

# CORIAN® SINKS & BASINS INSTALLATION BULLETIN

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This bulletin discusses the Fabrication & Installation of Corian® Solid Surface Sinks & Basins.

### OVERVIEW

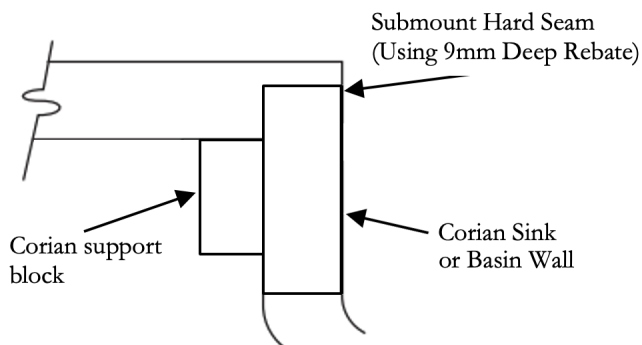
To facilitate the effective installation of high quality Corian® Sink or Basin, it is very important that the correct tools and techniques are required. **The technique required for ALL Corian® Sink and Basin installations is the deep rebate method, that is sub-mounted using Corian® adhesive.**

### TOOLS REQUIRED

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

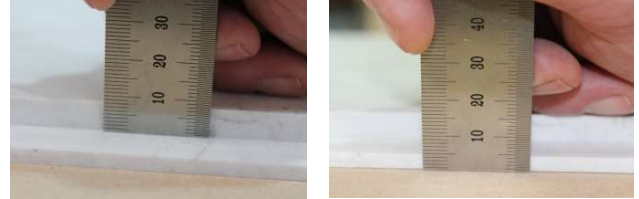
### STARTING THE JOB

We recommended a “deep rebate” technique for ALL Corian sinks and basins to ensure the best colour match. i.e. the rebate should be 9mm deep.



### 1. Deep Rebate

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



### 2. Rebate “Seat”

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



**NOTE** – cut-out needs to have **1.5mm overhanging the inside edge of the sink or basin**. This trim line of excess material (& adhesive) will be removed once the sink/basin has been hard seamed to the benchtop. Ensure an **additional 12mm** is allowed for any support straps that are attached to the sink/basin.

### 3. Preparing the Rebate

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



## 4. Pre-Preparation for Install

- a) Sand the top edge of the sink/basin using a sanding block to ensure the edge is level to allow uniform contact within rebate.
- b) Ensure top of the sink/basin is completely free of contamination or router/machine marks using appropriate grit sandpaper and cleaner. Also ensure area where the blocking will be “attached” is free of contamination.
- c) Sand all of the “blocks” on all sides.



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



## 5. Dry Fit

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



## 6. Clean using Methylated Spirits

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

## 7. Adhesive Bead.

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



- b) Ensure to apply additional adhesive to accommodate any straps that are part of sinks/basins.



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

## 8. Placing the Sink

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

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

## 9. Corian® Reinforcement Straps:

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



## 10. Clamping

Use a proper clamp suited to the sink/basin to ensure it remains in the correct position while the adhesive is curing.

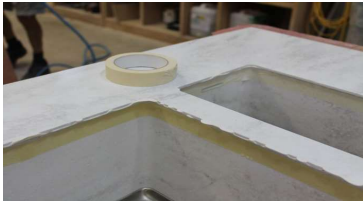
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## 11. Trimming

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



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



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



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



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

## Edge Radius

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



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

## Finished Corian® Sink example



## Finished Corian® Basin example



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