



INTEGRATING AN UNDERMOUNT DUPONT™ CORIAN® SINK OR BOWL TO A DUPONT™ ZODIAQ® COUNTERTOP OR VANITY TOP

INTRODUCTION

This bulletin discusses installing DuPont™ Corian® solid surface sinks and lavatories with DuPont™ Zodiaq® quartz surface tops with a smooth transition between top and sink or lavatory.

OVERVIEW

This Technical Bulletin describes recommended fabrication techniques that can be used to integrate an undermount Corian® sink or lavatory with a Zodiaq® countertop or vanity top using DuPont™ Joint Adhesive. This is an allowed exception to the general prohibition of bonding dissimilar materials with DuPont™ Joint Adhesive. Additional details on basic techniques can be found in *DuPont™ Corian® Solid Surface Fabrication/Installation Fundamentals – Sinks and Lavatories* (K-25296)

An assumption is that these techniques will be performed in the fabrication shop and not on the jobsite therefore, careful planning is needed when assessing the transportation and installation of the finished job. Also, in consideration of the increased weight of certain countertop sections with regard to the sink having been installed prior to installation on the jobsite, it is likely additional seams will be needed to aid in transporting the material to the jobsite. Recognize that this type of installation will not be feasible in some design applications. A discussion with the consumer may need to occur to discuss these items prior to installation.

A. SAFETY

Always wear proper personal protective safety equipment when handling, transporting, cutting, grinding, sanding, or polishing Corian® and Zodiaq® surfaces. Personal protective equipment includes, but is not limited to, gloves, safety shoes, respiratory protection and protective eyewear. Proper care should be taken when lifting Corian® sheet, Zodiaq® slabs and Corian® bowls as these products are heavy and awkward to lift.

B. FABRICATION RECOMMENDATIONS

The best method for fabricating the sink or bowl opening in the Zodiaq® top will be determined by the type of sink

or bowl chosen and the equipment and tooling available to perform this step. Two methods are discussed here. The sink or bowl must be fastened to the rough factory backside surface. Do not polish the area where the sink or bowl will be attached.

Method A – Polishing the Zodiaq® cutout back to the Corian® sink

1. Fabricate the cutout for the Corian® sink or bowl in the Zodiaq® top. Allow for $\frac{1}{32}$ " (0.8 mm) less in the Zodiaq® cutout than the inside flange measurement of the Corian® sink or bowl. This adjustment allows for the edge polishing of the Zodiaq® cutout.
2. Smooth any rough edges around the cutout with a medium sandpaper or 800+ grit diamond hand pad to remove any chipping from cutting.

If making the sink or bowl cut using a CNC router, most CNC tooling will provide an adequate cut and touch up may not be necessary.

3. Make sure the backside area within a 2" (51 mm) width around the cutout is somewhat flat and true. This is where the sink or bowl will be adhered. Grind, flat and true, the back side of the Zodiaq® top with a medium grit (approximately 320) diamond pad, cup wheel, or similar tool to aid adhesion.
4. Place the countertop backside up. Place on a soft material to protect the finished surface.
5. Clean the area to be adhered with acetone or alcohol. Apply DuPont™ Joint Adhesive to the sink or bowl flange. Attach the sink or bowl to the Zodiaq® back surface, carefully centering to allow for the $\frac{1}{32}$ " adjustment. Apply sink clamps to hold the sink or bowl in position during the curing process.
6. Immediately remove excess DuPont™ Joint Adhesive and allow remaining adhesive to cure. Secure sink or bowl with mounting clips as described in document Z-1, *Manufacturing and Installation Requirements for DuPont Zodiaq® Quartz Surfaces* (Technical Bulletin Z-2006-002).
7. After adhesive has properly cured, complete finishing of the Zodiaq® cutout edge on the inside of the sink or bowl using standard Zodiaq® polishing techniques.

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The polishing process may overlap onto the Corian® sink or bowl slightly. Care should be taken to avoid damage to the Corian® sink or bowl with the more aggressive diamond pads.

8. Mask off the polished Zodiac® edge with masking tape. Sand the Corian® sink or bowl until it is flush with the Zodiac® cutout (use P100, P180 and P230). Finish the Corian® sink or bowl to the proper matte finish using a ScotchBrite™ pad. Avoid damaging the polished Zodiac® edge.

Method B – Sanding the Corian® sink or bowl back to the finished Zodiac® cutout

1. Fabricate the cutout for the Corian® sink or bowl in the Zodiac® top. Allow for an additional $\frac{1}{32}$ " (0.8 mm) in the Zodiac® cutout than the inside flange measurement of the Corian® sink or bowl. This adjustment allows for sanding the Corian® sink or bowl flush to the Zodiac® edge which will be discussed in a later step.
2. Smooth any rough edges around the cutout with a medium sandpaper or 800+ grit diamond hand pad to remove any chipping. Note: If making the sink or bowl cut using a CNC router, most CNC tooling will provide an adequate cut and touch up may not be necessary.
3. Complete finishing of the Zodiac® cutout edge on the inside of the sink or bowl using standard Zodiac® polishing techniques.
4. Inspect and assure the backside area within a 2" (51 mm) width around the cutout is somewhat flat and true. This is where the sink or bowl will be adhered. If needed, grind, flat and true, the back side of the Zodiac® top with a medium grit diamond pad, cup wheel or similar tool.
5. Place the countertop backside up. Place on a soft material to protect the finished surface
6. Clean the area to be adhered with acetone or alcohol. Apply DuPont™ Joint Adhesive to the sink or bowl flange. Attach the sink or bowl to the Zodiac® top, carefully centering, to allow for the $\frac{1}{32}$ " (0.8 mm) adjustment. Apply sink clamps to hold sink or bowl in position during the curing process.
7. Immediately remove excess DuPont™ Joint Adhesive and allow remaining adhesive to cure. Secure sink or bowl with mounting clips as described in document Z-1 (Technical Bulletin Z-2006-002).
8. Mask off the polished Zodiac® edge with masking tape. Sand the Corian® sink or bowl until it is flush with the Zodiac® cutout (use P100, P180 and P230). Finish the Corian® sink or bowl to the proper matte finish using a ScotchBrite™ pad. Avoid damaging the polished Zodiac® edge.

C. TRANSPORTING TO THE JOBSITE

Careful planning and extra care should be taken in transporting to the jobsite due to the attached sink or lavatory. Recognize that additional weight from the sink or lavatory will affect weight and maneuverability of the top as it is being transported. A cutout carrier or similar device may be needed to add additional support and help avoid damaging the finished top during transportation and installation.

D. INSTALLATION

For sink installations, additional support must be added inside the cabinet base in the form of sink brackets, sink setters or cradles to aid in supplying additional support for the sink or bowl.

E. REFERENCES

Z-1, *Manufacturing and Installation Requirements for DuPont Zodiac® Quartz Surfaces* (Technical Bulletin Z-2006-002)

DuPont™ Corian® Solid Surface Fabrication/Installation Fundamentals – Sinks and Lavatories (K-25296)

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