tool or pneumatic rotary drill).



Deep throat locking plier clamps (such as Vise Grip DR18 Locking Clamp).



Orbital sander (such as Dynabug pneumatic sander).



(B) Adjustable square. (C) Carpenters square. [Tool (A) is listed under Swan Surfaces Tools.]



Spring clamps (such as Pony 3202 Spring Clamps).

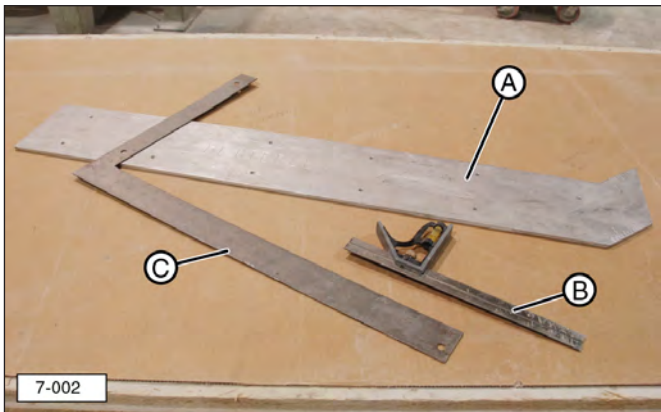
NOT SHOWN

Flexible Putty Knife, Solid Shank (Stiff) Putty Knife, Hammer, Clean Cloths, and Scotchbrite pads.



# General Information

## Swan Surfaces Tools



(A) Swan Part # VW 00140.00, Betterly 30 inch aluminum template. [Tools (B) and (C) are listed under General Tools.]



Swan Part # VW 0080.000,  
MixPac Type DP200-70 Pneumatic Glue Dispenser.



Swan Part # VW 0090.000,  
MixPac Type DM200-10 Manual Glue Dispenser.



Swan Part # VW 0050.000  
Special countersink drill bit.



Swan Part # VW 10030.001  
Tungsten router cutting bit.



Swan Part # VW 00010.000  
Bevel bit (12 degrees).



Swan Part # VW 00020.000  
Round-over bit (1/2 inch radius).

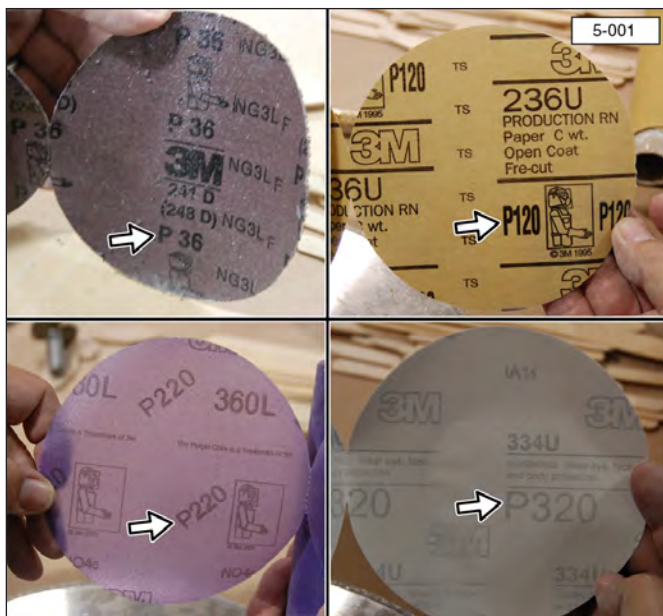


Stone-tip cutters for rotary tool.

**Supplies and Hardware**



Diamond tipped circular saw blades.  
Tungsten carbide grit jigsaw blades (not shown).



36 grit, 60 grit, 120 grit, 220 grit, and 320 grit sandpaper, pads to fit orbital sander. (Scotchbrite pads may be used instead of 320 grit sandpaper, if desired.)



Tungsten carbide grit hole saw  
(1-1/2 to 2 inch diameter).



Denatured alcohol. Clean cloths (not shown).



## General Information



Adhesive spreading sticks.



Size 20 wooden biscuits [such as Lamello # 20 56 x 23 x 4 mm (2-13/64 x 57/64 x 5/32 inch)].

## Optional Tools



Electric sander with vacuum dust extractor (such as Festool CleanTec CT22E and RO 125 FEQ Rotex Sander).

## Fabrication Tips

- Read these instructions carefully and familiarize yourself with the various parts of the products.
- The variety of installations possible for these products may require procedures other than those shown. Ensure construction is correctly sized, plumb, and square.
- Allow sufficient time for the parts in this kit to adjust to room temperature. We do not recommend installation of this product at temperatures below 65 degrees.
- Do as much of the fabrication as possible in a well equipped shop, away from the installation site. This controlled environment will result in a better fabrication and will minimize the amount of dust buildup and possible damage at the installation site.
- Store unused materials away from the work area to prevent accidental damage.
- Always use a soft lead pencil to mark measurements and outlines on Swanstone. Pencil lead is easily removed with denatured alcohol. **Do not use ink or markers on Swanstone products.**
- Always clean off any marks before gluing visible seams to avoid contaminating the seam line.
- Always wipe down Swanstone products with denatured alcohol before gluing components together, and between sanding with different sandpaper grits.
- Record (write down) glue up time to monitor the time until the acrylic adhesive is fully cured. The time can be written directly on the components being joined, using a soft lead pencil.

## Gluing Tips

- Follow the instructions on the Swanstone Adhesive (acrylic adhesive) tube.
- Wear protective disposable gloves when working with the two part acrylic adhesive.
- Remove excess acrylic adhesive with a flat blade putty knife. Clean up acrylic adhesive with denatured alcohol and a clean cloth.
- Be very careful not to disturb acrylic adhesive joints during the 1 hour cure time.



**Safety Equipment**

- When working with Swanstone solid surface material, always wear safety glasses, safety goggles, or an approved face shield.
- When cutting or sanding Swanstone solid surface material, wear an approved dust mask.
- When gluing Swanstone solid surface material, wear disposable gloves and provide for adequate ventilation or use protective respiratory equipment.
- When working with power tools wear approved ear plugs.



- For more information on proper safety equipment, refer to the Safety Guidelines section at the front of this manual.

**Disclaimer**

- The information contained in this manual is given free of charge. It is based upon technical data which we believe to be reliable and is intended for use, by persons having knowledge of this technical area, at their own discretion and risk. Swan Surfaces assumes no responsibility for results obtained or damage incurred from the use of this material either in whole or in part by the buyer.
- This manual will give you basic instructions for the installation of the product in a step-by-step sequence that will work in most types of installations. If you have an installation application that is not covered in this manual, please call your local Swan distributor or contact Swan directly for additional information about your application.
- Follow all installation instructions. Failure to follow these instructions could result in personal injuries or damage to tools, cabinets, vanities, floors, or other portions of the building or home.

**Vanity Sink and Countertop**

**IMPORTANT NOTICE**

Before beginning, refer to General Information section for important information on tools, hardware, and special equipment required for Swanstone fabrication.

Swanstone sink fabrication allows under mounting a vanity sink, bar sink, or kitchen sink directly to Swanstone solid surface countertops using Swanstone acrylic adhesive. The sink can be the same or a contrasting color. The rim of the under mounted sink is machined to give a seamless appearance, as if it was molded as one piece with the vanity or bar top.

**IMPORTANT NOTICE**

Swanstone Solid Surface Countertops without a molded-in backsplash are factory sanded and will not exactly match the interior surface pattern of an un-sanded Swanstone sink. To achieve an exact appearance match, pre-sand the entire surface of the sink interior with 120 grit sandpaper before installation.

**Layout**

1. To prevent damaging the top surface of the Swanstone countertop, cover the work table with a clean drop cloth, thin foam pad, or corrugated cardboard.
2. Place the Swanstone countertop upside down on the protective cloth or pad.
3. Measure the length of the countertop and use a pencil to mark the center point.



## Fabrication

- Use the carpenter's square and pencil to extend this centerline.



- For standard vanity countertops, measure 10-1/4 inches from the front edge of the countertop and use a pencil to mark the center point for the sink location at in three points.



**Note:** For information on positioning kitchen (double bowl) sinks, refer to the Double Bowl Sink and Countertop section in this manual.

- Use the carpenter's square and pencil to extend this centerline.



- Locate the sink position on the countertop.

**Note:** Make sure to position the sink with the overflow drain toward the front edge of the countertop, as shown.

- Align the four arrows molded into the underside of the sink rim with the pencil lines on the countertop.

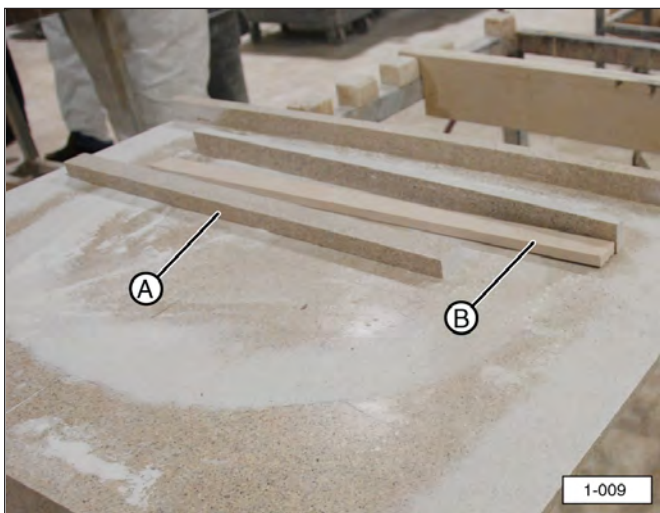




- b. Draw a pencil line all the way around the perimeter of the sink rim.



- 8. If desired, cut end caps from matching Swanstone material. End caps can be made from single thickness material (A) or glued-up material (B) with the surface that matches the countertop facing out.



**Sanding**

- 1. Thoroughly sand the underside of the countertop, inside the sink outline, with 36 grit sanding pads. Sand an area 3 inches wide, up to the pencil line. Remove all gloss and rough up the surface to allow for proper adhesion. Do not sand away the pencil mark of the sink outline.



- 2. If installing end caps, thoroughly sand both side edges on the underside of the countertop with 36 grit sanding pads. Sand an area 2 inches wide. Be sure to also sand the back side of the front edge of the countertop. Remove all gloss and rough up the surface to allow for proper adhesion of the end caps.



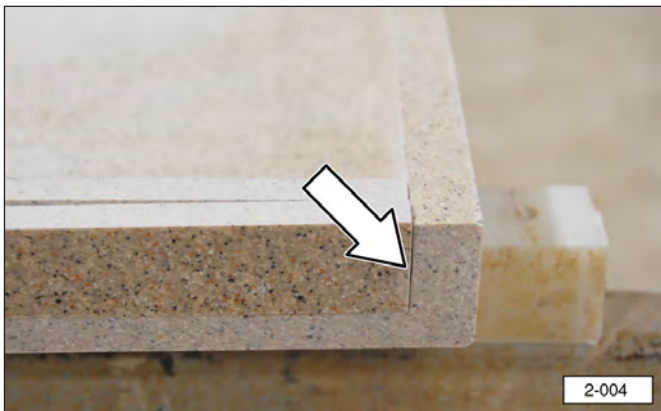


## Fabrication

- Use 36 grit sanding pads to thoroughly sand the edges of the end caps that will be glued together, if they are being stacked. Sand all the edges of the end caps that will contact the underside of the countertop. Remove all gloss and rough up the surface to allow for proper adhesion of the end caps.



**Note:** If installing Swanstone material end caps, make sure to sand the ends of the caps for a precise fit against the back side of the front edge of the countertop, as shown.



- Thoroughly sand the rim of the sink with 36 grit sanding pads. Remove all gloss and rough up the surface to allow for proper adhesion.



- Wipe all the sanded surfaces with denatured alcohol. Remove all dust and let the surfaces dry completely. Do not remove the pencil lines used to locate (position) the sink on the countertop.



**Glue-Up**

**End Caps**

If the countertop will have exposed sides, matching Swanstone end caps should be fabricated and installed. End caps can be made from 1 inch thick material or from thinner pieces glued together to achieve the 1 inch minimum thickness.

**IMPORTANT NOTICE**

Before glue-up, wipe all the sanded surfaces with denatured alcohol. Remove all dust and let the surfaces dry completely.

1. Select the correct matching color Swanstone Adhesive cartridge(s). Follow manufacturers instructions to install a mixing nozzle and install the cartridge in a dispensing gun.



**IMPORTANT NOTICE**

Before applying adhesive onto a Swanstone component, always dispense some of the adhesive into a waste container. Dispense enough adhesive to allow complete mixing of the two part adhesive in the corkscrew design nozzle. This way, freshly mixed adhesive with a full 10 minute working time will be dispensed onto the components to be joined.

2. The Swanstone Adhesive has a working time of ten minutes and a cure time of 1 hour. Gather all the tools needed before beginning glue-up.
  - a. If installing end caps, have large quantities (20 or more) of small clamps ready to hold the end caps in position until the adhesive cures.



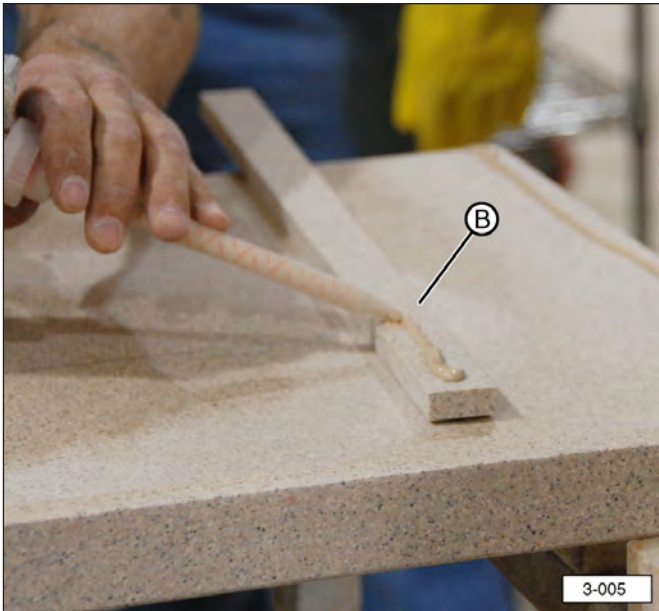
- b. Have several glue spread sticks, a flexible putty knife, denatured alcohol, and clean rags available for spreading the acrylic adhesive and for clean up.
- 3a. Dispense a generous bead of the correct color-match Swanstone Adhesive on the underside of countertop (A).



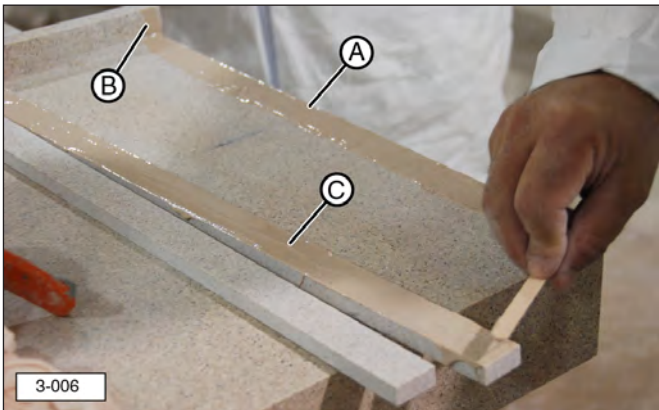


## Fabrication

- 3b. Dispense a generous bead of the correct color-match Swanstone Adhesive on any end cap surface (B) to be glued together.



4. Use a spread stick to smooth out the adhesive. The adhesive should be just thick enough to hide the Swanstone surface underneath. Spread adhesive on the underside of countertop (A), the backside of countertop front edge (B), and the contact surface of glue-up end caps (C).



**Note:** Adhesive that is spread too thick will not allow proper fit, and finish of the joint. Adhesive that is spread too thin can result in gaps in the joint and a weak bond.

5. Position the first clamp at the front edge of the countertop (as shown in the insert) to help pull this joint together. Be sure to clamp the stacked end cap pieces together and clamp the end cap to the countertop. Space the clamps very close together, as shown.



**Note:** Allow adhesive to squeeze from all the seams to make sure that each joint is completely filled with the adhesive material. Excess adhesive on the inside edge of the end cap should be removed with a putty knife, denatured alcohol, and a clean cloth.



6. If installing end caps, repeat this process to attach the remaining end cap on the opposite end of the countertop. Record the time the end caps were attached, and allow the adhesive to cure for at least 1 hour.



**Vanity Sink**

The vanity sink can be installed before or after end caps. If the vanity top will have exposed sides, matching Swanstone end caps should be fabricated and installed. End caps can be made from 1 inch thick material or from thinner pieces glued together to achieve the 1 inch thickness.

**IMPORTANT NOTICE**

Before glue-up, wipe all the sanded surfaces with denatured alcohol. Remove all dust and let the surfaces dry completely.

1. Select the correct matching color Swanstone Surfacing Adhesive cartridge(s). Follow manufacturers instructions to install a mixing nozzle and install the cartridge in a dispensing gun.



**IMPORTANT NOTICE**

Before applying adhesive onto a Swanstone component, always dispense some of the adhesive into a waste container. Dispense enough adhesive to allow complete mixing of the two part adhesive in the corkscrew design nozzle. This way, freshly mixed adhesive with a full 10 minute working time will be dispensed onto the components to be joined.

2. The Swanstone Adhesive has a working time of ten minutes and a cure time of 1 hour. Gather all the tools needed before beginning glue-up.
  - a. Have large quantities (10 or more) of long reach locking clamps available to hold the sink in position until the adhesive cures.



- b. Have several glue spread sticks, a flexible putty knife, denatured alcohol, and clean rags available for spreading the acrylic adhesive and for clean up.
  - c. Have a variable speed reversible drill, Swan Part # VW 0050.000 Special countersink drill bit, and Swanstone under mount screws ready for use.
3. Pre-drill the sink alignment screw holes.
  - a. Place the sink on the underside of the countertop. Make sure the overflow drain is toward the front cap (edge) of the countertop.
  - b. Align the reference marks (arrows) with the four lines marked on the underside of the countertop in an earlier section.
  - c. Use the special drill bit to drill two pilot holes into the underside of the countertop, through two of the rim openings, 180 degrees apart.



## Fabrication

- d. Remove the sink and use compressed air and denatured alcohol with a clean cloth to remove all dust and debris from the holes, sink rim and vanity surface.

### IMPORTANT NOTICE

Before applying adhesive onto a Swanstone component, always dispense some of the adhesive into a waste container. Dispense enough adhesive to allow complete mixing of the two part adhesive in the corkscrew design nozzle. This way, freshly mixed adhesive with a full 10 minute working time will be dispensed onto the components to be joined.

4. Dispense several beads of the correct color-match Swanstone Adhesive on the sanded surface of the countertop, using the sink outline as a guide.



5. Use a spread stick to smooth out the adhesive. The adhesive should be just thick enough to hide the Swanstone surface underneath.



**Note:** Adhesive that is spread too thick will not allow proper fit, and finish of the joint. Adhesive that is spread too thin can result in gaps in the joint and a weak bond.

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6. Position the sink on the adhesive and wiggle it slightly to seat it on the countertop. Insert the two screws in the pre-drilled holes and carefully tighten.



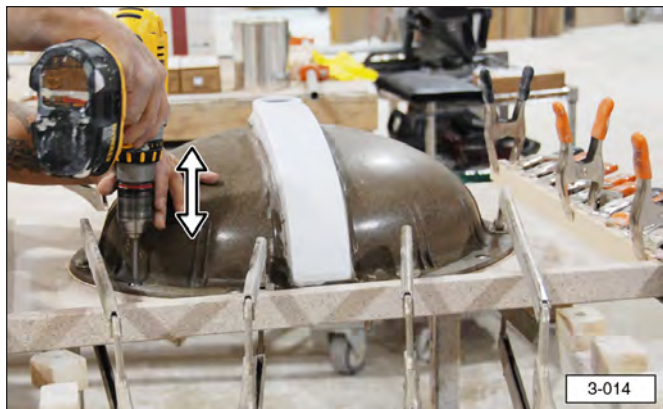
7. Clamp the sink in place using several large deep-throat clamps applied to the rim of the sink and countertop, as shown.



**Note:** Four to six clamps are adequate for a small bar sink. Six to eight clamps work well for a normal vanity sink, and 12 to 14 clamps are required to properly secure a large double bowl sink.



- Once the sink is securely clamped in place, carefully back out one of the two screws from the rim of the sink, then retighten that screw. Repeat for the second rim screw. This will allow the clamps to apply full pressure to the sink rim, without having the sink slide out of position.



- Allow the adhesive to squeeze from between the rim of the sink and countertop to ensure that the joint is completely filled with the adhesive material. A bad glue-up joint is shown in the example below. This lack of adhesive can leave gaps in the interior sink seam that will show up during machining and sanding.



- Record the time the sink was attached to the countertop and allow the adhesive to cure for at least 1 hour.



- Once the adhesive has cured, remove the clamps. Use the Swan Part # VW 0050.000 Special countersink drill bit and drill pilot holes in the remaining sink rim screw locations. Install a Swanstone screw in each of the holes and tighten securely.



## IMPORTANT NOTICE

To avoid damaging the sink or vanity top, do not over tighten the screws. Use caution if using a variable speed drill to install the screws. Install the screws just until they are tight.



## Fabrication

### Cut and Machine Countertop

With the sink secured to the underside of the countertop, the opening for the under mount sink can be cut and machined.

#### IMPORTANT NOTICE

Before cutting the opening in the vanity top, make sure the hole location will not cause the hole saw to damage the sink bonded to the underside of the vanity top. To avoid damage to the sink, locate the opening towards the center of the vanity top.

1. Flip the sink assembly over and support the countertop and sink on a secure work surface. Use a 1 inch to 2 inch diameter tungsten carbide tipped hole saw to cut an opening in the center of the vanity top, as shown.



2. Prepare the router by installing the cutting bit. Use a Swan part # VW 10030.001 bit with roller bearing.



#### IMPORTANT NOTICE

Before cutting the opening in the countertop, make sure the depth of the router bit is adjusted to allow the bearing to ride against the surface of the sink, just below the seam. To avoid damage to the sink and countertop, do not cut against the rotation of the router bit (from right to left) and do not allow the router bit bearing to travel into the sink drain overflow opening.

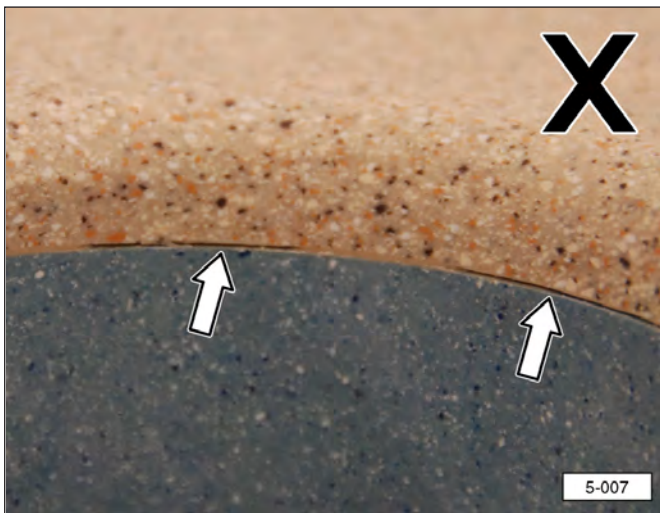


3. Cut the opening in the countertop.
  - a. Start the router in the drilled opening and work outward until the roller bearing contacts the inside surface of the sink.
  - b. Carefully guide the router, cutting from left to right, while keeping router level and firmly against the upper surface of the vanity top. Keep the bearing in light contact with the sink, just under the vanity top.
  - c. Remove and discard the cut out material. Make a second pass with the router, cutting from left to right, to ensure that all excess countertop material has been removed.
  - d. Vacuum shavings from the sink and use denatured alcohol and a clean cloth to wipe off dust before continuing.

**Note:** Marks on the sink caused by the router bit bearing will be removed during the sanding process in a later section.



4. Inspect the sink to countertop seam, looking for any voids or cracks. If defects are found, refer to the Swanstone Removal (disassembly) section for instructions on removing the sink in order to re-glue the seam.



5. Prepare the router by installing the 12 degree bevel bit. Use a Swan part # VW 00010.000 bit with roller bearing.



**IMPORTANT NOTICE**

Before beveling the opening in the countertop, make sure the depth of the router bit is adjusted to allow the bearing to ride against the sink, just below the seam. To avoid damage to the sink and countertop, do not cut against the rotation of the router bit (from right to left) and do not allow the router bit bearing to travel into the sink drain overflow opening.



6. Bevel the opening in the countertop.
  - a. Start the router and move it until the roller bearing contacts the inside surface of the sink.
  - b. Carefully guide the router, cutting from left to right, while keeping router level and firmly against the upper surface of the countertop. Keep the bearing in light contact with the sink, just under the seam.
  - c. Make a second pass with the router, cutting from left to right, to ensure that all excess countertop material has been removed.
  - d. Vacuum shavings from the sink and use denatured alcohol and a clean cloth to wipe off dust before continuing.



## Fabrication

**Note:** Marks on the sink caused by the router bit bearing will be removed during the sanding process in a later section.

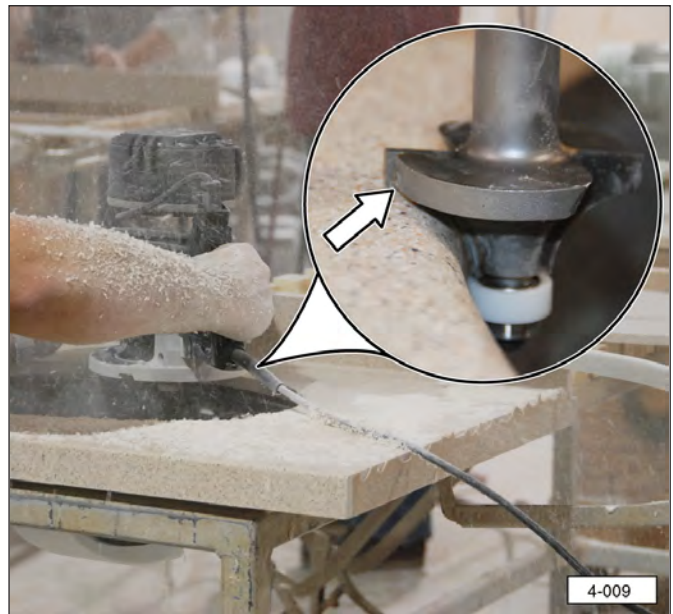


7. Prepare the router by installing the 1/2 inch round over bit. Use a Swan part # VW 00020.000 bit with roller bearing.



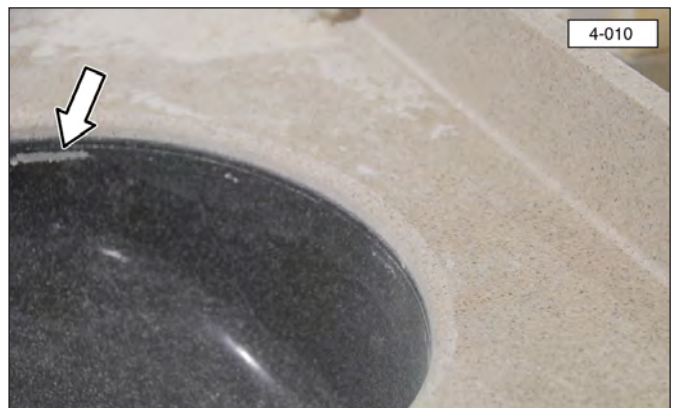
### IMPORTANT NOTICE

Before rounding over the opening in the countertop, make sure the depth of the router bit is adjusted to allow the bearing to ride against the sink, just below the seam. Do not allow the router bit to cut into the upper surface of the countertop, causing an unsightly groove. To avoid damage to the sink and countertop, do not cut against the rotation of the router bit (from right to left) and do not allow the router bit bearing to travel into the sink drain overflow opening.



8. Round over the opening in the countertop.
  - a. Start the router and move it until the roller bearing contacts the inside surface of the sink.
  - b. Carefully guide the router, cutting from left to right, while keeping router level and firmly against the upper surface of the countertop. Keep the bearing in light contact with the sink, just under the seam.
  - c. Make a second pass with the router, cutting from left to right, to ensure that all excess vanity top material has been removed.
  - d. Vacuum shavings from the sink and wipe off dust before continuing.

**Note:** Marks on the sink caused by the router bit bearing will be removed during the sanding process in a later section.



**Finish Sand Sink and Countertop**

With the sink opening cut and machined, the sanding process will remove excess adhesive, blend the edges and give the Swanstone a uniform, finished appearance.

Use 36 grit sandpaper and a palm sander to remove excess adhesive and shape the Swanstone material.

Sanding the Swanstone to achieve a smooth even finish is a three step process using 120, 220, and 320 grit sandpaper and a palm sander. Scotchbrite pads can be used in place of the 320 grit sandpaper, if desired.



**IMPORTANT NOTICE**

To avoid damaging the Swanstone surfaces, always remove sanding dust and wipe all surfaces with denatured alcohol and a clean cloth between sanding with each grade (grit) of sandpaper. This will ensure a smooth, even finish on the Swanstone surfaces.

**Note:** A 4 inch belt sander with 36 grit sandpaper works well for removing large amounts of excess adhesive and rounding the corners on Swanstone countertops.

1. Use 36 grit sandpaper to remove excess adhesive and Swanstone material. Up to a two inch corner radius can normally be applied to a Swanstone counter top with glued on end caps.



2. Use 120 grit sanding pads to remove 36 grit sanding scratches and router bit bearing marks, and to blend edges and seams.

**Note:** If desired, 60 grit sanding pads can be used before the 120 grit sanding pads to remove and blend deeper scratches and marks.





## Fabrication

- Use 220 grit sandpaper to remove sanding scratches and open up the surface to fully reveal the Swanstone pattern. Sand the entire surface of the sink and vanity top.

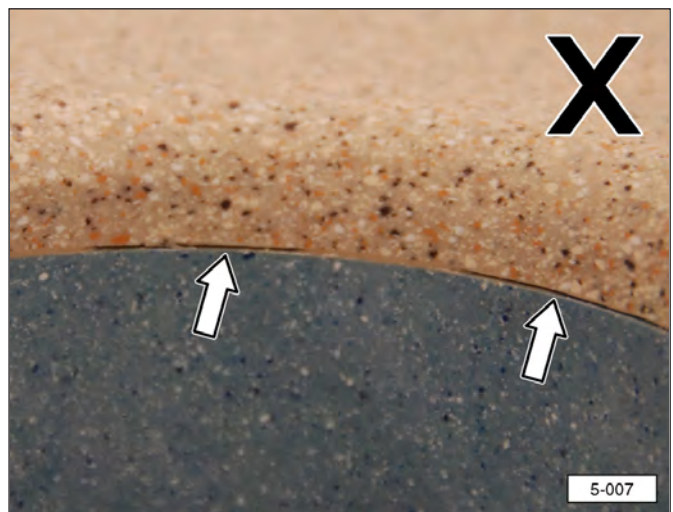
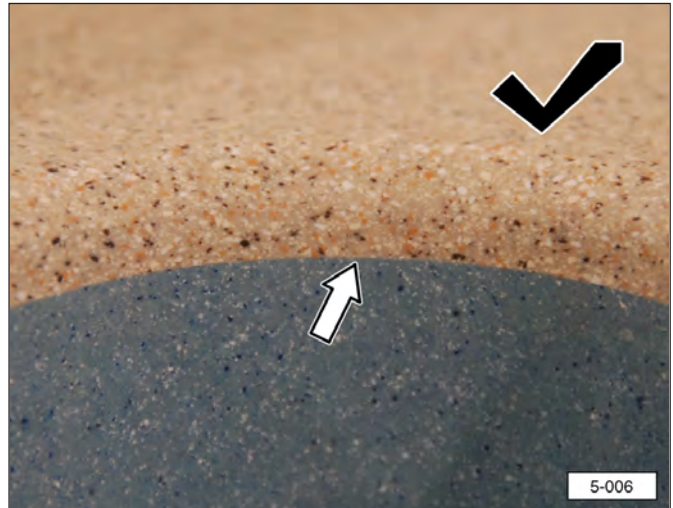


- Use 320 grit sandpaper or Scotchbrite to achieve a final finish. Sand the entire surface of the sink and vanity top.

**Note:** A decorative edge up to 3/4 inch wide can be put on the vanity top using a variety of router bits. The edge treatment should be done after sanding with the 120 grit sandpaper and before sanding with the 220 and 320 grit sandpaper.



**Note:** Inspect all joints and seams, looking for gaps or cracks. If voids in the adhesive joints are found, the components should be taken apart and reglued. For more information on removing Swanstone components, refer to the Swanstone Removal (disassembly) section in this manual.



## Double Bowl Sink and Countertop

### IMPORTANT NOTICE

Before beginning, refer to General Information section for important information on tools, hardware, and special equipment required for Swanstone fabrication.

Swanstone Double Bowl sink fabrication allows under mounting a sink directly to Swanstone solid surface countertops using Swanstone acrylic adhesive. The sink can be the same or a contrasting color. The rim of the under mounted sink is machined to give a seamless appearance, as if it were molded as one piece with the countertop.

### IMPORTANT NOTICE

Swanstone Solid Surface Countertops without a molded-in backsplash are factory sanded and will not exactly match the interior surface pattern of an un-sanded Swanstone sink. To achieve an exact appearance match, pre-sand the entire surface of the sink interior with 120 grit sandpaper, before installation.

## Layout

1. To prevent damaging the top surface of the Swanstone countertop, cover the work table with a clean drop cloth, thin foam pad, or corrugated cardboard
2. Place the Swanstone countertop upside down on the protective cloth or pad.
3. Measure the countertop length and use a pencil to mark the center point.



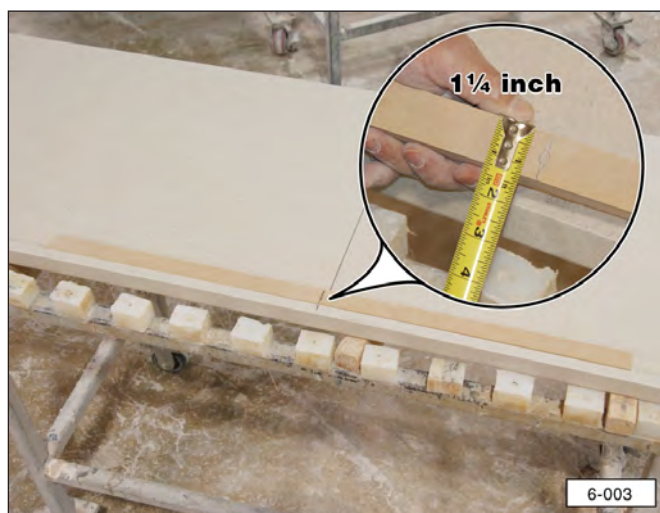
800-325-7008

4. Use a carpenter's square to mark a pencil line indicating the center point of the double bowl sink.

**Note:** If the double bowl sink is not going to be located at the center point on the countertop, measure the distance off of this line and use the carpenter's square to draw a pencil line representing the desired center point of the double bowl sink.



5. Make a spacer board.
  - a. Cut a spacer board out of MDF (Medium Density Fiberboard) 1-1/4 inches wide and as long as needed to support the front edge of the countertop when installed on the cabinets.
  - b. Measure and use a pencil to mark the center point of the spacer board.
  - c. Position the spacer board against the backside of the front lip on the countertop, with the pencil marks aligned as shown.

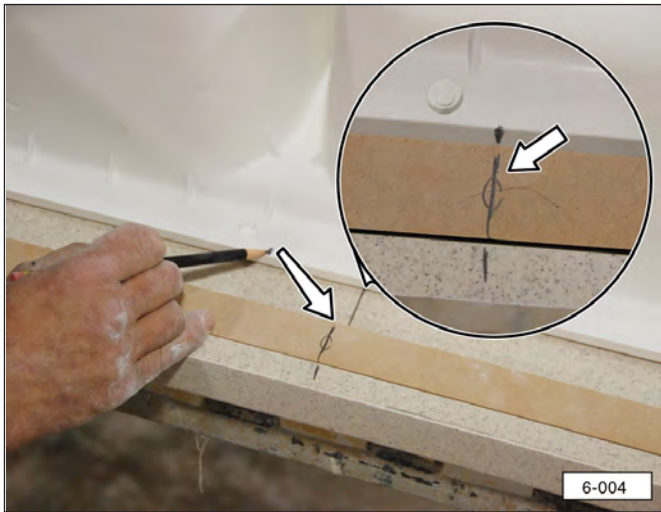




## Fabrication

**Note:** At minimum, the spacer board should be a few inches longer than the overall length of the double bowl sink, including the mounting lip.

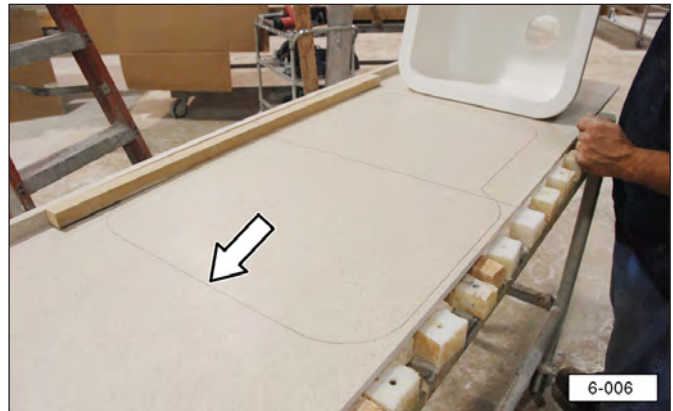
6. Position the double bowl sink upside down on the countertop.
  - a. Align the molded in sink arrow with the line on the spacer board, as shown.



- b. Verify the opposite side molded in sink arrow aligns with the pencil line on the back edge of the counter top, as shown.



7. Use a pencil to draw the outline of the sink on the countertop.



8. Remove the spacer board and sand all the mating surfaces of the countertop and spacer board with 36 grit sanding pads. Wipe down all sanded surfaces with denatured alcohol and let dry completely.
9. Use a good quality contact cement to secure the spacer board to the underside of the countertop, tight against the backside of the front cap (edge).
10. Refer to the appropriate installation instructions outlined in the Vanity Sink and Countertop section to pre-sand, glue-up, machine, and finish sand the Double Bowl sink and countertop.

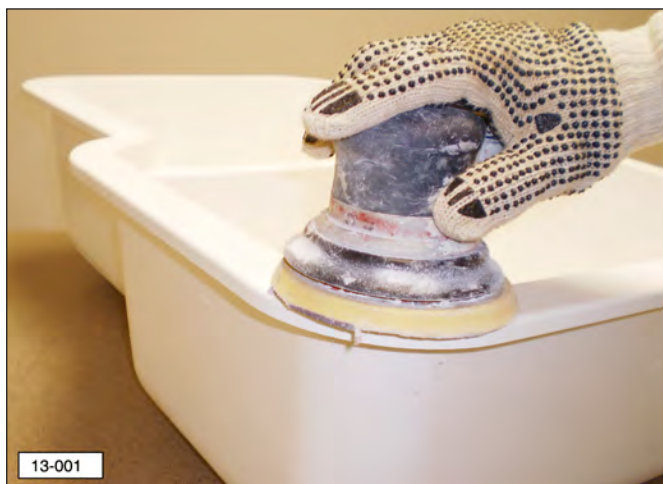
## Undermount Swanstone Sink with Laminate Countertop

**Note:** Modifications will be needed for other styles of laminate tops.

### Prepare Swanstone Sink

1. Sand the entire rim of the sink with a dual action orbital sander using 40 grit sandpaper. Make sure there are consistent grooves (scratches) on the entire rim.

**Note:** Do not roll the sander over the inside edge of the sink bowl. It is necessary to maintain the integrity of the sharp inside edge to ensure a uniform glue line with the laminate top.



13-001

2. Sand the outside perimeter (edge) of the sink with 40 grit sandpaper.



13-002

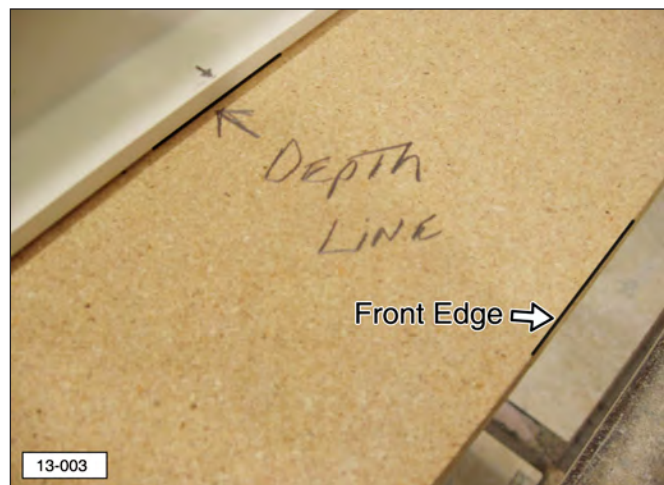
3. Clean the sink with denatured alcohol to remove any sanding particles.

### Prepare Wood Substrate

**Note:** Preparing the wood substrate is done before the laminate is applied. This process will not work on prelaminated countertops.

1. Position the Swanstone sink in the desired location on the underside of the wood substrate. Measure and mark the proper depth of the sink from the front edge of the wood substrate.

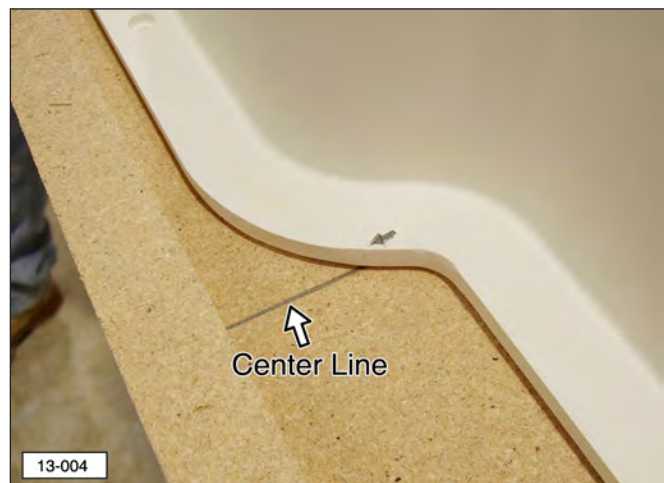
**Note:** Remember to allow for tip trays/specialty cabinets or bump outs when measuring for the depth of the sink.



13-003

2. Find the center line of the sink and mark this line on the substrate. Line up locator arrows on the sink flange and position the sink on the centerline and on the depth line.

**Note:** Make sure the sink flange is parallel with the front edge of the countertop.

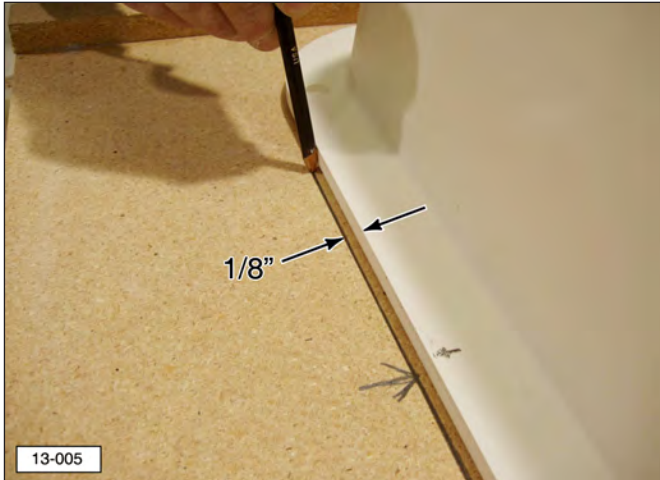


13-004



## Fabrication

- Trace the entire sink perimeter onto the wood substrate. Mark this line 1/8 inch larger than the sink perimeter.



### IMPORTANT NOTICE

To allow for proper glue up, make sure the cutout is 1/8 inch larger all the way around the perimeter of the Swanstone sink.

- Cut the wood substrate using a jigsaw with a wood cutting blade. Trial fit the sink into the cutout and make sure there is a 1/8 inch clearance between the substrate and the outer edge of the sink flange all the way around. If not recut the substrate.

**Note:** Save the cut out substrate piece for use during the countertop lamination procedure.

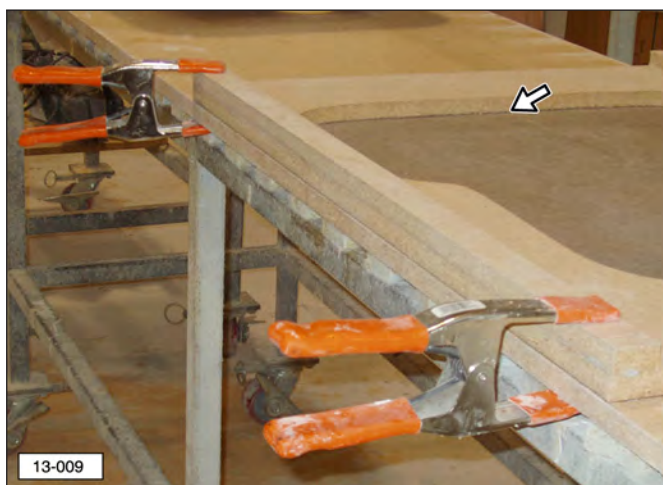


## Apply Laminate

- Apply laminate to the front (thick) edge of the countertop substrate following normal glue-up procedures. If necessary, trim the top of the front edge laminate flush with the top surface of the wood substrate with either a belt sander or router.



2. Mark the sink location on the laminate material.
  - a. Place the laminate material finished side down on a sturdy workbench or table. To prevent damaging the laminate material, first cover the table with a clean drop cloth, thin foam pad, or corrugated cardboard.
  - b. Place the countertop substrate over the laminate material, positioned exactly as it will be glued up.
  - c. Use the cut-out in the substrate to mark the sink perimeter on the laminate material.
  - d. Remove the countertop substrate.



3. Place the sink cut-out on the laminate material, aligning it with the mark made in Step 2 (where the sink will be located). The sink cut out will prevent over spraying of contact adhesive onto the underside of the laminate material where the sink will be glued.



4. Spray the top of the wood substrate and bottom of the laminate material with contact cement.



5. Bond the two pieces together, following all normal glue-up procedures.

## IMPORTANT NOTICE

Follow all laminate material manufacturers instructions for bonding the laminate material to the substrate. Make sure the adhesive is fully cured and the laminate material is securely bonded to the substrate before undermounting the Swanstone sink.



# Fabrication

## Undermount Swanstone Sink

1. Clamp the countertop, finished side down, to a sturdy workbench or table to ensure a proper fit of the sink. To prevent damaging the laminate material, first cover the table with a clean drop cloth, thin foam pad, or solid thickness cardboard.



### IMPORTANT NOTICE

Before gluing the sink to the laminate all the sanded surfaces must be clean. Dust, dirt particles, or contact cement left on the gluing surface can cause the sink to not adhere properly to the laminate.

2. Using a soft, clean cloth, wipe down the underside of the laminate material and the edge of the substrate with denatured alcohol. Do not use paper towels, mineral spirits or lacquer thinner. Remove all dust and let the surfaces dry completely.



3. Using a soft, clean cloth, wipe down the rim (mounting flange) and outside perimeter of the Swanstone sink with denatured alcohol. Do not use paper towels, mineral spirits or lacquer thinner. Remove all dust and let the surfaces dry completely.



4. Gather the proper tools and adhesive to glue the sink to the laminate.

### IMPORTANT NOTICE

To prevent damage or inadequate adherence of the sink to the laminate, only use color matched acrylic Swanstone Surfacing Adhesive. Other manufacturers adhesive will not work and will void the warranty if used.



**Note:** The adhesive required to bond a single bowl sink is approximately 1/3 of a cartridge and the adhesive required to bond a double bowl sink is approximately 1/2 of a cartridge.

## IMPORTANT NOTICE

Before application, dispense enough adhesive to allow complete mixing of the two-part adhesive in the corkscrew design nozzle onto a piece of scrap material. Freshly mixed adhesive will provide a full 10 minute working time and ensure the two parts are mixed correctly.

4. Apply the recommended Swanstone adhesive to the laminate material.
  - a. Dispense some of the Swanstone adhesive through the nozzle, onto scrap material. This will ensure that the adhesive is mixing properly.

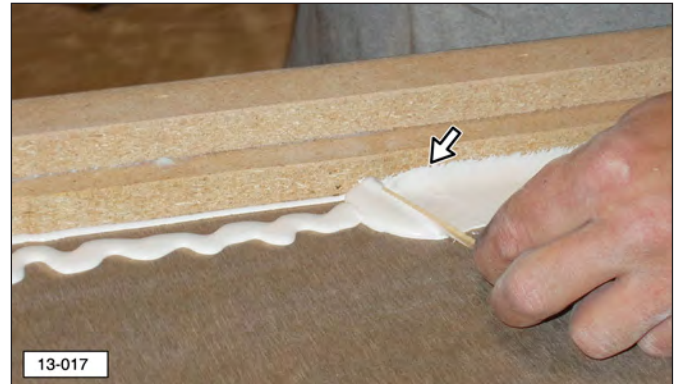


- b. Apply a 2 inch wide bead of Swanstone adhesive, in an s-shape pattern, onto the laminate material around the perimeter of the substrate sink cut out.

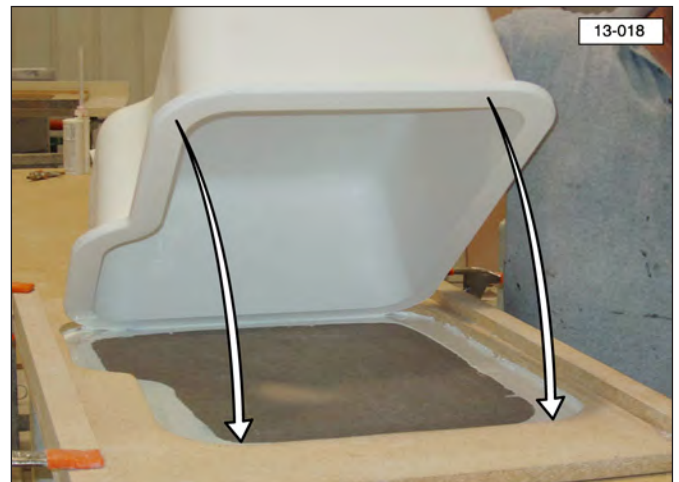
**Note:** Swanstone adhesive causes an exothermic reaction when mixed. Do not interrupt applying the adhesive once you begin, otherwise the adhesive may cure (harden) in the nozzle.



- c. Spread the Swanstone adhesive with a wood stick. Spread the adhesive slightly wider than the sink flange (about 2 inches) on the laminate material and up the side of the substrate, as shown.



5. Position the sink in the substrate cutout and gently move it around to create a good bond with the Swanstone adhesive.

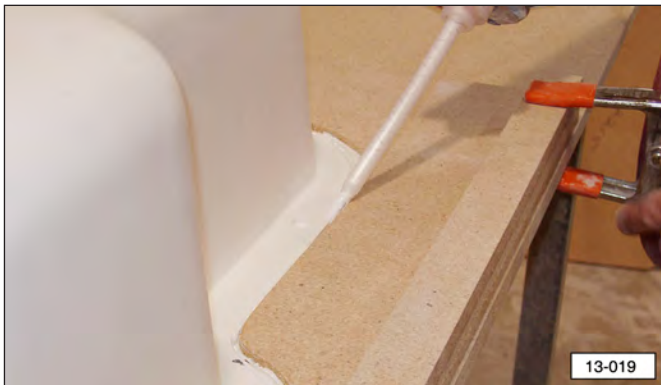


**Note:** It is very important that the laminate is lying on a flat surface. If the surface of the table is uneven, the bond between the sink and laminate may have air gaps.



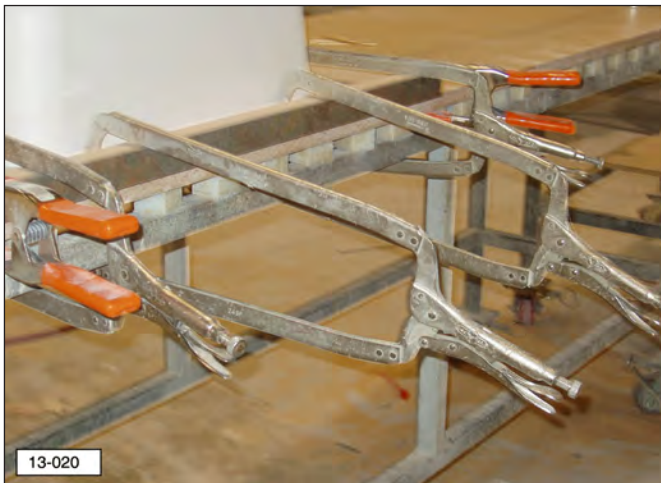
## Fabrication

6. Apply a generous bead of Swanstone adhesive in the perimeter gap between the sink and wood substrate. The goal is to bond the sink to the substrate, in order to form a strong, uniform joint.



7. With the countertop still clamped to the sturdy workbench or table, fasten a minimum of 6 extended throat vice clamps onto the sink flange and underside of the workbench or table. Allow the adhesive to cure for at least 1 hour for before finishing.

**Note:** Do not use bar clamps, weights, or threaded rod clamps through the sink drain opening.



8. Each Swanstone sink kit contains factory supplied mounting clips and screws. These clips must be installed to secure the Swanstone sink to the laminate countertop.

- a. Line up clips around the perimeter of the sink, using the pilot holes (molded into sink) on the sink rim as a placement guide.

**Note:** Do not install clips in the area where the faucet base will be seated.



- b. Use a screwdriver to install self-tapping wood screws through the clip slots, as shown. Do not overtighten the clip screws.



**Note:** To allow for proper countertop fit, it may be necessary to cut off the back edge of some clips when installed near the front or back edges of the countertop. Test fit the clip, mark a line and cut off the excess material.



**Finishing Procedure**

1. Once the adhesive has cured for at least an hour, unclamp the counter top, turn it over, and support it on sawhorses or an open top table.

**IMPORTANT NOTICE**

To prevent damage, do not allow the Swanstone sink bottom to bear the weight of the countertop during the finishing procedure. Always place the countertop on sawhorses or an open top table during finishing.



2. Use a hole saw to drill a one inch diameter hole in the laminate material, within the bowl of the sink.

**IMPORTANT NOTICE**

Before drilling the hole in the laminate, make sure the hole location will not cause the hole saw to damage the sink. To avoid damage to the sink, locate the opening towards the center of the countertop.



3. Use a router and a laminate trim bit, with a roller bearing, to cut out the laminate.

**IMPORTANT NOTICE**

Before cutting the opening in the countertop, make sure the depth of the router bit is adjusted to allow the bearing to ride against the surface of the sink, below the seam. To avoid damage to the sink and countertop, do not cut against the rotation of the router bit (from right to left) and do not allow the router bit bearing to travel into the sink drain overflow opening, if equipped.





## Fabrication

4. Remove the cut out laminate and inspect the adhesive seam. Make sure there are no gaps or cracks in the joint.



5. Blend and finish the sink and countertop seam.
  - a. Use a dual action orbital sander at a 45 degree angle to sand the laminate material edge and Swanstone sink with 320 grit sandpaper. Blend the edge of the laminate material and Swanstone sink into a smooth seam with a finished appearance.

### IMPORTANT NOTICE

To avoid damage to the laminate material, do not allow the sander to come in contact with the finished (top) surface of the countertop.



- b. Vacuum out the dust and clean the sink with a soft cloth and approved cleansers.

### IMPORTANT NOTICE

Abrasive cleansers are NOT APPROVED for laminate material countertops. ALWAYS consult your laminate material supplier for cleaning guidelines on the laminate countertop surface.

## Installing Faucets

When installing faucets, etc, it is necessary to apply silicone sealant to the wood substrate at any hole, cut out, or other opening that may have been drilled through the laminate material countertop (i.e. air gaps, sprayers or hot water dispensers.) Always follow the manufacturers installation instructions for any accessory installed through the countertop. Swan Surfaces is not liable for any faucet, sprayer or hot water dispenser installations.

### IMPORTANT NOTICE

Swan Surfaces warranties Swanstone sinks only from any manufacturer's defects. Swanstone reserves the right to either repair or replace a defective sink. Swanstone does not warranty the labor or the laminate material countertop.

## Countertop Seam (shop fabrication)

### IMPORTANT NOTICE

Before beginning, refer to General Information section for important information on tools, hardware, and special equipment required for Swanstone fabrication.

Swanstone countertop fabrication allows joining two or more sections of solid surface material to form various countertop configurations, with a seamless appearance. This European (dogleg) joint is designed to be used with Swanstone solid surface material without a molded-in backsplash.

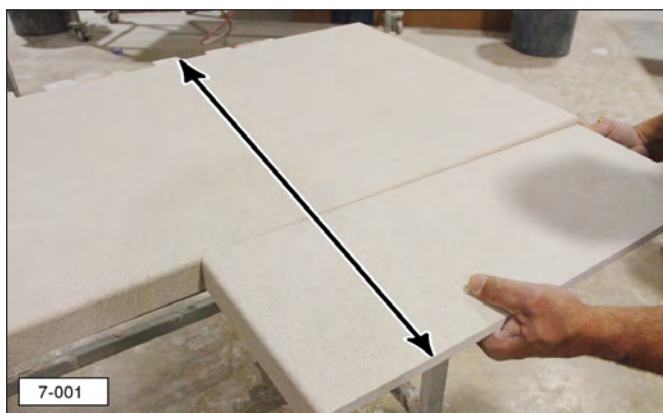
**Note:** When possible, countertop fabrication should be done in the shop to control the fabrication process, minimize on site dust, and reduce installation time.

### IMPORTANT NOTICE

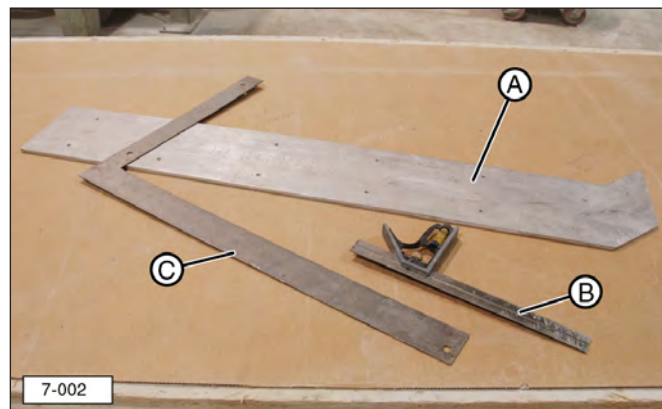
To minimize installation time and avoid damage to the building site, cabinets, and/or Swanstone countertop, double check all measurements before cutting, joining, and sanding the fabricated countertop. Make sure the mating edges of the countertop sections are square and true.

## Layout

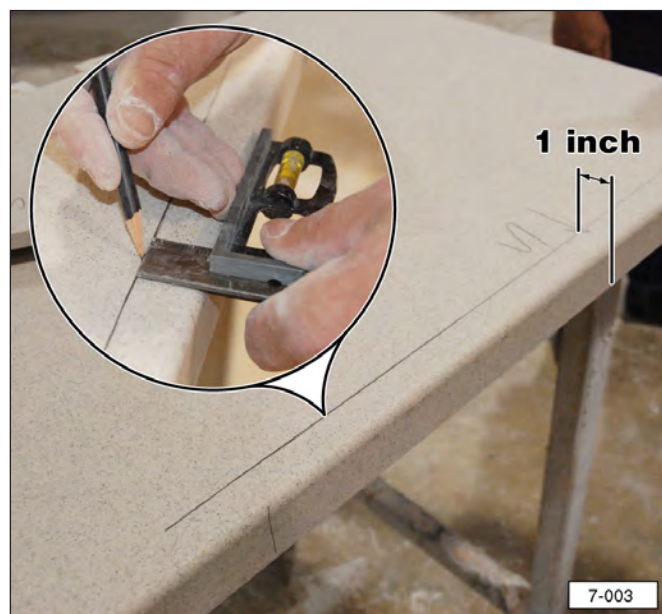
1. Allow an additional 1-1/8 inch or more when calculating the finished length of the countertop. This material will be removed to form the “dogleg” joint in the two sections of the countertop.



**Note:** In addition to a tape measure, you will need a Swan VW 00140.00 Template (A), an adjustable square (B), and a carpenters square (C) to lay out the European seam.



2. Set the adjustable square at 1 inch depth and mark a pencil line along the seam edge of the countertop main section.



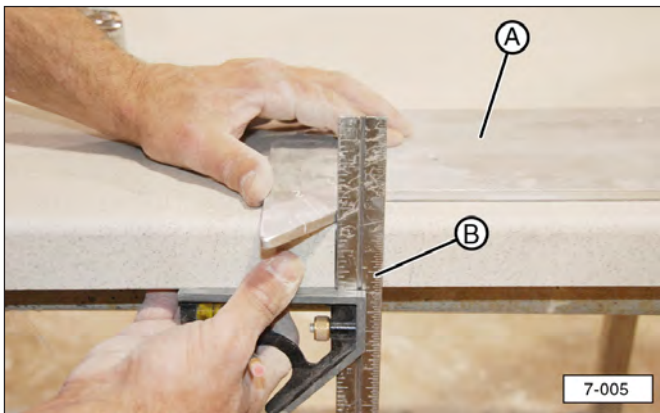


## Fabrication

3. Measure the width of the countertop leg and transfer this measurement to the pencil line previously marked on the main countertop section. Use the adjustable square to mark an intersecting pencil line, as shown.



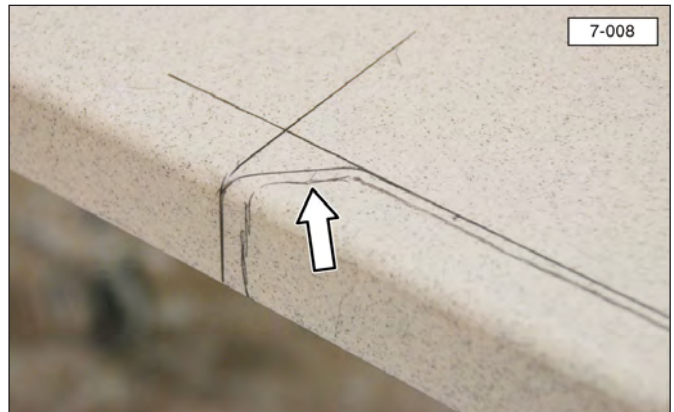
4. Lay template (A) on the long pencil line marked in Step 2. Use adjustable square (B) to position the template on the short pencil line marked in Step 3.



5. Mark a pencil line on the countertop to connect the long and short pencil lines using the template angle as a guide.



6. Mark a "rough cut" line 1/8 to 1/4 inch away from the seam line. This is the material that must be removed prior to machining the seam with a router.

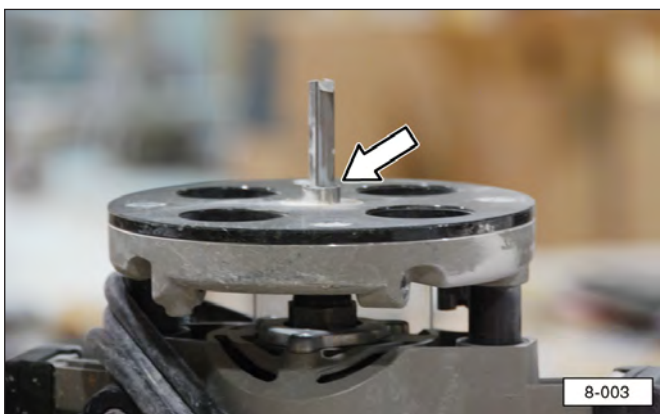


**Cut and Machine Countertop**

1. Use a saber saw with a carbide grit blade to cut away the excess Swanstone material.

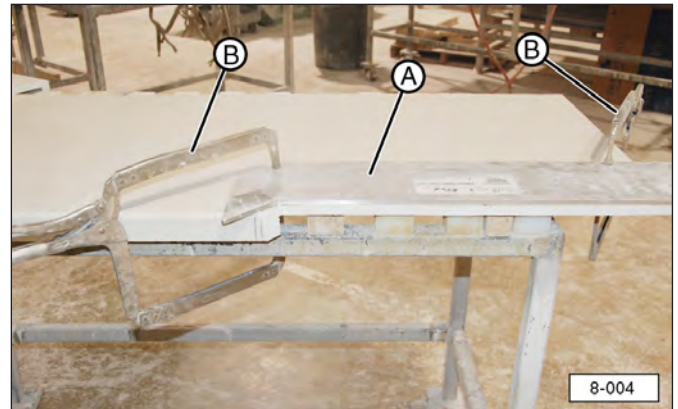


2. Measure the offset between the router cutting bit and guide. This measurement (1/16 inch in this example) is transferred to the countertop main section.



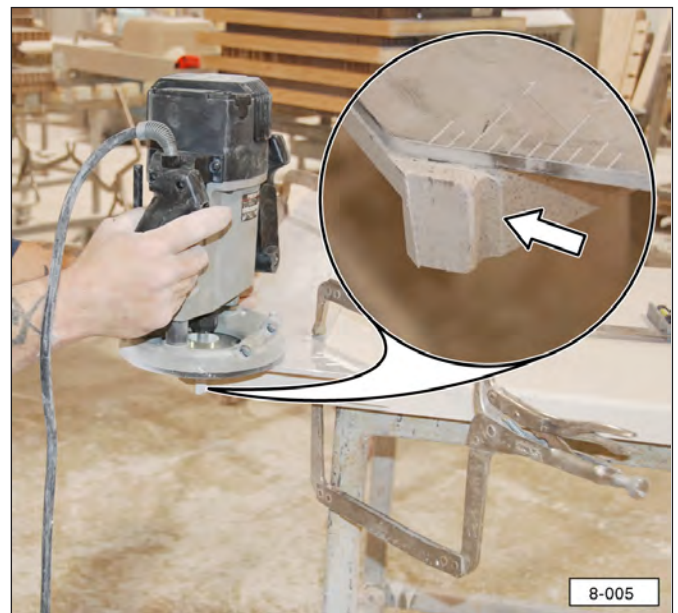
3. Use clamps (B) to position VW 00140.00 Template (A) **back** from the seam line the amount measured in Step 3 (1/16 inch in this example).

**Note:** The set back is to allow for the thickness of the router guide. This will allow the router bit to cut exactly to the seam line.



**IMPORTANT NOTICE**

Damage (chipping) to the countertop can occur when finishing an angle cut at the countertop front edge. To avoid damage, hold the router very firmly and carefully back the router into the front of the countertop approximately 1/4 inch to form a clean edge, as shown.



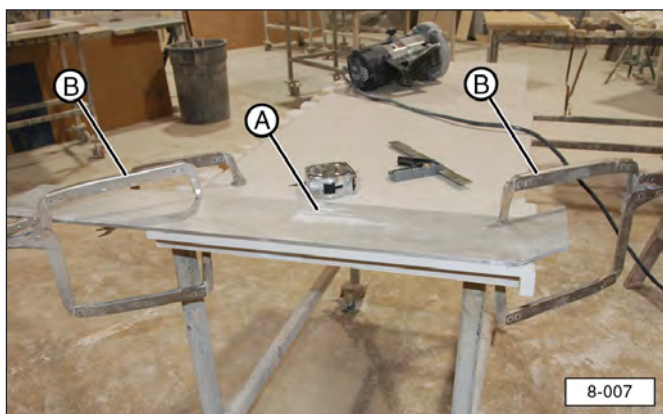


## Fabrication

- Use the router to finish cut the edge of the countertop main section, cutting with the rotation of the router blade (left to right).



- Clamp the second countertop (leg section) to a stable work surface.
- Use the carpenter's square to mark a pencil line 90 degrees off the front edge of the countertop leg, parallel to the mating end. This seam line should be held back 1/8 inch from the mating end of the countertop leg.
- Use clamps (B) to position VW 00140.00 Template (A) on the countertop leg. The template should be flipped over with the corner angle away from the seam edge and set back from the seam line the amount measured in Step 3 (1/16 inch in this example).

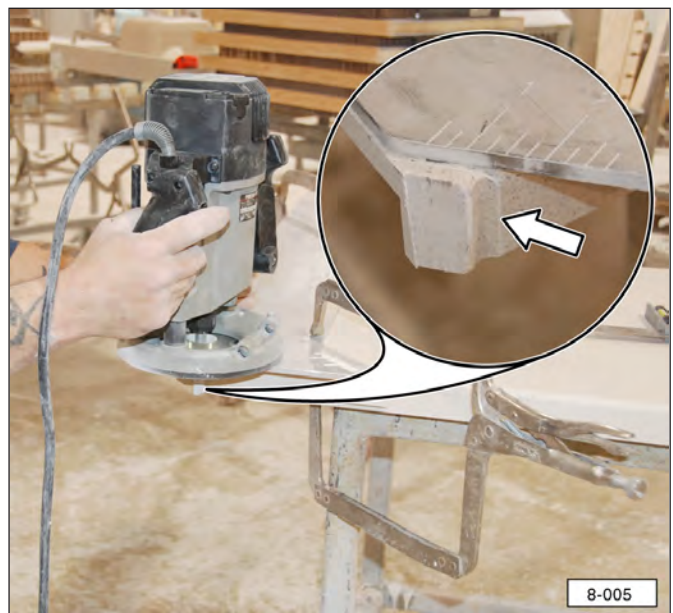


- Use the saber saw to remove the excess Swanstone material from the front cap (edge) corner.

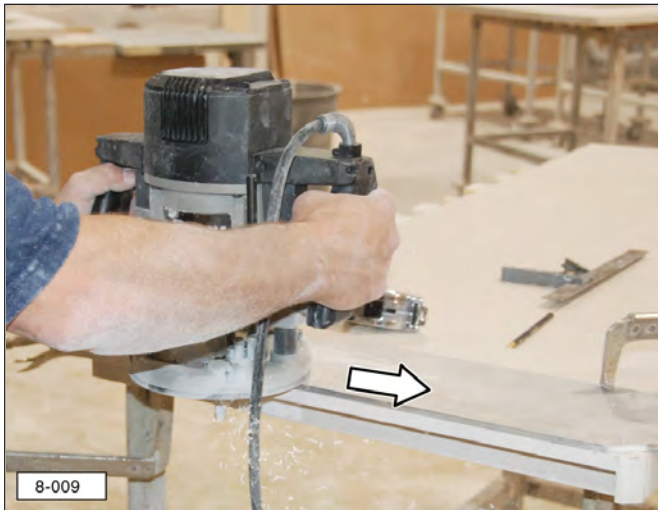


### IMPORTANT NOTICE

Damage (chipping) to the countertop can occur when finishing an angle cut at the front cap (edge). To avoid damage, hold the router very firmly and carefully back the router into the front edge of the countertop approximately 1/4 inch to form a clean edge, as shown.



- Use the router to finish cut the edge of the countertop leg, cutting with the rotation of the router blade (left to right).

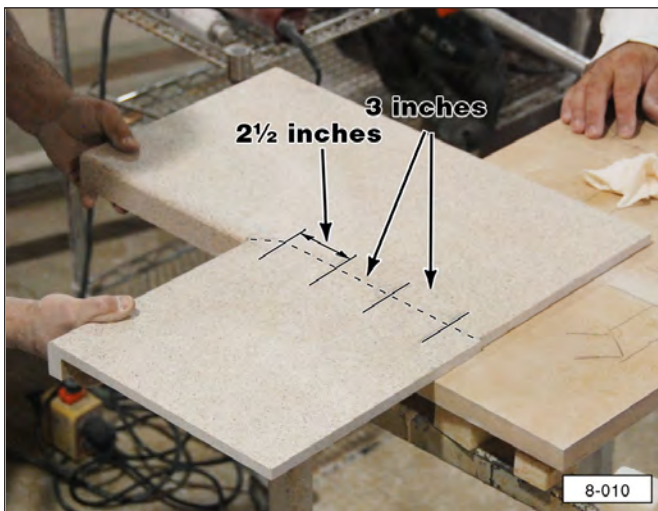


**Note:** To avoid extending a biscuit slot beyond the edge of the countertop, make sure the last biscuit slot measurement is in at least 2-1/2 inches from the countertop end edge, as shown in the photo insert.



**Cut Biscuit Slots**

- Trial fit the countertops and mark for cutting biscuit slots. The first slot must be a minimum of 2-1/2 inches from the angled corner and approximately every three inches apart after that.



- Use the biscuit joiner to cut biscuit slots for #20 biscuits at each mark on the main countertop section and the countertop leg.





# Fabrication

## Countertop Glue-up

1. Use 36 grit sandpaper to abrade the edge of both countertop seam edges. Fold the sandpaper and sand the inside of each biscuit slot.



### IMPORTANT NOTICE

Improper seams can occur if contaminated with wood fibers from tight fitting biscuits or other foreign material. If necessary, sand the wood biscuits until they fit easily into the biscuit slots.

2. Trial fit the #20 biscuits. They must fit loosely without scrapping off wood fibers when inserted.



3. Trial fit the countertops. They must fit together tightly with the biscuits installed.



4. Clean both countertop sections with denatured alcohol to remove all pencil marks and dust. Thoroughly clean the seam edges and slots.



5. The Swanstone Surfacing Adhesive has a working time of ten minutes and a cure time of 1 hour. Gather all the tools needed before beginning glue-up.
  - a. Have two inch wide masking tape, several glue spread sticks, a flexible putty knife, denatured alcohol, and clean rags available for spreading the acrylic adhesive and for clean up.
  - b. Have appropriate clamps (suction cup clamps or long bar clamps) ready to secure glued-up countertop sections together.

## IMPORTANT NOTICE

Before applying adhesive onto a Swanstone component, always dispense some of the adhesive into a waste container. Dispense enough adhesive to allow complete mixing of the two part adhesive in the corkscrew design nozzle. This way, freshly mixed adhesive with a full 10 minute working time will be dispensed onto the components to be joined.

6. Select the correct matching color Swanstone Surfacing Adhesive cartridge(s). Follow manufacturers instructions to install a mixing nozzle and install the cartridge in a dispensing gun.
7. Apply two inch wide masking tape (A) 1/16 inch back from the edge of both countertop sections, as shown. Dispense a bead of adhesive (C) into the biscuit slots and on the seam edges of both countertop sections.

**Note:** The masking tape must be removed before the clamps are taken off. To allow for easy tape removal, fold tape sections back where clamps will cross seam (B), as shown.



8. Join the countertop sections, leaving a 1/8 inch seam gap.



9. Completely fill the seam gap with the correct color Swanstone Surfacing Adhesive.

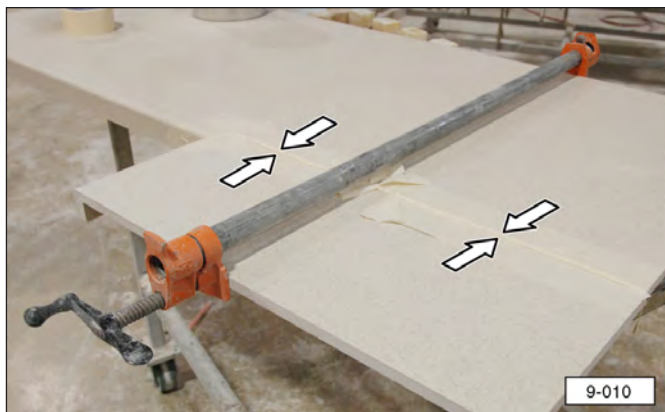




## IMPORTANT NOTICE

Over tightening clamps can pull up on the countertops, causing an bowed surface at the seam. Do not squeeze all the adhesive out of the seam. Only tighten clamps enough to draw the seam together. Check countertops for level after clamping and adjust the tension as necessary.

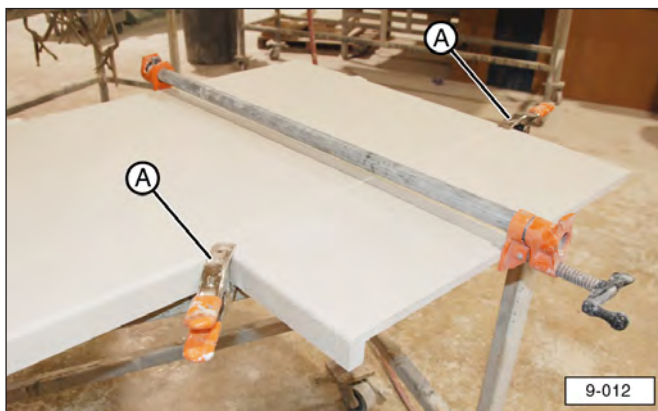
10. Install appropriate clamps across the seam, as shown. Use the clamping mechanism to draw the two countertop sections together.



11. Use glue spread sticks to smooth out the Swanstone Surfacing Adhesive along the entire seam. Remove excess adhesive from the inside corner joint.

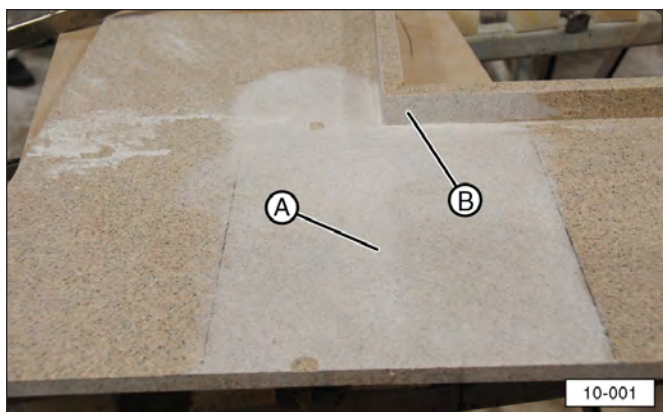


12. Pull up the masking tape, leaving a 1/8 inch wide bead of adhesive along the seam. Install clamps (A) at the seam corners to help align the joint. Let the adhesive cure one hour.

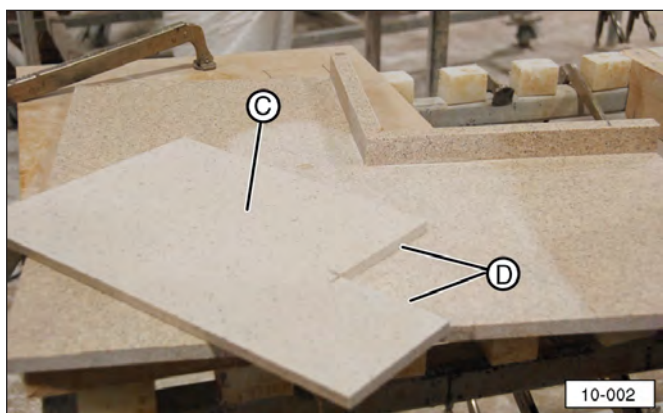


## Countertop Support Structure

1. After the adhesive has cured and the clamps are removed, flip the countertop assembly over.
  - a. Rough sand 6 inches on either side of seam (A) with 36 grit sandpaper.
  - b. Abrade the back side of the countertop corner front edge (B).
  - c. Wipe the sanded area with denatured alcohol to remove all dust.



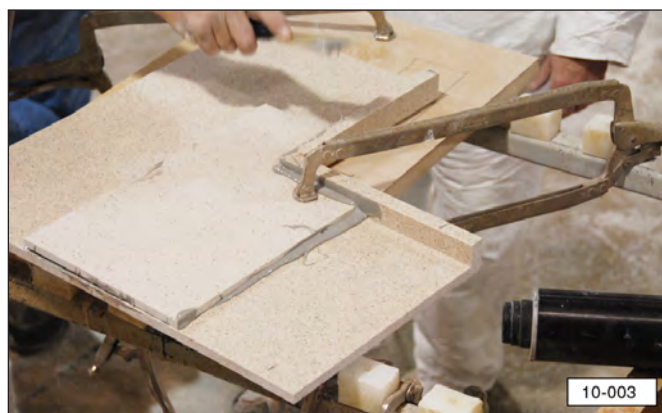
2. Cut a 12 inch wide piece of Swanstone material the length of the seam plus 6 inches, to form a support plate.
  - a. Notch the plate to fit around the countertop front edge corner, as shown.
  - b. Rough sand side (C) of the plate that will be applied to the underside of the countertop and abrade the corner edges (D).
  - c. Wipe the sanded area with denatured alcohol to remove all dust.



## IMPORTANT NOTICE

Before applying adhesive onto a Swanstone component, always dispense some of the adhesive into a waste container. Dispense enough adhesive to allow complete mixing of the two part adhesive in the corkscrew design nozzle. This way, freshly mixed adhesive with a full 10 minute working time will be dispensed onto the components to be joined.

3. Follow manufacturers instructions to install a mixing nozzle and place the Swanstone Adhesive cartridge in a dispensing gun.
4. Attach the support plate to the underside of the countertop.
  - a. Apply an S shaped bead of adhesive across the plate and on the corner edges. Spread the adhesive evenly using a glue spread stick.
  - b. Position the support plate over the seam and secure in place with several clamps. Make sure adhesive squeezes out of the joints, as shown.



- c. Remove the excess adhesive with a putty knife, denatured alcohol, and clean cloths. Allow the adhesive to cure one hour before removing the clamps.





# Fabrication

## Sanding

1. With the countertop positioned finished side up, sand the countertop seam area with 120 grit sandpaper to remove excess adhesive from the seam. Wipe off the dust with denatured alcohol and a clean cloth.



**Note:** A file can be used to carefully remove excess adhesive from the inside corner.



2. Use 220 grit sandpaper to blend the seam area and sand the entire countertop. Wipe off the dust with denatured alcohol and a clean cloth.



3. Use 320 grit sandpaper to sand and finish the entire countertop. Wipe off the dust with denatured alcohol and a clean cloth.



## Countertop Seam (Field Fabrication)

### **IMPORTANT NOTICE**

Before beginning, refer to General Information section for important information on tools, hardware, and special equipment required for Swanstone fabrication.

Swanstone countertop fabrication allows joining two or more sections of solid surface material to form various countertop configurations, with a seamless appearance. The European (dogleg) joint is designed to be used with Swanstone solid surface material without a molded in backsplash.

**Note:** Countertop fabrication in the field utilizes the same basic procedures as in the shop fabrication. Field installation requires that the support plate and European joint glue-up is done in one step, as the countertop is placed in position on the cabinets.

## IMPORTANT NOTICE

To minimize installation time and avoid damage to the building site, cabinets, and/or Swanstone countertop, double check all measurements before cutting, joining, and sanding the fabricated countertop. Make sure the mating edges of the countertop sections are square and true.

**Note:** Prior to Swanstone countertop field fabrication:

- a. All cabinets must be installed and level.
  - b. Any countertop support blocks must be glued in place on the underside of the Swanstone Countertop.
  - c. Any under counter mount sinks must be installed.
1. Follow the steps in the Countertop European Seam (Shop Fabrication) Layout, Cut and Machine, and Cut Biscuit Slot sections to prepare the countertop sections for glue-up.
  2. Follow the steps in the Countertop European Seam (Shop Fabrication) Support Structure section to cut, sand, and trial fit the seam support plate.
  3. Trial fit the countertop assembly.
    - a. Set the main section of the countertop on the cabinets, insert the support plate under the seam of the countertop and check for proper fit. Make any necessary adjustments.
    - b. Place the second leg of the countertop on the cabinets with the biscuits installed and dry fit the seam. Make any necessary adjustments.
    - c. When countertop fit is set, carefully remove the second leg of the countertop assembly. Also remove the support plate prior to glue-up.
    - d. Clean all sanded Swanstone surfaces with denatured alcohol and a clean cloth.

## IMPORTANT NOTICE

Before applying adhesive onto a Swanstone component, always dispense some of the adhesive into a waste container. Dispense enough adhesive to allow complete mixing of the two part adhesive in the corkscrew design nozzle. This way, freshly mixed adhesive with a full 10 minute working time will be dispensed onto the components to be joined.

4. Select the correct matching color Swanstone Surfacing Adhesive cartridge(s). Follow manufacturers instructions to install a mixing nozzle and install the cartridge in a dispensing gun.
5. Follow the steps in the Countertop European Seam (Shop Fabrication) Support Structure section to apply and spread the adhesive on the sanded side of the support plate. Position (center) the support plate under the seam of the main section of the countertop.
6. Follow the steps in the Countertop European Seam (Shop Fabrication) Countertop Glue-up section to apply masking tape, adhesive, and biscuits, to the Swanstone countertop sections.
7. Install the second leg of the Swanstone countertop and follow the steps in the Countertop European Seam (Shop Fabrication) Glue-up section to apply adhesive and secure the sections together with appropriate clamps, until the adhesive cures.
8. Install long reach clamps through the cabinets and over the top of the countertops to secure the support plate to the countertop, until the adhesive cures.
9. Allow the adhesive to cure one hour. Follow the steps in the Countertop European Seam (Shop Fabrication) Sanding Countertops section to sand the seams and finish sand the countertop assembly.



## Fabrication

### Adding a Stacked Edge Buildup

If the countertop will need a thicker front edge, a matching stacked edge buildup can be fabricated and installed to the countertop. For proper strength, the buildup can be made from excess material of 1-3/4" wide strips. Three strips are stacked on top of each other when using .40" sheets and 2 layers are stacked when .50" sheets are used.

1. Before beginning fabrication of the stacked edge or drop edge, please check color of strip material with color of deck to ensure proper color match.



2. To ensure proper glue adhesion when fabricating, it is important to prepare all strip material and deck material by abrading with 36 grit (535 Micron) sandpaper, then cleaning abraded surfaces with denatured alcohol or Methyl Ethyl Ketone (MEK). Do NOT use Mineral Spirits. Remove all dust and let the surfaces dry completely.



### IMPORTANT NOTICE

Select the correct matching color Swanstone Adhesive cartridge(s). Follow manufacturer's instructions to install a mixing nozzle and install the cartridge in a dispensing gun.

Before applying adhesive onto a Swanstone component, always dispense some of the adhesive into a waste container. Dispense enough adhesive to allow complete mixing of the two-part adhesive in the corkscrew design nozzle. This way, freshly mixed adhesive with a full 10-minute working time will be dispensed onto the components to be joined.

3. The Swanstone Adhesive has a working time of ten minutes and a cure time of 1 hour. Gather all the tools needed before beginning buildup.
  - a. Have small clamps ready to position on the stacked edge until the adhesive cures.
  - b. Have several glue spread sticks, a flexible putty knife, denatured alcohol, and clean rags available for spreading the acrylic adhesive and for clean-up
4. Using Swan's color match adhesive, place an even and generous amount on the deck surface and on the sides of the strip material that will be adhered to each other.



5. Use a spread stick to smooth out the adhesive so that it completely covers the deck area where the strips will be installed. Spread adhesive on the front, back and side edges of the strips so that no areas of the seamed joint will be seen. This promotes the best surface adhesion.

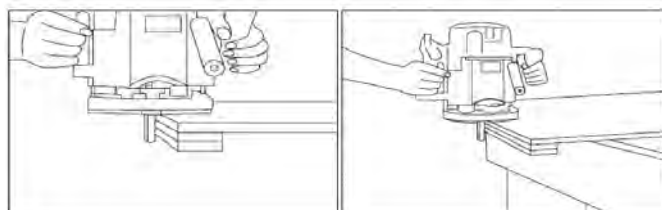


6. Position the first 2" spring clamp or similar type clamp at the edge of the countertop and then every 2-2-1/2" across the entire length. This will give just enough clamping pressure to make an inconspicuous seam.



**Note:** Allow adhesive to squeeze from all the seams to make sure that each joint is filled with the adhesive material. Excess adhesive on the underside edge of the buildup should be removed with a putty knife, denatured alcohol, and a clean cloth.

7. Allow 60 minutes for the adhesive to properly dry before the next step. Allow 1 - 1 1/2 hours for the adhesive to dry in cold climate.
8. Once all are dried, rout the front edge square to the top. This can be accomplished by either setting up a straight edge and router with template guide, or by using a flush cutter.



9. Sand out any imperfections left by the routing process, using the 3-step sanding procedure described in this manual to achieve a smooth even finish

**Note:** These instructions include how to glue multiple buildup layers at one time. You can also work one layer at a time to keep the process cleaner.



## Fabrication

### Adding a Drop Edge Buildup

If the countertop will need multiple depth edges, a dropped edge buildup will allow the ability to create multiple depths with one seam.

1. We recommend using two strips measuring 1-3/4" wide strips using either .40" or .50" sheets. The thickness of 2 strips adhered together provide a minimum of at least 3/4" glue surface for proper installation.



2. A 2" drop edge will require 3 strips, or a minimum of 1-3/16" surface area, while a 3" drop edge will require 4 strips, or a minimum of 1-9/16" surface area.

**NOTE:** This illustration is of a typical standard edge depth. For longer profile edges, it will require more strips to be used to provide the necessary adhesive surface area for added strength.

3. Before beginning fabrication of the stacked edge or drop edge, please check color of strip material with color of deck to ensure proper color match.

4. To ensure proper glue adhesion when fabricating, it is important to prepare all strip material and deck material by abrading with 36 grit (535 Micron) sandpaper, then cleaning abraded surfaces with denatured alcohol or Methyl Ethyl Ketone (MEK). Do NOT use Mineral Spirits. Remove all dust and let the surfaces dry completely.



### IMPORTANT NOTICE

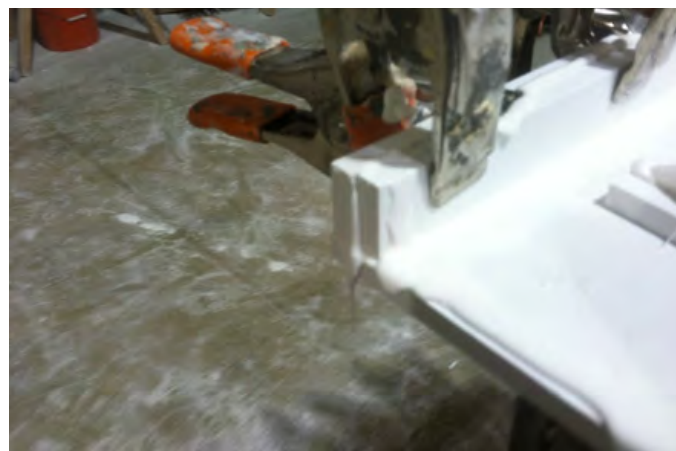
Select the correct matching color Swanstone Adhesive cartridge(s). Follow manufacturer's instructions to install a mixing nozzle and install the cartridge in a dispensing gun.

Before applying adhesive onto a Swanstone component, always dispense some of the adhesive into a waste container. Dispense enough adhesive to allow complete mixing of the two-part adhesive in the corkscrew design nozzle. This way, freshly mixed adhesive with a full 10-minute working time will be dispensed onto the components to be joined.

3. The Swanstone Adhesive has a working time of ten minutes and a cure time of 1 hour. Gather all the tools needed before beginning buildup.
  - c. Have small clamps ready to position on the stacked edge until the adhesive cures.
  - d. Have several glue spread sticks, a flexible putty knife, denatured alcohol, and clean rags available for spreading the acrylic adhesive and for clean-up.
4. Using Swan's color match adhesive, place an even and generous amount on the deck surface and on the sides of the strip material that will be adhered to each other.
5. Use a spread stick to smooth out the adhesive so that it completely covers the deck area where the strips will be installed. Spread adhesive on the front, back and side edges of the strips so that no areas of the seamed joint will be seen. This promotes the best surface adhesion.



6. Position the first 2" spring clamp or similar type clamp at the edge of the countertop and then every 2-2-1/2" across the entire length. This will give just enough clamping pressure to make an inconspicuous seam.



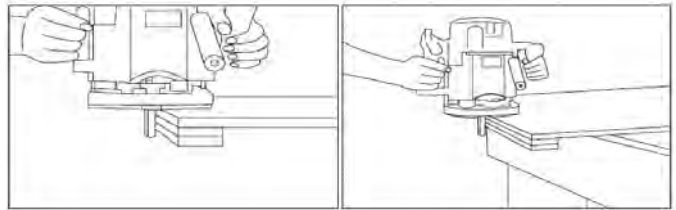


## Fabrication



**Note:** Allow adhesive to squeeze from all the seams to make sure that each joint is filled with the adhesive material. Excess adhesive on the underside edge of the build should be removed with a putty knife, denatured alcohol, and a clean cloth.

7. Allow 60 minutes for the adhesive to properly dry before the next step. Allow 1 - 1 1/2 hours for the adhesive to dry in cold climate.
8. Once all are dried, rout the front edge square to the top. This can be accomplished by either setting up a straight edge and router with template guide, or by using a flush cutter.



9. Sand out any imperfections left by the routing process, using the 3-step sanding procedure described in this manual to achieve a smooth even finish.



**Note:** These instructions include how to glue multiple buildup layers at one time. You can also work one layer at a time to keep the process cleaner.

## Swanstone Removal (disassembly)

### IMPORTANT NOTICE

Before beginning, refer to General Information section for important information on tools, hardware, and special equipment required for Swanstone fabrication.

During fabrication, if the Swanstone solid surface material components are mis-assembled, or the assembly does not fit correctly, the glued up components can be taken apart and reglued. Molded in features, such as the front edge on countertops, can not be removed.

### Sink Removal

1. Use a hammer to drive a solid shank putty knife between the sink and countertop, at the glue line.



2. Use a hammer and drive a second solid shank putty knife between the components, at a different location.



3. Remove the putty knife and drive it in between the components at a different location, working around the sink glue line. Continue to alternate driving in the putty knives until the sink and countertop separate.

### End Cap Removal

1. To remove glued on end caps, use a hammer to drive a solid shank putty knife between the end cap and the countertop, at the glue line.



2. Use a hammer and drive a second solid shank putty knife between the end cap and countertop, in a different location.



3. Remove the first putty knife and drive it in between the components at a different location. Continue to alternate driving in the putty knives until the end cap and countertop separate.



**Sanding**

1. Scrape away as much of the old adhesive as possible.



2. Use course 36 grit sandpaper to remove all traces of the old adhesive from all of the components and rough up the surface.



3. Reassemble the Swanstone components following all the instructions in the appropriate section of this manual.

**Swanstone Solid Surface Repairs**

**IMPORTANT NOTICE**

Before beginning, refer to General Information section for important information on tools, hardware, and special equipment required for Swanstone fabrication.

If Swanstone solid surface material is damaged, it can be repaired. Slight blemishes can be progressively sanded out using 120 grit, 220 grit, and 320 grit sandpaper. Wipe off dust with denatured alcohol and a clean cloth between each sanding with finer grit sandpapers.

For gouges and deep scratches, repair kits are available to Swan Dealers. Be sure to order the correct color when ordering. If possible, a sample of the actual Swanstone material can be sent to the factory for an exact color-matched.

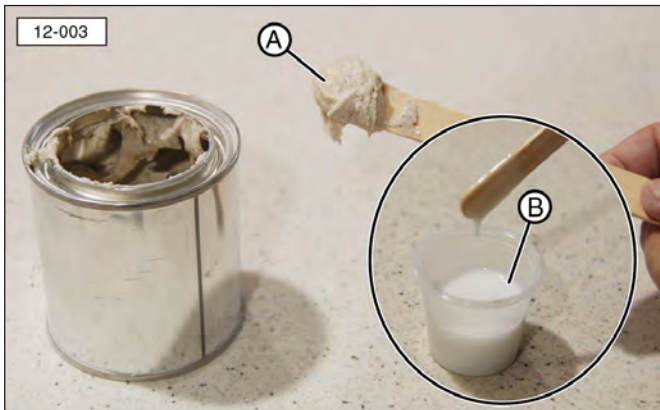
1. Use a rotary tool such as a Dremel tool and stone grinding tip to clean out the damaged area.
  - a. Use the stone grinding tip to make the edges uneven and random.
  - b. Undercut the edges so there will be no tapered (thin) areas of repair material.



2. Blow out the dust and thoroughly clean the area with denatured alcohol and a clean cloth.



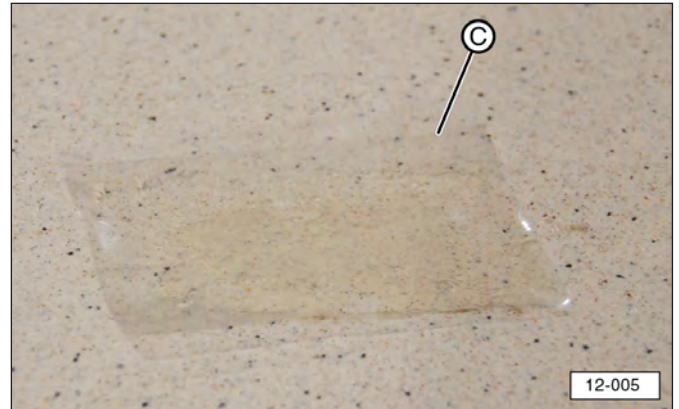
3. Follow repair kit instructions to completely mix the proper amounts of repair material (A) and hardener (B).



4. Spread the mixture onto the Swanstone surface, forcing it into the undercut areas. Overfill the opening slightly to allow for sanding and blending the repair material.



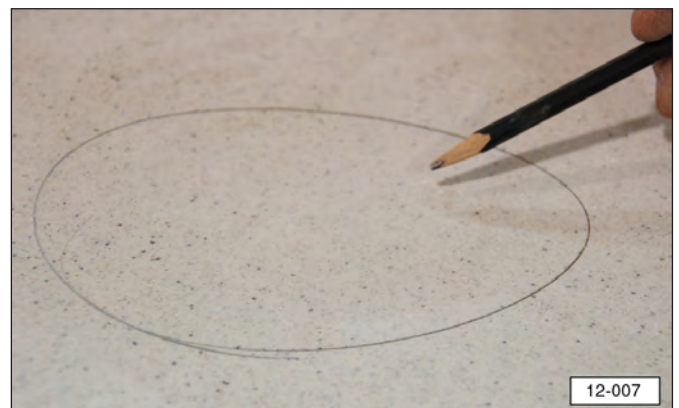
5. Immediately cover the repair mixture with a piece of heavy-duty clear plastic film (C). Use your fingers to lightly press down and even out the repair material, under the plastic film. Do not force the repair material out from under the film. Allow the repair material to cure for one hour.



6. Sand the repair using 120 grit, to remove excess material. Finish blending the area with 220 grit, and then 320 grit sandpaper. Wipe off any dust with denatured alcohol and a clean cloth between sanding with different grit sandpapers.



7. The finished repair will blend in with the surrounding area.





## Maintenance

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### Product Care and Cleaning

Swanstone solid surface products are stain and abrasion resistant; however, the finish requires reasonable care.

#### **IMPORTANT NOTICE**

Abrasive cleaners such as Comet or Ajax are recommended for Swanstone. Abrasive cleansers are NOT APPROVED for laminate countertops. ALWAYS consult your laminate supplier for cleaning guidelines on the laminate countertop surface.

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### Day-To-Day Cleanup

Wash regularly with warm water. Use a soft cloth with a mild detergent such as Handy Andy, Mr. Clean, or Lestoil. Always rinse off cleaners within five minutes of application. Scratch-free pads made of nylon, saran, or polyethylene may be used.

#### **IMPORTANT NOTICE**

NEVER use steel wool or metal scouring pads on Swanstone solid surface material. They will damage the surface.

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### Hard to Remove Stains

Use abrasive cleaners such as Ajax, Bon Ami, or Bar Keepers Friend or use an abrasive pad such as Scotch-Brite.

For the most stubborn sink stains, fill the swanstone sink about one quarter full with a 50/50 solution of bleach and water. After ten or fifteen minutes of soaking, drain the solution from the sink as you wash and rinse both sink sides and bottom.

### Marks or Discolorations

White automotive rubbing compound may be used to remove stubborn marks or discolorations.

### Scratches

Use sandpaper, starting with 120 grit (coarsest) and going to 220 grit and 320 grit until scratches disappear. Blend the area with an abrasive finishing pad (Scotch-Brite)

**Note:** For Swanstone granites, use #9 fine finishing film for the final blending. Use a paste wax to restore the color.

Use of the above products will not damage the Swanstone solid surface material. Always follow label directions. For more information, on cleaning and maintaining Swanstone products, contact the Swan representative in your area.

**Save these Installation Instructions for future reference.  
They provide important information on cleaning and  
maintenance of Swan Surfaces products.**

