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**Durasein**  
Profile Bits for  
Undermount Bowls



# Durasein

## Fabrication and Installation

### Bowl Mounting

BULLETIN NO.  
Bowl Mounting\_0525

TECH INFO  
Bowl Mounting  
Date

#### Introduction

In this bulletin, methods are provided for mounting sinks and lavatories to a Durasein® Solid Surface countertop. The typical methods are 'hard' seam and 'soft' seam. These two methods are used in mounting the following types of bowls:

- Seamed Undermount
- Stainless Steel Undermount
- Undermount Generic
- Cast Iron

#### 'Hard' Seam Undermount Installation

Seaming a solid surface bowl to the underside of a Durasein® Solid Surface countertop

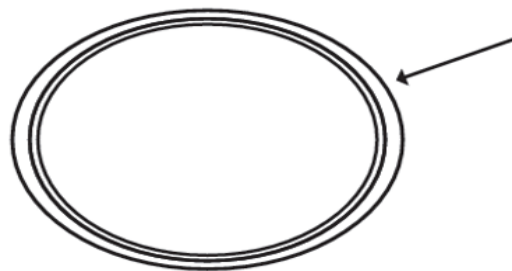
#### Positioning

- Turn the Durasein® Solid Surface sheet back-side up on a well-supported surface. Position the bowl on the sheet. Be sure to allow for the front rail of the cabinet and for plumbing considerations.
- Draw a pencil line on the sheet around the perimeter of the bowl (or clamp provided template into position) while the sheet is positioned back-side up. Drill a 1"- 2" (25 - 50 mm) pilot hole, with a hole-saw or plunge router, in the sheet in line with the drain hole of the bowl.
- Mark the location for 4 positioning blocks as shown. These blocks can be scrap pieces of wood or solid surface approximately 1"x 1 1/2" x 1/2" (25 mm x 38 mm x 13 mm).

- Fasten the blocks to the back of the sheet using hot melt adhesive or other suitable adhesive. Leave a slight gap between the block and the sink to allow the sink to be placed without scraping the block.
- Clean and, if necessary, sand the underside of the sheet where the bowl is to be bonded. This removes factory sanding lines or scuff marks.
- Clean and, if necessary, sand the top flange of the bowl. Do not round over or nick the inside edge of the rim.

#### Bonding

Remove the bowl and clean the sheet bonding area and the bowl flange with denatured alcohol. Apply Durasein® Surfacing Adhesive to the bowl flange.



Apply carefully and use a healthy bead of adhesive to assure 100% coverage. (Refer to Approved Solvents for Surface Preparation of Durasein® Solid Surface During Fabrication)

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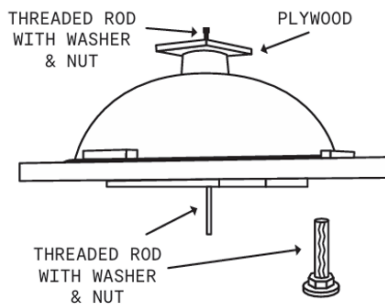
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#### Clamping

There are several different methods when it comes to clamping the bowl or sink in place. A few common methods are:

Use an all-thread rod, two blocks of plywood, and a wing nut to clamp the bowl to the sheet. Tighten the clamp until the seam adhesive squeezes out evenly. Allow the seam adhesive to harden.



A similar clamp can also be constructed using standard pipe clamp hardware or sliding bar clamp. Do not over tighten. This will starve the seam of adhesive which can lead to seam failure. It could also build stress into the bowl. Use only hand pressure to tighten the clamp.



Bags of sand or a very dense granular material can be placed on top of the drain providing an even force on the bowl flange. Be sure the sheet is properly supported so it will not bow or flex thus not allowing the bowl to properly seat.

Deep jawed clamps such as mechanics' vice-grip pliers can be strategically placed around the perimeter of the bowl flange.

#### Vacuum plug clamping system

- A specially designed vacuum plug is installed in the drain hole after the bowl with adhesive has been positioned.
- The vacuum is created by either a vacuum pump or a venturi built into the unit.



- This method is performed prior to drilling with the hole saw into the sheet.

**Note:** Whatever clamping method used, always keep in mind the amount of labor involved and do everything possible to minimize your labor costs.



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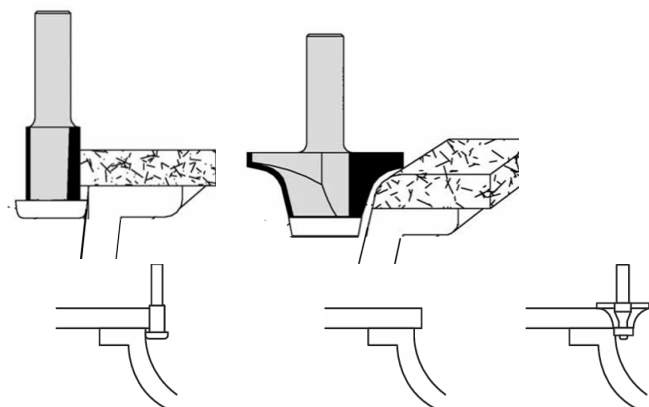
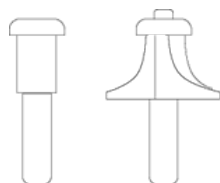
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#### Shaping the Edge

Turn the top over and cut the sheet material from the center of the bowl area with a special flush-cut router bit with an oversized nylon bearing. Start from the pilot hole and rout clockwise around the bowl. Hold the cutout steady as it separates from the top to avoid damage to the edge. Select the desired bowl profile bit and rout clockwise around the bowl. Sand to the desired finish.

The flush cut bit with oversized bearing removes most of the sheet material. The profile bit cuts the overhang flush and creates a profile.



Flush Cut with Oversized Bearing

Flush Cut showing Overhang

Profile Bit Cut

#### 'Soft' Seam Undermount Installation

Stainless Steel Undermount

Generic Undermount

Cast Iron Undermount

Joining an undermount bowl to the underside of a Durasein® Solid Surface countertop

Undermount bowls generally follow the same process as the 'hard' seam undermount bowl with the following exceptions:

1. The bowl is usually a different material than the countertop.
2. The cutout needs to be cut and finished prior to the installation of the bowl.
3. The cutout needs to be sanded to the same finish as the countertop.
4. The cutout sometimes has a routed profile.
5. The bowl utilizes a flexible adhesive such as 100% silicone adhesive to bond the bowl to the countertop. (Allow silicone adhesive to cure overnight prior to installing the countertop or installing the plumbing) connections.
6. Mechanical fasteners used to clamp the bowl to the top



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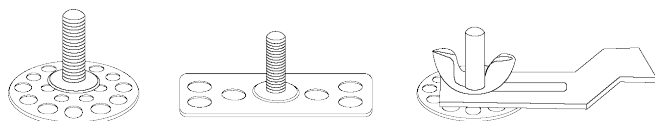
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#### Positioning

- Lay out the position of the bowl on the sheet. Be sure to allow for the front rail of the cabinet and for plumbing considerations. This step can be done with either side of the sheet facing up.
- Cut the bowl opening using a router and template, CNC router or other appropriate routing machinery.
- Profile the finished cutout with appropriate router bit. Be sure the top and bottom edges of the cutout are sanded smooth to eliminate stress risers and to achieve the desired aesthetic.
- Turn the solid surface sheet back-side up on a well-supported surface. Position the bowl on the sheet. Layout the locations for appropriate mechanical fasteners. Positioning blocks, if desired, can also be put in place at this time.

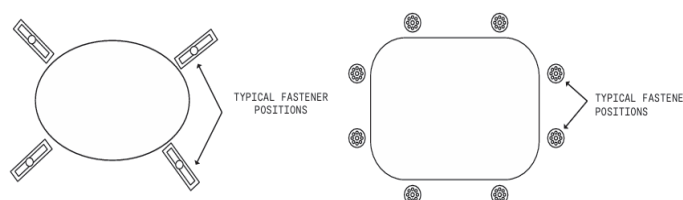
#### Typical Fasteners

Fasteners with threaded post fastener showing clip and wing nut



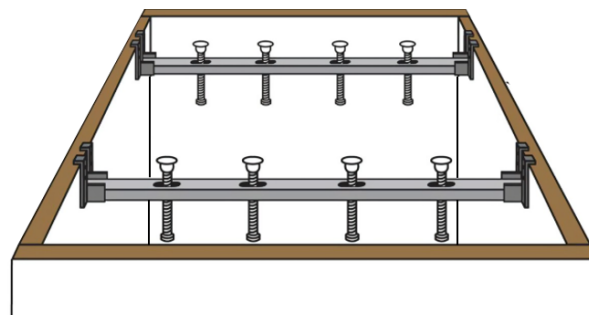
Mechanical fasteners are recommended for undermounting most bowls to a Durasein® Solid Surface top. The most common method is adhering a device to the top using Durasein® Surfacing Adhesive seam adhesive or another appropriate type of adhesive engineered specifically for this purpose. Then a fastening clip is connected.

The following drawings show typical locations for mechanical fasteners



Cast iron Undermount bowls are very heavy and require additional support. There are several styles of support bars or cradles on the market. When installed properly, these devices support the weight of the bowl and water when in use.

#### Example of Undermount Sink Cradle Support





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#### Bonding

- Remove the bowl and clean the sheet bonding area and the bowl flange with denatured alcohol and a clean, white cloth. Allow to dry.
- Install the mechanical fasteners using Durasein® Surfacing Adhesive seam adhesive or an appropriate adhesive engineered specifically for this purpose. Allow to cure completely.
- Use 100% silicone adhesive to bond the bowl to the countertop. Apply carefully and use a healthy bead of adhesive to assure optimal coverage.
- Put the bowl in place on the countertop being sure the reveal is uniform around the perimeter of the bowl.
- Install the fastening clips and tighten. Clean any unwanted adhesive squeeze-out on the inside of the bowl.

#### Top Mount Installation

Joining a Top Mount Bowl to a Durasein® Solid Surface countertop

Most top mount sinks are simply adhered in place with 100% silicone flexible adhesive or clamped using a fastening system supplied by the manufacturer. Always follow the manufacturer's instructions.

#### Positioning

- Lay out the position of the bowl on the sheet. Be sure to allow for the front rail of the cabinet and for plumbing considerations. This step can be done with either side of the sheet facing up. When available, use the manufacturer's template for laying out the cutout.
- Cut the bowl opening using a router and template, CNC router or other appropriate routing machinery. Do not use a jigsaw.
- Be sure the top and bottom edges of the cutout are sanded smooth to eliminate stress risers.

#### Bonding

- Clean the sheet bonding area and the bowl flange with denatured alcohol and a clean, white cloth. Allow to dry.
- Follow the sink manufacturer's instructions for installation.
- Use 100% silicone adhesive to bond the bowl to the countertop. Apply carefully and use a healthy bead of adhesive to assure optimal coverage.
- Put the bowl in place on the countertop being sure the position is uniform around the perimeter of the bowl.
- If required, install the fastening clips and tighten. Clean any unwanted adhesive squeeze-out.

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#### Vessel Bowl

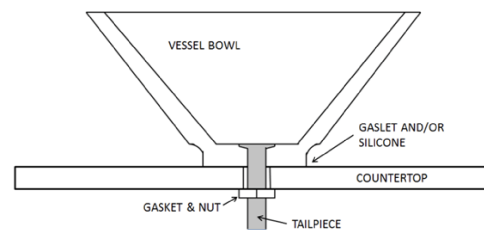
Joining a Vessel Bowl on a Durasein® Solid Surface top

##### Positioning

- Lay out the position of the bowl on the sheet. Be sure to allow for the front rail of the cabinet and for plumbing considerations. This step can be done with either side of the sheet facing up. When available, use the manufacturer's template for laying out the cutout.
- Cut the tailpiece opening using a hole saw or router and template. Do not use spade bits or auger bits.
- Be sure the top and bottom edges of the cutout are sanded smooth to eliminate stress risers.

##### Bonding

- Clean the sheet bonding area and the bowl base with denatured alcohol and a clean, white cloth. Allow to dry.
- Follow the sink manufacturer's installation instructions.
- Use 100% silicone adhesive to bond the bowl to the countertop. Apply carefully and use a healthy bead of adhesive to assure optimal coverage.
- Put the bowl in place on the countertop being sure the position is uniform around the perimeter of the bowl.
- Install the drain and tailpiece hardware and tighten.
- Clean any unwanted adhesive squeeze-out.



##### Helpful Hints:

Use Durasein® Surfacing Adhesive for adhering undermount solid surface bowls.

Referenced Documents: Approved Solvents for Surface Preparation of Durasein® Solid Surface During Fabrication



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