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General Safety

Safety is a critical concern for any shop and key part of a successful business. The following safety rules should be incorporated into your safety program to help prevent an accident. Safety training, knowledge, product use and environment is the responsibility of the facility owner and the shop employees.

CAUTION: Always follow product, equipment and/or tools manufacturer's recommendations and instructions carefully.

- Read directions carefully before installing Wilsonart® Sinks.
- Read instructions manual before operating the different tools.
- Keep all guards in place and in working order.
- Insure all tools are properly grounded. Never remove the third prong.
- Keep work area clean, uncluttered and well lit.
- Don't use electric power tools in a damp or wet work area.
- Keep visitors at a safe distance from the work area.
- Use the right tools. Don't force a tool or attachment to do a job it was not designed to perform.
- Always use safety glasses or approved eye protection and/or face shield, ear/noise protectors and safety shoes. (FIG. 1A & 1B)
- Wear the proper apparel, no loose clothing or jewelry.
- Secure all work with the proper clamp or vice to a stable work surface.
- Don't overreach. Keep proper footing and balance at all times.
- Maintain tools in top condition. Disconnect tools before servicing and when changing accessories such as blades, bits, cutters, etc.
- Keep and use denatured alcohol, adhesives and materials in a safe, ventilated place.
- Dust collection should be utilized when cutting, routing and sanding. Tools should be used with dust collection at all times.

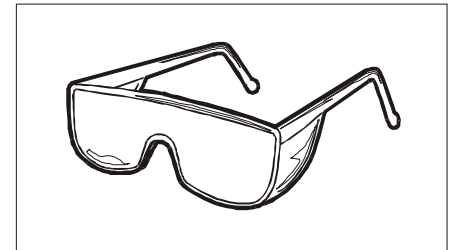


Figure 1A



Figure 1B

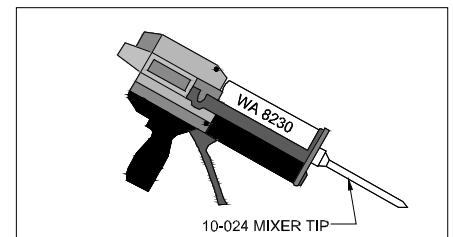


Figure 1C

Wilsonart® 8230 - LS Sink Seam Adhesive

- Wilsonart 8230 - LS Sink Seam Adhesive is for professional use only. Always follow the manufacturer's recommendations and instructions carefully. Recommended shop temperature for bonding is 65°F or warmer. (FIG. 1C)

Warning: This seam kit contains the following hazardous ingredients: Methyl Methacrylate, Benzoyl Peroxide, and Dibutyl Pathlate. Avoid prolonged breathing of vapors. Use only in a well ventilated area. Keep out of reach of children. Eye protection is always recommended. Motors and other equipment used in the fabrication and installation process must be UL labeled explosion proof.

For further information refer to Wilsonart 8230 Sink Seam Adhesive Material Safety Data Sheet available on request. Contact your local distributor or call 1-800-433-3222 for immediate response to a question concerning Wilsonart 8230 Sink Seam Adhesive.

Storage and Inspection

- Store Wilsonart® Sinks indoors in their original shipping boxes until ready to install.
- Wilsonart 8230 - LS Sink Seam Adhesive - refrigerated storage required. Store in tightly closed containers in cool, dry, well ventilated place between 40° F (4.4° C) and 60° F (15.4° C) preferably at 50° F (9.9° C). **Do Not Freeze**

Wilsonart Sinks Inspection:

- Every effort has been made to supply high quality materials free of defects. You must conduct a final (precutting) inspection to continue the quality control process prior to fabrication or the warranty may be void.
- Inspect sink for imperfections, verify color as necessary.
- Verify the thickness (top to bottom) of the sink flange. It needs to be;
 - $1\frac{1}{16}$ " or less for the Wilsonart postform method.
 - $\frac{3}{4}$ " or less for other methods (FIG. 2A)
- If thicker than listed above, make a jig to trim the bottom of the sink flange. (FIG. 2B)
 - Use a flat sheet of particleboard or MDF approximately $1\frac{1}{8}$ " wider than the sink.
 - Apply 1" wide by $\frac{5}{8}$ " or $\frac{3}{4}$ " strips of particleboard or MDF even with the outer perimeter of the flat sheet.
- Place on a well supported work surface and with a router and a top bearing flush trim bit, machine the excess flange. (FIG. 2C)

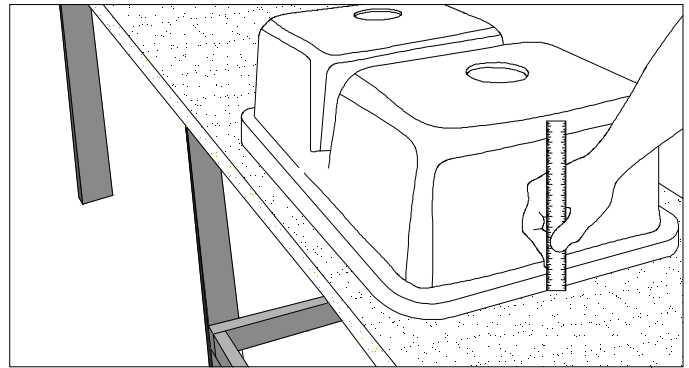


Figure 2A

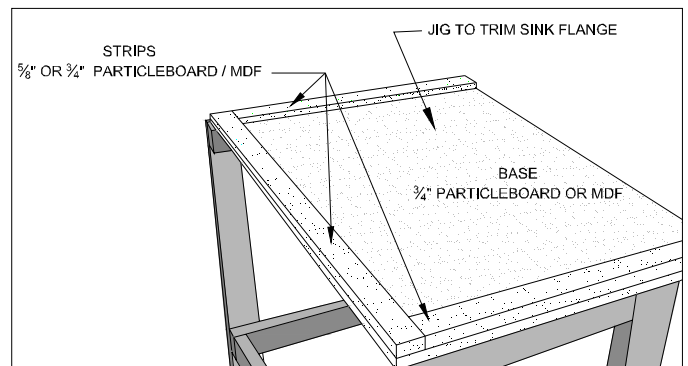


Figure 2B

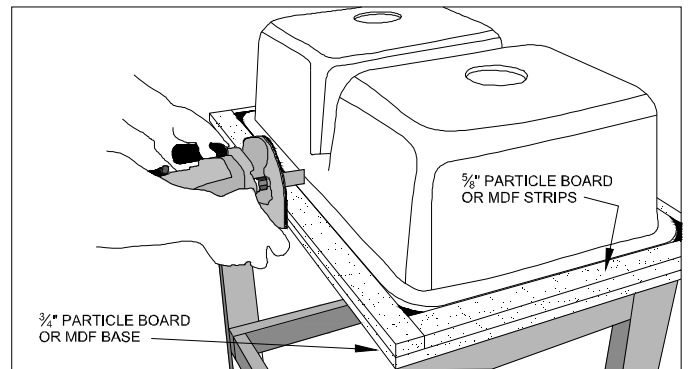


Figure 2C

Suggested Tool List

- The following suggested tool list is only a minimum requirement for professional and successful Wilsonart® Sink installation in a laminate top.
- Various woodworking and specialized solid surface fabrication tools are available in the market today.

Hand & Power Tools

- Routers (FIG. 3A)
 - 3¹/₄ HP plunge base w/1/2" (13mm) collet
 - 2¹/₂ HP plunge or set base
 - Laminate tilt base w/1/4" (6mm) collet
- General Router Bits (FIG. 3B)
 - 1¹/₈" (28.6mm) Top bearing flush trim bit
 - 1" (25.4mm) straight cut bit
 - 3/4" (19mm) straight cut bit
 - 1/4" (6mm) Bottom bearing flush trim bit (velvet touch guide bearing suggested)
- Template Guide (FIG. 3B)
 - 1¹/₄" (31.75mm) Template guide
- HD Sink bits (FIG. 3B)
 - H1006782 - 7/8" (19mm) Flush trim bit
 - H1006783 - Beveled profile bit
 - H1006784 - Replacement bearings
- Sanders (FIG. 3C)
 - Random Orbital
 - Dust collection system (suggested)
 - Sanding Disks (Micron)
 - Scotch-Brite® pads
- Laminate file (FIG. 3C)
- Seam Kit dispensing gun (FIG. 3D)
 - 10-018 Mixer tip or
 - 10-024 Mixer tip

WARNING: When using electrical tools, please use caution to prevent electrical shock.

CAUTION: Always follow product, equipment and/or tool manufacturer's recommendations and instructions carefully.

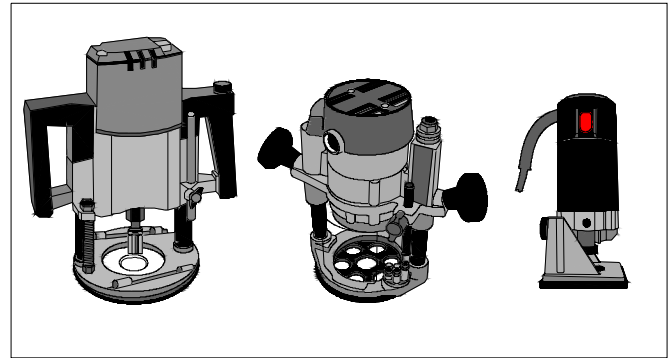


Figure 3A

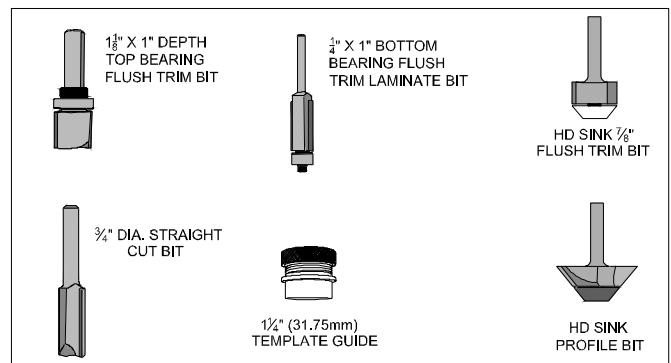


Figure 3B

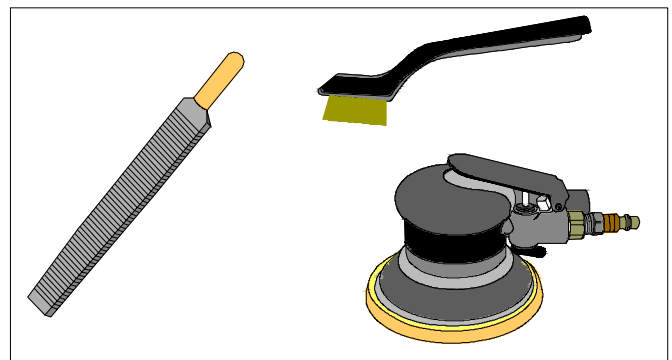


Figure 3C

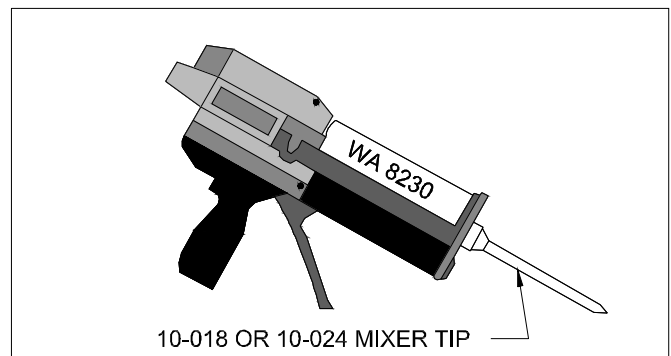


Figure 3D

Bonding Preparation

- Do not use lacquer thinner, acetone or other solvents.
- Colored or printed towels will contaminate the seam material and cause a weak or stained bond line.
- For stubborn residue use a Scotch-Brite® pad and denatured alcohol.

Prior to Bonding

Cure time of WA 8230 - LS Sink Seam Adhesive may vary due to temperature and humidity.

- Apply small bead of WA 8230 - LS Sink Seam Adhesive to scrap laminate to verify cure time.
- Clean sink flange and/or sink ring with denatured alcohol and a clean white cloth. (FIG. 4A & 4B)
- Also clean the area of the laminate where the sink or sink ring will be bonded. (FIG. 4C)
 - Do not saturate laminate with denatured alcohol.
- Prepare the WA8230 - LS Sink Seam Adhesive to bond the sink to the laminate.
- Insure proper mixture of adhesive and catalyst with the following procedures. (FIG. 4D)
 - With the cartridge in dispensing gun, purge cartridge by slightly pulling handle until both adhesive and catalyst are coming out of the tube.
 - Apply mixer tip (10-018 or 10-024) to cartridge and purge tip with one complete pull of the handle.
- Recommended shop temperature for bonding is 65°F or warmer.

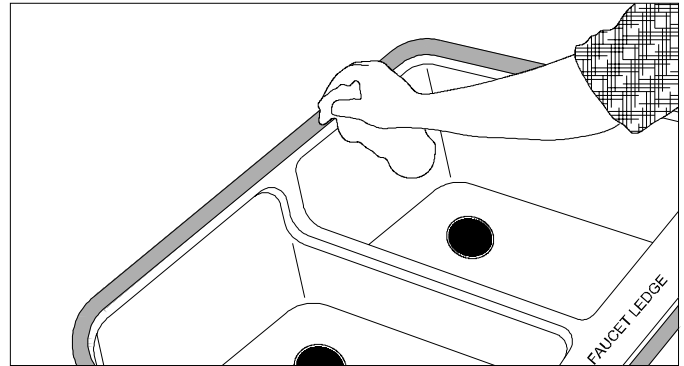


Figure 4A

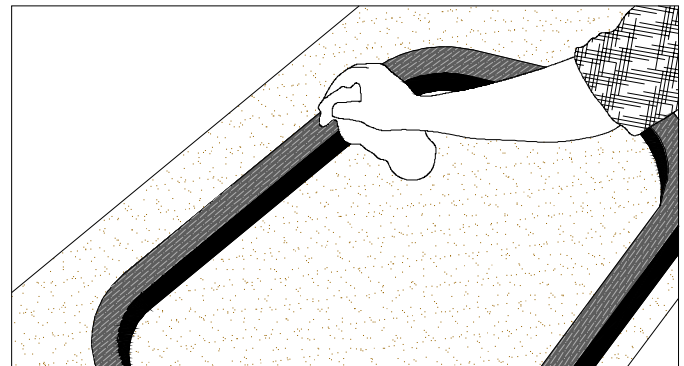


Figure 4B

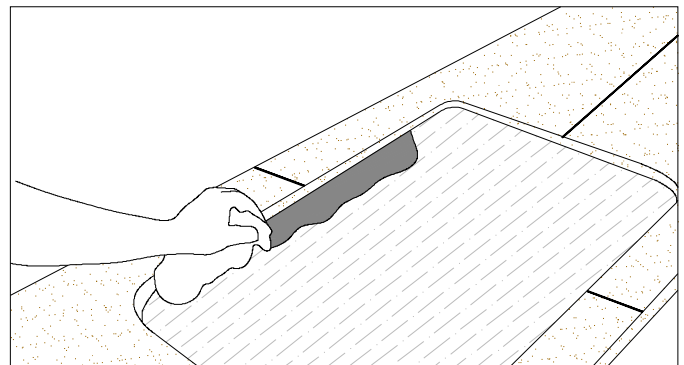


Figure 4C

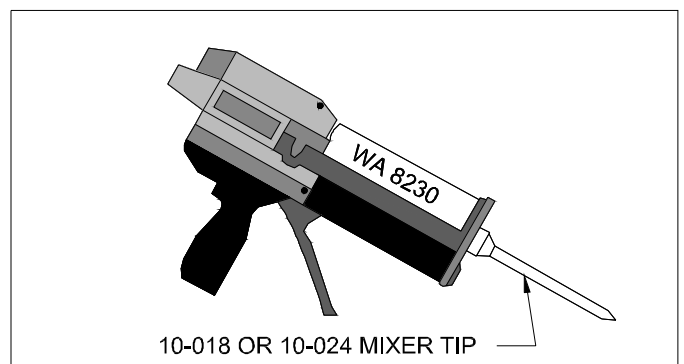


Figure 4D

Direct To Laminate Method

The following process was developed to install a Wilsonart® HD® sink in a postform or pre-bonded laminate top.

Prepare the Substrate

- Locate where sink is to be installed on the substrate and draw reference lines. (FIG. 5A)
- Make a two part template to route the substrate for your sink cutout in the pre-bonded laminate countertop. (FIG. 5B)
 - See page 24 for instructions to make a two part template.
- Align the cross hairs of the two part undermount sink template with the reference lines on substrate.
 - Fasten securely to substrate with properly sized screws.
- Index a 3¹/₄ HP or 2¹/₂ HP plunge router with a 1¹/₈" x 1" top bearing flush trim router bit to remove the substrate. (FIG. 5C)
 - Set the cutting depth to route within 1/32" of the laminate.
 - Adjust depth to include the thickness of the template and the countertop substrate.
 - Do not set routing depth to reach the laminate.
 - Substrate and adhesive thickness variation may cause damage to the laminate if routing depth is set to deep.
- Route along templates in the direction indicated.
 - Remove all substrate for this routing depth between the two part templates. (FIG. 5D)
- Once this step is completed there should be 1/32" of substrate remaining.
- Remove the template from the substrate.

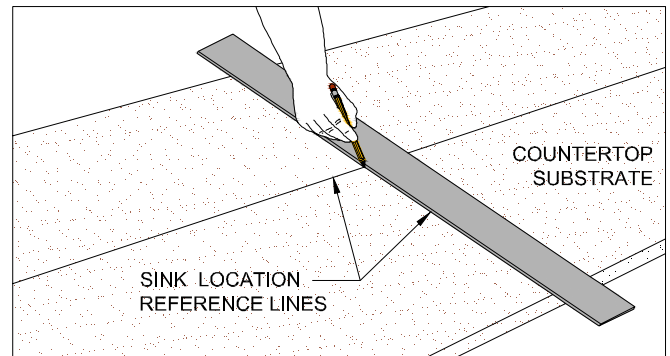


Figure 5A

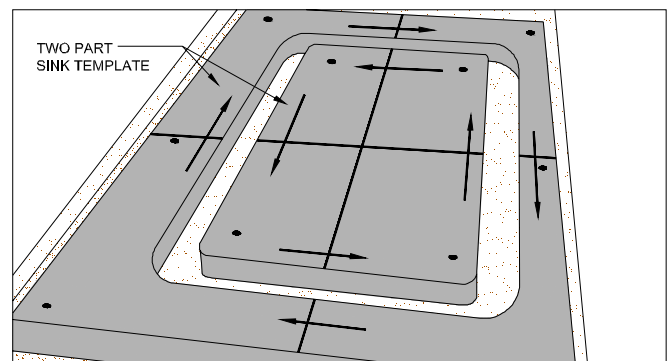


Figure 5B

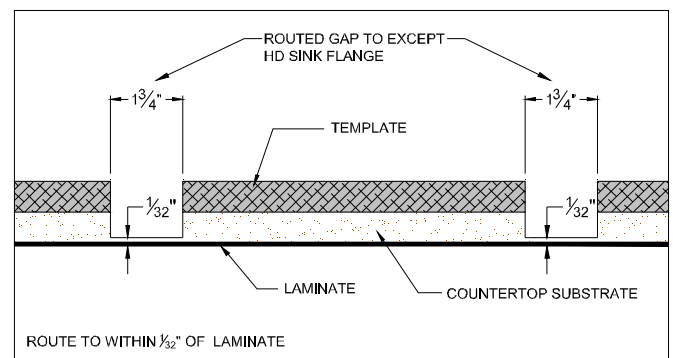


Figure 5C

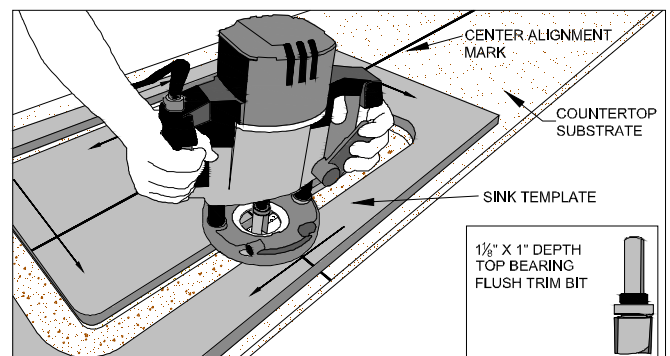


Figure 5D

Direct To Laminate Method (cont')

- Using a sharp chisel remove the remaining substrate and adhesive layer from the back of the laminate.
 - Keep chisel flat, beveled side up, so as not to damage laminate. (FIG. 6A)
- Using a wire brush remove any remaining substrate or adhesive residue from the exposed laminate. Blow off all residue with compressed air. (FIG. 6B)
 - Do not use adhesive solvents which may saturate the substrate or degrade the bond between the laminate and the substrate.
- Drill a $\frac{3}{8}$ " or larger pilot hole through the substrate at the inside of the sink cutout to insert a laminate trim bit to cutout center piece. (FIG. 6C)
- Turn top over so laminate is facing up.

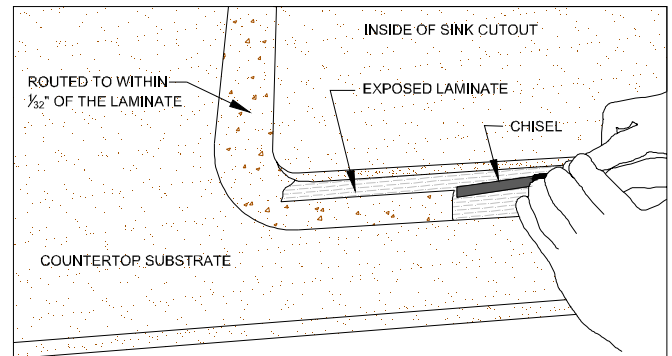


Figure 6A

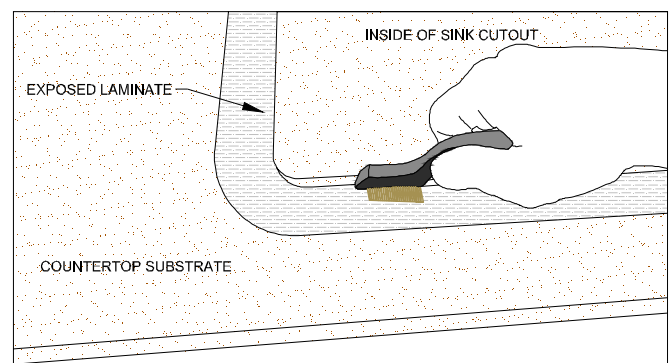


Figure 6B

Center Cutout Removal

- Use a laminate trim router with a $\frac{3}{8}$ " bottom bearing flush trim bit, route around the inside of the sink cutout. (FIG. 6D)
 - Remember to route to the inside of the cutout.
 - This step will remove the center section of the cutout.
- Flip top back over so laminate is facing down

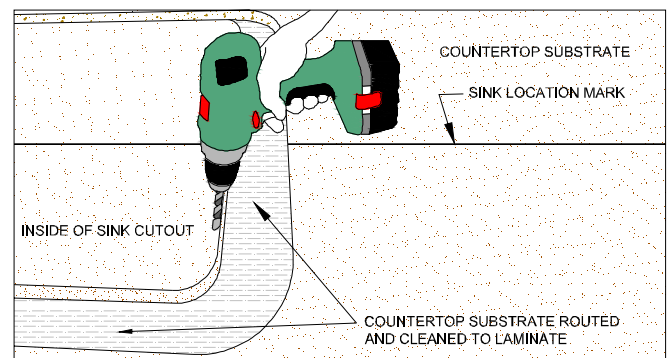


Figure 6C

Dry Fit Sink

- Place sink in cutout
 - Insure sink flange does not extend above substrate.
 - Do not exceed a $\frac{1}{4}$ " gap between the sink flange and the substrate.
- If not flush with substrate;
 - Re-trim as directed on page 2 of this manual or
 - Use belt sander or surface leveler to remove excess flange.

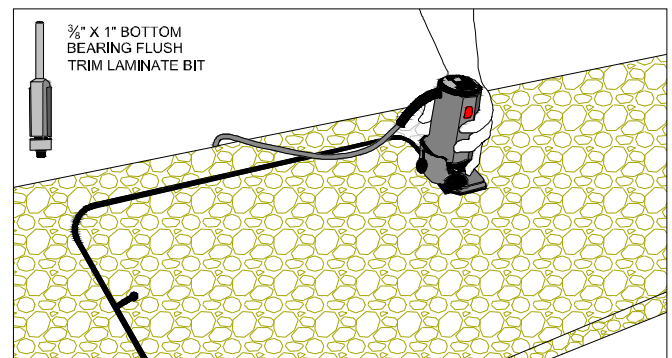


Figure 6D

Direct To Laminate Method (cont')

Bonding Process

- Clean the sink flange and exposed laminate with denatured alcohol and a clean white cloth. (FIG. 7A)
 - See Section B page 4 for procedures and precautions.
- Prepare the WA8230 - LS Sink Seam Adhesive to bond the sink to the laminate.
 - See Section B page 4 for procedures and precautions.
- Apply the WA8230 - LS Sink Seam Adhesive to the HD sink flange. (FIG. 7B)
 - Apply one $\frac{3}{16}$ " bead of adhesive $\frac{1}{16}$ " from the inside edge of sink flange.
- Place the sink in the cutout and move sink to spread the seam kit and apply firm pressure for 5 to 10 seconds.
 - No weight is necessary.
- Align sink with register marks on flange and reference lines on the substrates.
- Fill gap between sink rim and substrate with 100% silicone. (FIG. 7C)
- Allow the seam kit to cure completely before moving or routing.
- Place $\frac{3}{4}$ " thick wood support strips around entire perimeter of sink flange. (FIG. 7D)
 - Minimum 2" wide strips are required.
 - Strips should cover only the area of the flange that was previously trimmed.
 - In the front and back of the sink, they should extend over the substrate to cover the entire area inside the cabinet base.
 - Secure with wood glue and properly sized screw or staples.

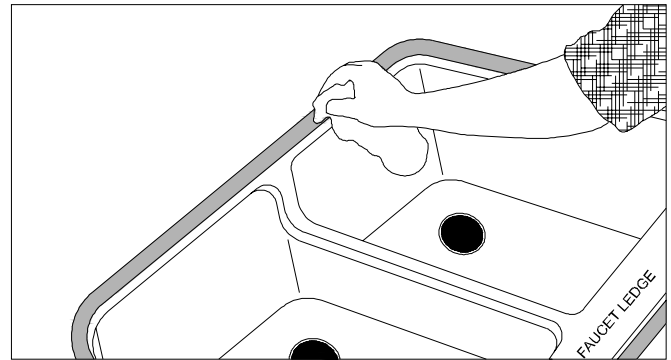


Figure 7A

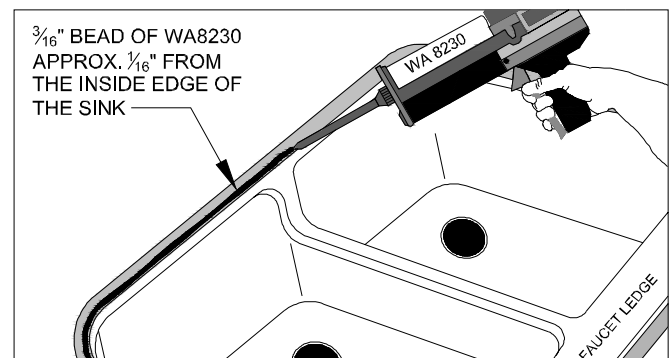


Figure 7B

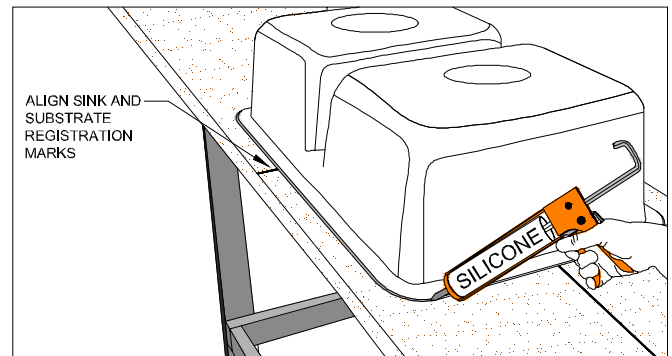


Figure 7C

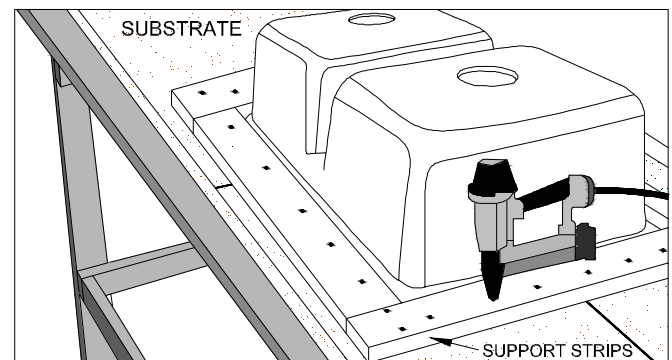


Figure 7D

Direct To Laminate Method (cont')

Routing & Profiling the HD Sink

Routing Precautions

- Set depth of bit so that it does not come in contact with the sink plumbing ledge.
- Using a variable speed router set at 16,000 to 18,000 rpm will prolong the life of the carbide router bits.
- Clean and lubricate HD bits after each use

Countertop without an attached backsplash

- Adjust the laminate tilt-base trim router with a $\frac{3}{8}$ " bottom bearing flush trim bit. (FIG. 8A)
 - Set the angle of the base at approximately 45° to 48° .
 - Set bearing to run along bevel of sink.
- Route around the inside of the sink. (FIG. 8A)
 - Remember to twist the router base in corners to properly follow the radius and eliminate router chatter.

Countertops with an attached backsplash (postform top)

Due to limited space between the sink and the backsplash Wilsonart suggests the following procedures.

- Use a laminate trim router with the HD bottom bearing flush trim bit and flush trim the overhanging laminate. (FIG. 8B)
- Use a laminate trim router with the HD sink profile bit, profile the edge of the laminate with the angle of the sink. (FIG. 8B)

Finishing

- Sand the edge of the laminate and sink wall with a random orbital palm sander. Use a 150 to 220 grit sandpaper. (FIG. 8C)
 - Use only light to medium pressure when sanding.
 - Keep sander at same angle as sink wall.
 - Keep sander moving to minimize the chance of dips or over sanding one area.
- Finish sanded area with a gray 3M® Scotch-Brite™ pad.
 - Use only light to medium pressure in a circular motion.
- Soften the sharp edge of the laminate with a laminate file.
 - Lightly file at a 45° angle. (FIG. 8D)

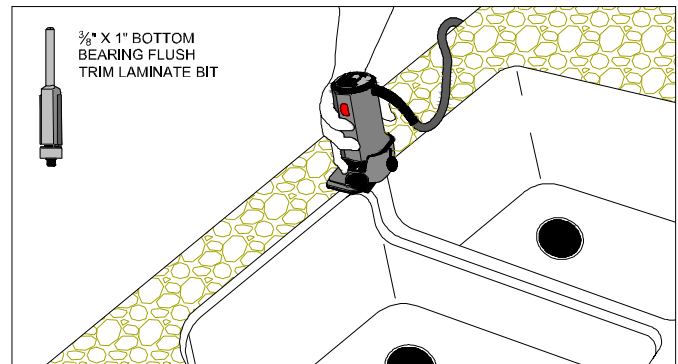


Figure 8A

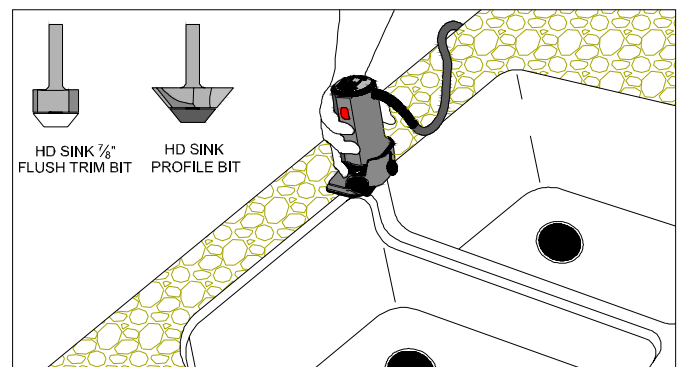


Figure 8B

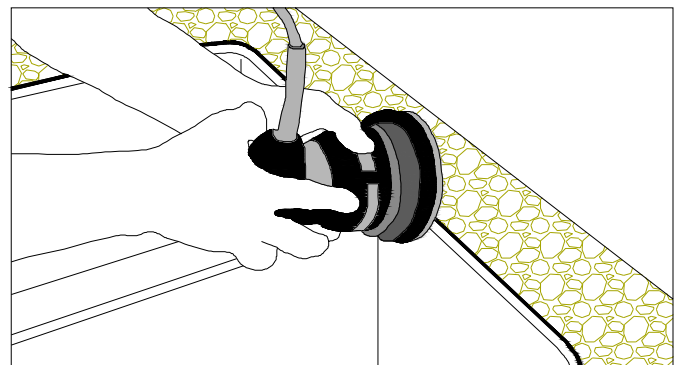


Figure 8C

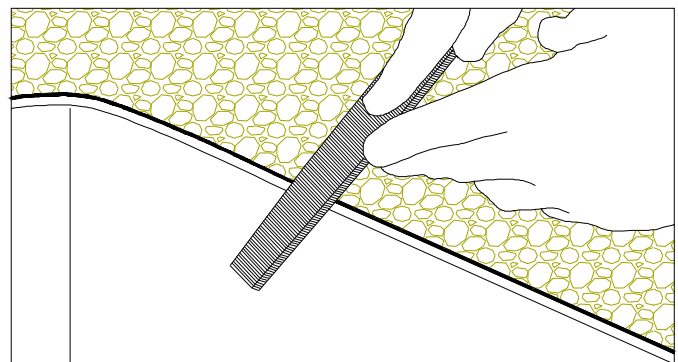


Figure 8D

Postform / Pre-Bonded Laminate Tops

Ledge Method

The following process was developed by Wilsonart® to install a Wilsonart HD® sink in a postform or pre-bonded laminate top.

Prepare the Substrate

- Locate where sink is to be installed on the substrate and draw reference lines. (FIG. 9A)
- Make a two part template to route the substrate for your sink cutout in the pre-bonded laminate countertop. (FIG. 9B)
 - See page 22 for instructions to make a two part template.
- Align the cross hairs of the two part undermount sink template with the reference lines on substrate.
 - Fasten securely to substrate with properly sized screws.
- Index a 3¼ HP or 2½ HP plunge router with a 1¼" x 1" top bearing flush trim router bit to remove the substrate. (FIG. 9C)
 - Set the cutting depth to route within ¼" of the laminate.
 - Adjust depth to include the thickness of the template and the countertop substrate.
 - Do not set routing depth to reach the laminate.
 - Substrate and adhesive thickness variation may cause damage to the laminate if routing depth is set to deep.
- Route along templates in the direction indicated.
 - Remove all substrate for this routing depth between the two part templates. (FIG. 9D)
- Once this step is completed there should be ¼" of substrate remaining.

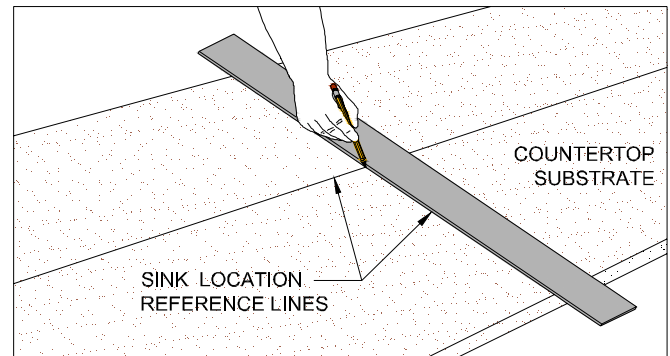


Figure 9A

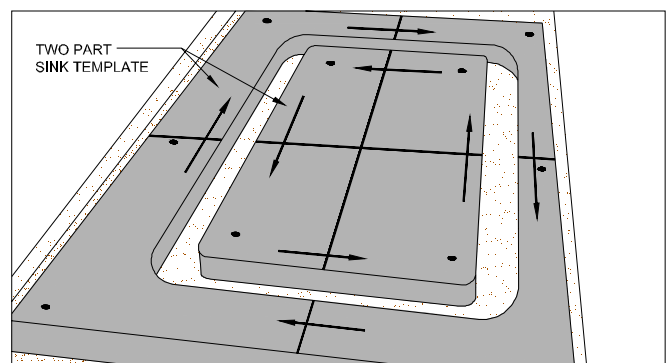


Figure 9B

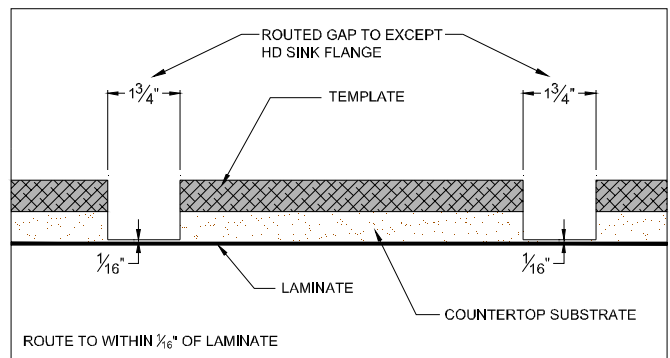


Figure 9C

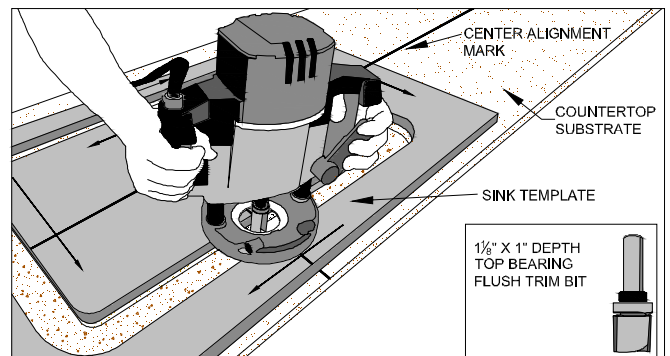


Figure 9D

Ledge Method (cont')

- Index a 3¹/₄ hp or 2¹/₂ hp plunge router with a 1" straight cut router bit and a 1¹/₄" (31.75mm) template guide to remove the remaining substrate to within 1¹/₃₂" of the laminate. (FIG. 10A)
 - Do not set routing depth to reach the laminate.
 - Substrate and adhesive thickness variation may allow damage to the laminate if routing depth is set too deep.
- Once set, route a small area along the remaining inside substrate of the sink cutout only. (FIG. 10B)
- Use a sharp chisel and scrape away the remaining substrate to verify proper routing depth.
 - Adjust routing depth as necessary.
- Once set, route along the remaining inside substrate of the sink cutout only, this will create a 1" wide channel. (FIG. 10B)
- Remove the template from the substrate.
- Using a sharp chisel remove the remaining substrate and adhesive layer from the back of the laminate.
 - Keep chisel flat, beveled side up, so as not to damage laminate. (FIG. 10C)
- Using a wire brush remove any remaining substrate or adhesive residue from the exposed laminate. Blow off all residue with compressed air. (FIG. 10D)
 - Do not use adhesive solvents which may saturate the substrate or degrade the bond between the laminate and the substrate.

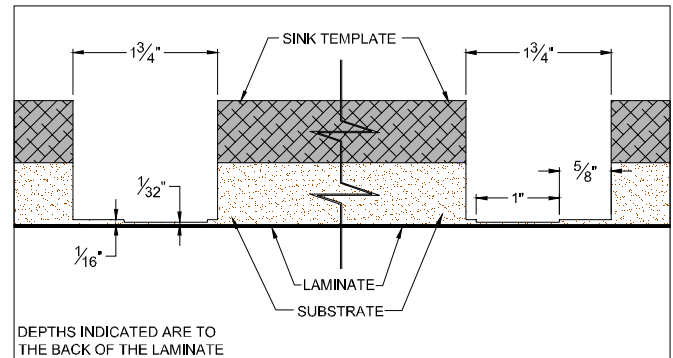


Figure 10A

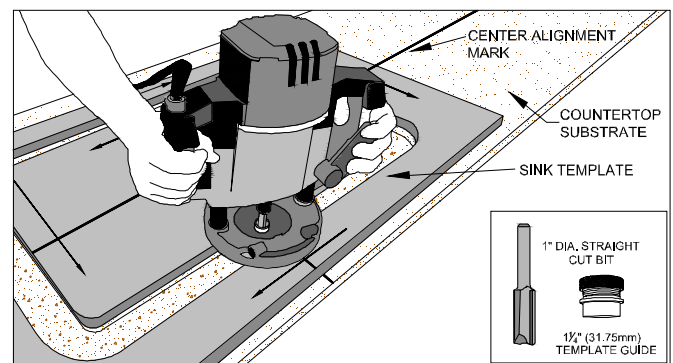


Figure 10B

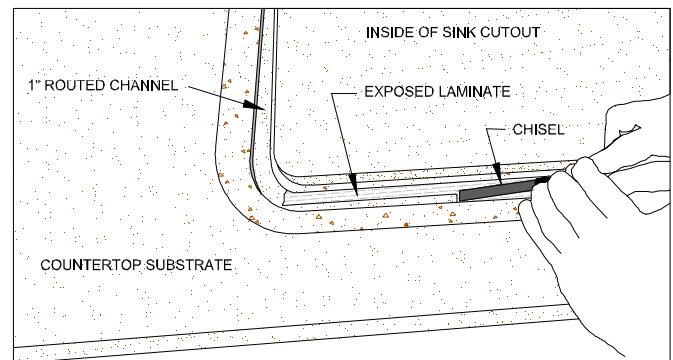


Figure 10C

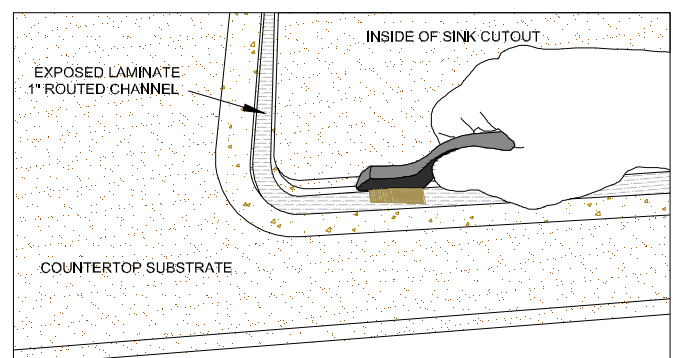


Figure 10D

Ledge Method (cont')

- Drill a $\frac{3}{8}$ " or larger pilot hole through the substrate at the inside of the sink cutout to insert a laminate trim bit to cutout center piece. (FIG. 11A)
- Turn top over so laminate is facing up.

Center Cutout Removal

- Use a laminate trim router with a $\frac{3}{8}$ " bottom bearing flush trim bit, route around the inside of the sink cutout. (FIG. 11D)
 - Remember to route to the inside of the cutout.
 - This step will remove the center section of the cutout.

Dry Fit Sink

- Place sink in cutout.
 - Insure sink flange does not extend above substrate.
 - Do not exceed a $\frac{1}{4}$ " gap between the sink flange and the substrate.
- If not flush with substrate;
 - Re-trim as directed on page 2 of this manual or
 - Use belt sander or surface leveler to remove excess flange.

Bonding Process

- Clean the sink flange and exposed laminate with denatured alcohol and a clean white cloth.
 - See Section B page 4 for procedures and precautions.
- Prepare the WA8230 - LS Sink Seam Adhesive to bond the sink to the laminate.
 - See Section B page 4 for procedures and precautions.
- Apply the WA8230 - LS Sink Seam Adhesive to the HD sink flange. (FIG. 11C)
 - Apply one $\frac{1}{4}$ " bead of adhesive $\frac{1}{16}$ " from the inside edge of sink flange or on the laminate around the outer edge of the channel.
- Place the sink in the cutout and move sink to spread the seam kit and apply firm pressure for 5 to 10 seconds.
 - No weight is necessary.
- Align sink with register marks on flange and reference lines on the substrates.
- Fill gap between sink rim and substrate with 100% silicone. (FIG. 11D)
- Allow the seam kit to cure completely before moving or routing.

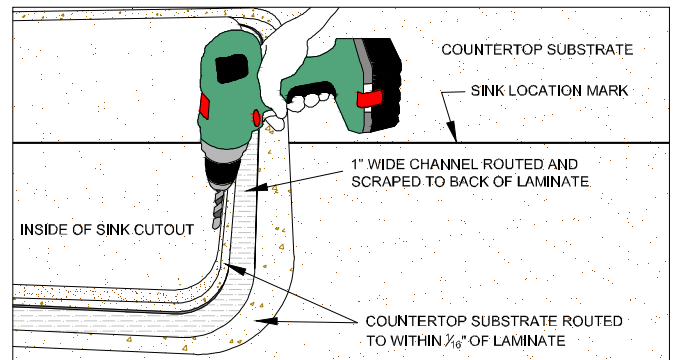


Figure 11A

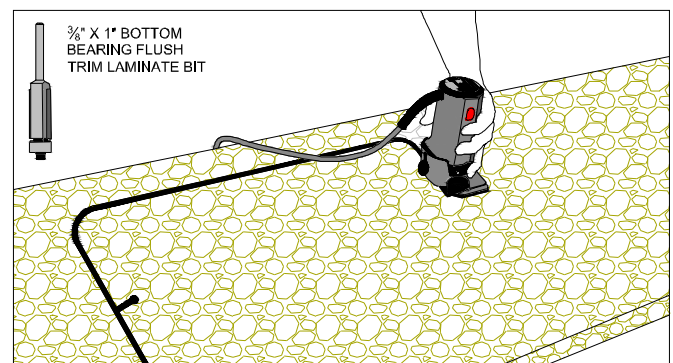


Figure 11B

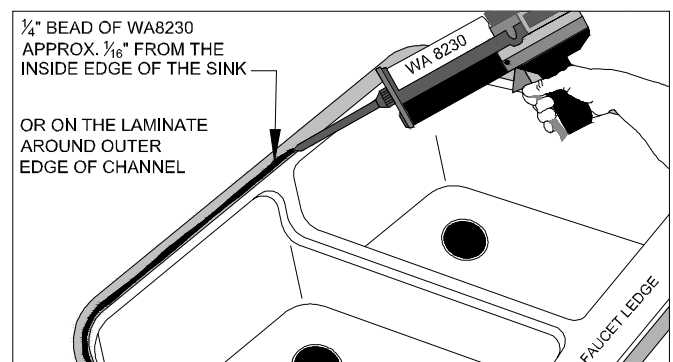


Figure 11C

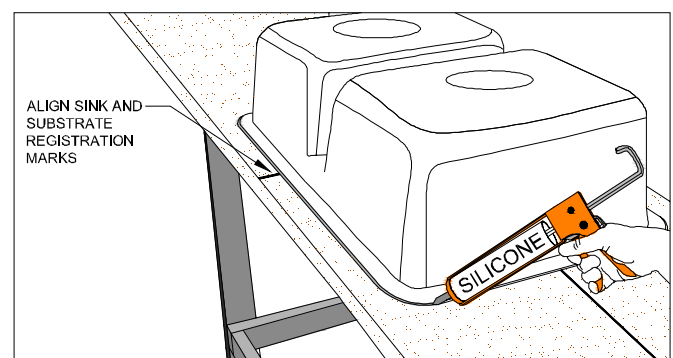


Figure 11D

Ledge Method (cont')

Sink Support

- Place $\frac{3}{4}$ " thick wood support strips around entire perimeter of sink flange. (FIG. 12A)
 - Minimum 2" wide strips are required.
 - Strips should cover only the area of the flange that was previously trimmed.
 - In the front and back of the sink, they should extend over the substrate to cover the entire area inside the cabinet base.
 - Secure with wood glue and properly sized screw or staples.
- Once seam adhesive has completely cured, flip the countertop over on well supported surface.

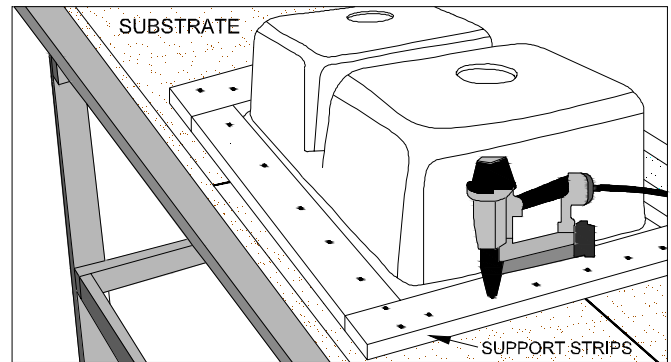


Figure 12A

Routing & Profiling the HD Sink

Routing Precautions

- Set depth of bits so that they do not come in contact with the sink plumbing ledge.
- Using a variable speed router set at 16,000 to 18,000 rpm will prolong the life of the carbide router bits.
- Clean and lubricate HD bits after each use

Countertop without an attached backsplash

- Adjust the laminate tilt-base trim router with a $\frac{3}{8}$ " bottom bearing flush trim bit. (FIG. 12B)
 - Set the angle of the base at approximately 45° to 48° .
 - Set bearing to run along bevel of sink.
- Route around the inside of the sink. (FIG. 12B)
 - Remember to twist the router base in corners to properly follow the radius and eliminate router chatter.

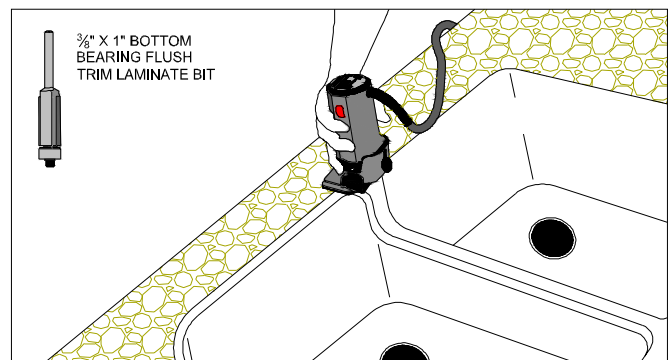


Figure 12B

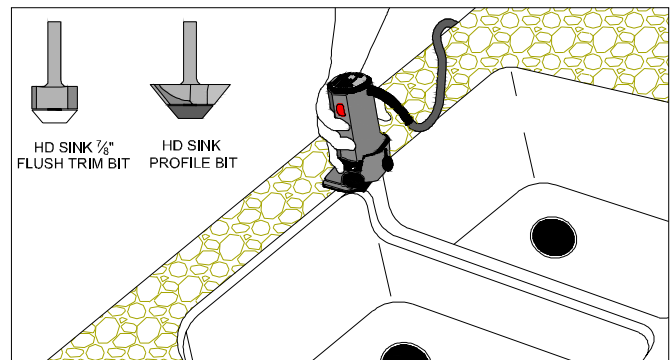


Figure 12C

Countertops with an attached backsplash (postform top)

Due to limited space between the sink and the backsplash Wilsonart suggests the following procedures.

- Use a laminate trim router with the HD bottom bearing flush trim bit and flush trim the overhanging laminate. (FIG. 12C)
- Use a laminate trim router with the HD sink profile bit, profile the edge of the laminate with the angle of the sink. (FIG. 12C)

Ledge Method (cont')

Finishing

- Sand the edge of the laminate and sink wall with a random orbital palm sander. Use a 150 to 220 grit sandpaper. (FIG. 13A)
 - Use only light to medium pressure when sanding.
 - Keep sander at same angle as sink wall.
 - Keep sander moving to minimize the chance of dips or over sanding one area.
- Finish sanded area with a gray 3M® Scotch-Brite™ pad.
 - Use only light to medium pressure in a circular motion.
- Soften the sharp edge of the laminate with a laminate file.
 - Lightly file at a 45° angle. (FIG. 13B)

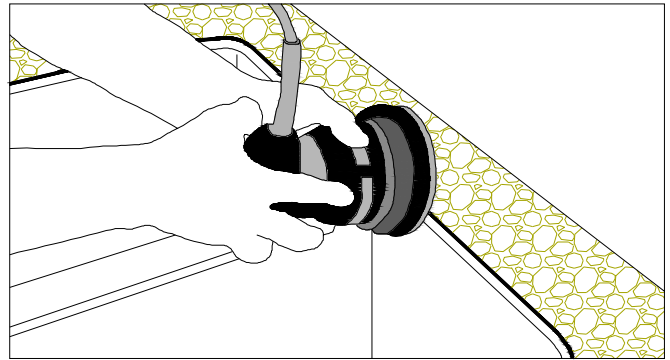


Figure 13A

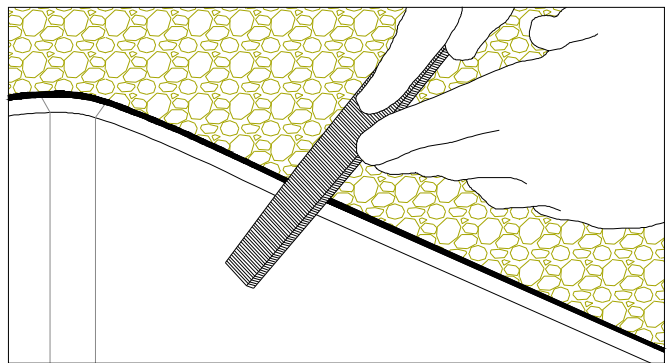


Figure 13B

Custom Tops - Filler Method

The following method can be used to install a Wilsonart® HD® Sink into a countertop that does not already have the laminate bonded to the substrate. The filler method will provide added stability and strength between the sink and the substrate.

Prepare the Substrate

- Pencil the sink location on the substrate with a vertical and horizontal cross hair. (FIG. 14A)
- Position sink on substrate, align register marks on the flange with the pencil cross hair.
- With a pencil, trace the sink perimeter leaving an $\frac{1}{8}$ " gap between the pencil line and the rim of the sink. (FIG. 14B)
- Remove the sink.
- Using a jig saw, cut the substrate along the pencil outline of the sink. (FIG. 14C)
 - Keep the cutout for laminate bonding process.
- Place substrate with cutout on the laminate to be bonded.
- With a pencil, trace the inside perimeter of cutout onto the back side of the laminate to be bonded. (FIG. 14D)
 - Once done remove the laminate.

Dry Fit Sink

- Place sink in cutout
 - Insure sink flange does not extend above substrate.
 - Do not exceed a $\frac{1}{4}$ " gap between the sink flange and the substrate.
- If not flush with substrate;
 - Re-trim as directed on page 2 of this manual or
 - Use belt sander or surface leveler to remove excess flange.

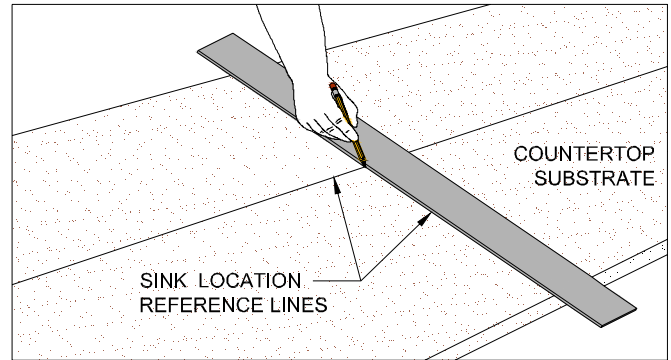


Figure 14A

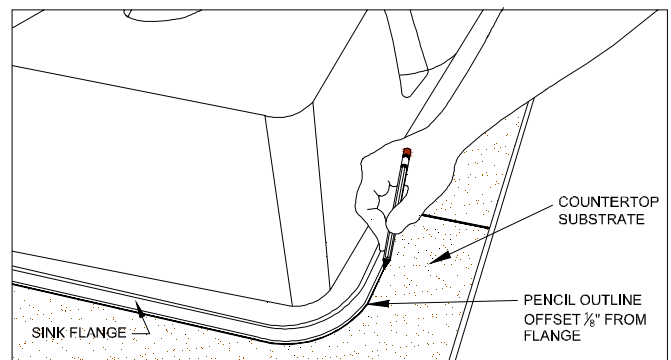


Figure 14B

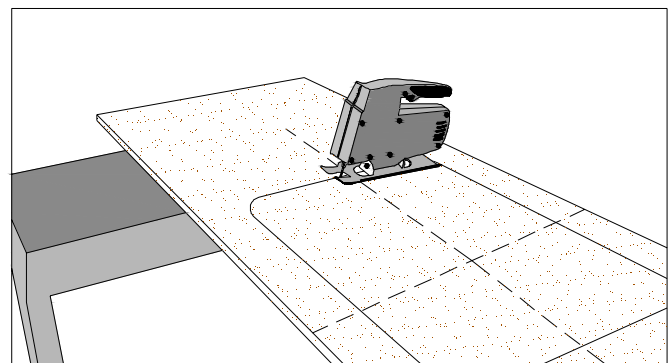


Figure 14C

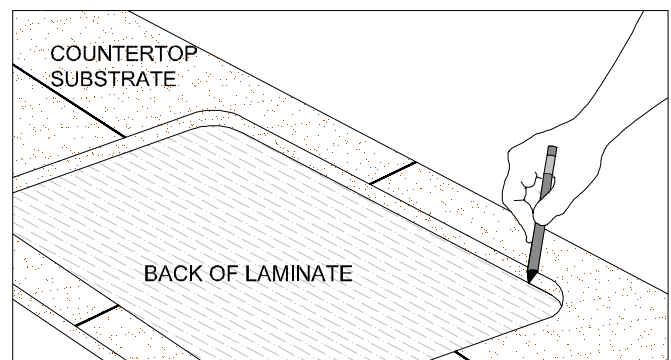


Figure 14D

Custom Tops - Filler Method (cont')

- Place $\frac{3}{4}$ " thick wood support strips around entire perimeter of sink flange. (FIG. 15A)
 - Minimum 2" wide strips are required for adequate support.
 - Strips should cover only the area of the flange that was previously trimmed.
 - In the front and back of the sink, they should extend over the substrate to cover the entire area inside the cabinet base.
 - Secure to substrate with wood glue and screw or staples.
- Flip countertop over and center sink in cutout on the wood support strips.
 - The sink should sit slightly higher than the substrate. (FIG. 15B)
 - Adjust height as needed by placing laminate chips under flange on the wood support strips.
- Select a auto body repair filler such as Evercoat® or comparable product.
 - Use and mix the filler according to the manufacturer's recommendations.
- Apply the filler into the gap between the sink and the substrate. Allow mixture to cure or harden completely. (FIG. 15C)
- Once completely cured, use a belt sander with coarse grit sandpaper and sand the rim of the sink and the filler.
 - Keep the belt sander level in order to sand the sink rim level with the substrate. (FIG. 15D)

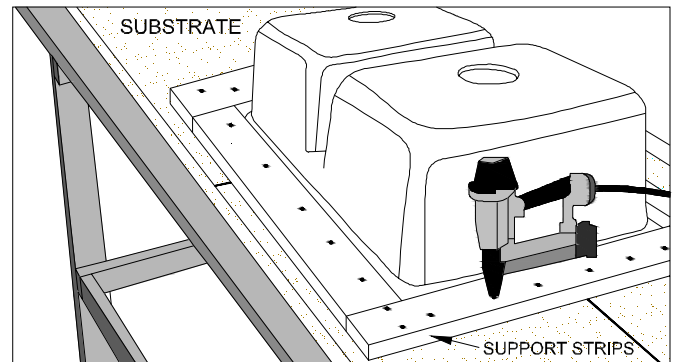


Figure 15A

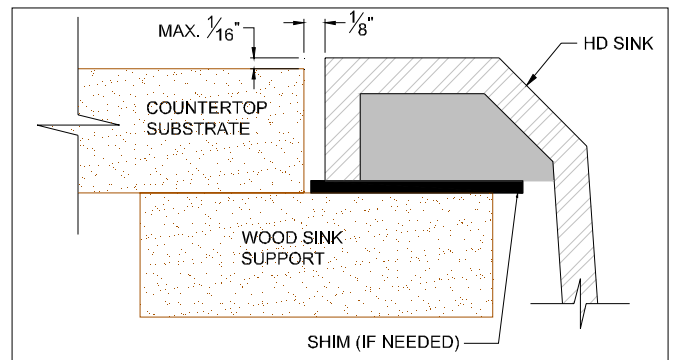


Figure 15B

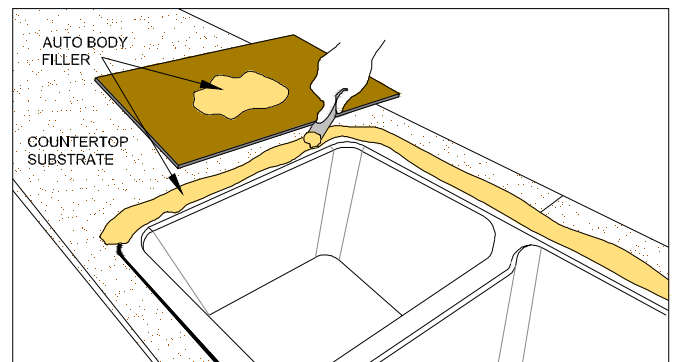


Figure 15C

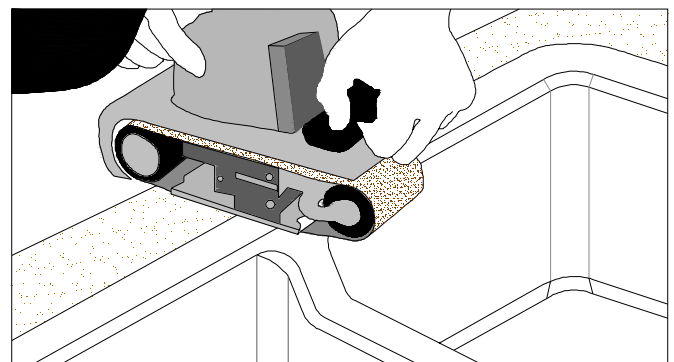


Figure 15D

Custom Tops - Filler Method (cont')

- Apply a release tape such as masking tape on the side walls around the entire sink. (FIG. 16A)
 - Place approximately $\frac{1}{16}$ " to $\frac{1}{8}$ " below the rim of the sink.

NOTE: Applying this tape will minimize time required for the final trimming stage to remove the seam kit used to bond the sink to the back of the laminate which may squeeze out on to the side wall of the sink.

Bonding Process

- Place the substrate cutout of the sink on the backside of the laminate. (FIG. 16B)
 - Align the cutout with the penciled outline to eliminate applying contact adhesive in this area.
- Apply contact adhesive per manufacturer's recommendations to the back side of the laminate. (FIG. 16B)
- Place the same substrate cutout over the sink bonded in the substrate.
 - Insure the edges of the sink are completely covered.
- Apply contact on the substrate per manufacturer's recommendations.
- Clean sink flange with denatured alcohol and a clean white cloth.
 - See Section B page 4 for procedures and precautions.
- Prepare the WA8230 - LS Sink Seam Adhesive to bond the sink to the laminate.
 - See Section B page 4 for procedures and precautions.
- Apply the WA8230 - LS Sink Seam Adhesive to the sink flange. (FIG. 16C)
 - Apply one $\frac{3}{16}$ " bead of adhesive $\frac{1}{16}$ " from the inside edge of the sink flange.
- Bond laminate to substrate using the manufacturer's recommendations and procedures.
- Apply pressure directly to the sink rim area with two sheets of particle board or with something of comparable weight. (FIG. 16D)
 - Insure even weight is applied around entire sink rim.
 - Allow seam kit to cure completely before moving or routing.

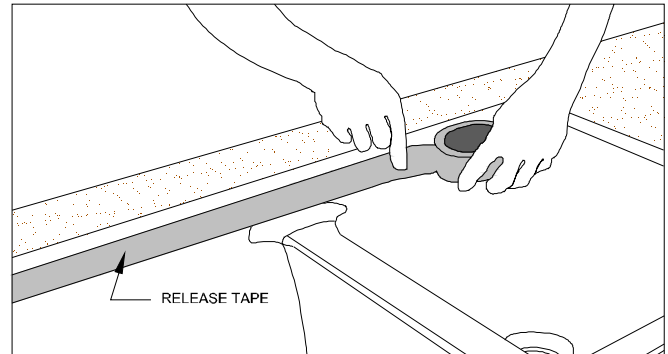


Figure 16A

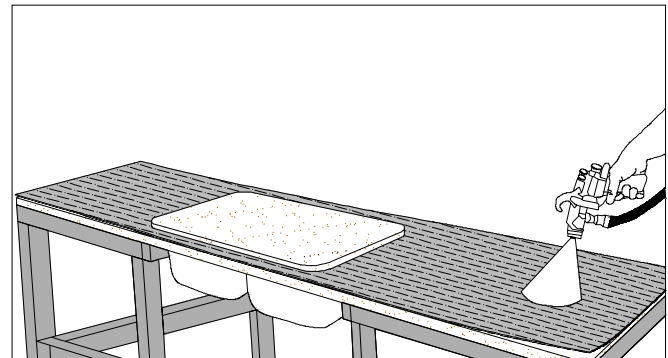


Figure 16B

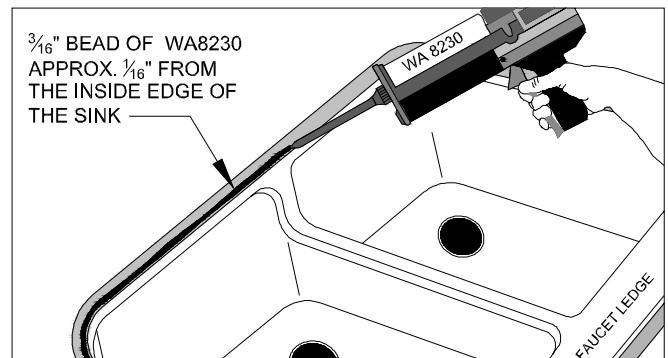


Figure 16C

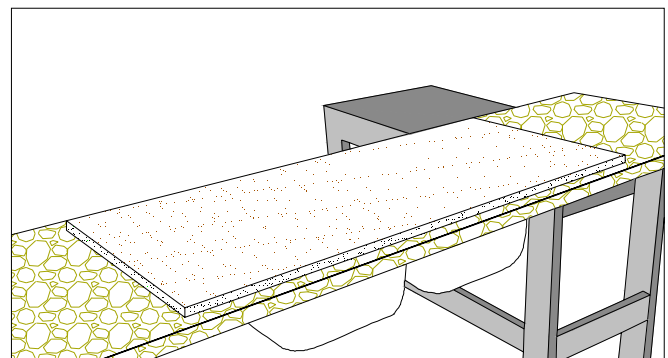


Figure 16D

Custom Tops - Filler Method (cont')

Center Cutout Removal

- Drill a $\frac{3}{8}$ " or larger pilot hole approximately 1" from inside edge of sink flange. (FIG. 17A)
 - Do not drill pilot hole over faucet deck area.

Routing & Profiling the HD Sink

Routing Precautions

- Set depth of bit so that it does not come in contact with the sink plumbing ledge.
- Support the laminate cutout during the routing process.
- Do not allow laminate to sag and drop between the carbide and the bearing.
- Using a variable speed router set at 16,000 to 18,000 rpm will prolong the life of the carbide router bits.
- Clean and lubricate HD bits after each use

Countertop without an attached backsplash

- Use a laminate tilt-base trim router with a $\frac{3}{8}$ " bottom bearing double-fluted flush trim bit, remove the laminate over the sink. (FIG. 17B)
 - Set the angle of the base at approximately $35^\circ - 40^\circ$
 - Set depth of bit so that it does not come in contact with the sink plumbing ledge.
- Adjust the laminate tilt-base trim router with a $\frac{3}{8}$ " bottom bearing flush trim bit. (FIG. 17C)
 - Set the angle of the base at approximately 45° to 48° .
 - Set bearing to run along bevel of sink.
- Route around the inside of the sink.
 - Remember to twist the router base in corners to properly follow the radius and eliminate router chatter.

Countertops with an attached backsplash (postform top)

Due to limited space between the sink and the backsplash Wilsonart suggests the following procedures.

- Use a laminate trim router with the HD bottom bearing flush trim bit and flush trim the overhanging laminate. (FIG. 17D)
- Use a laminate trim router with the HD sink profile bit, profile the edge of the laminate with the angle of the sink. (FIG. 17D)

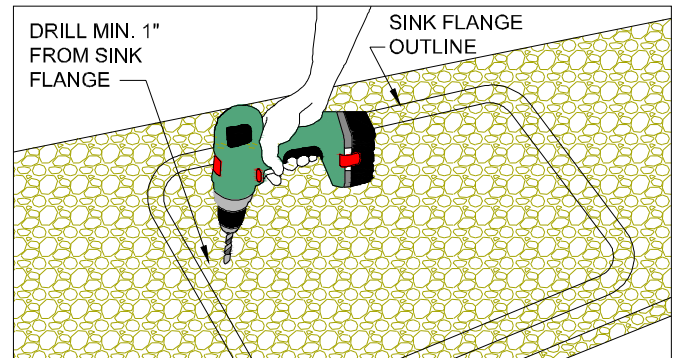


Figure 17A

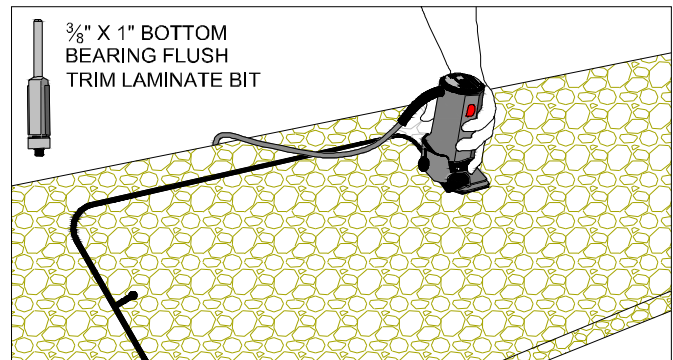


Figure 17B

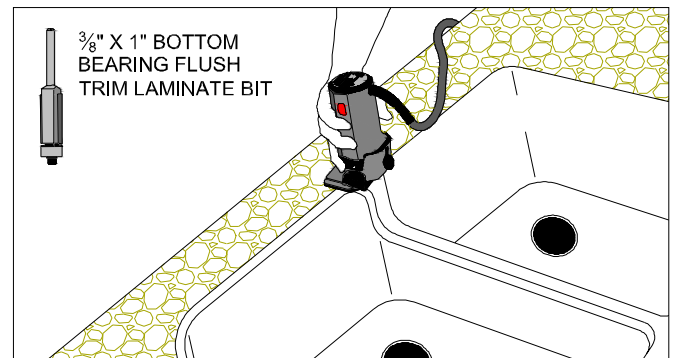


Figure 17C

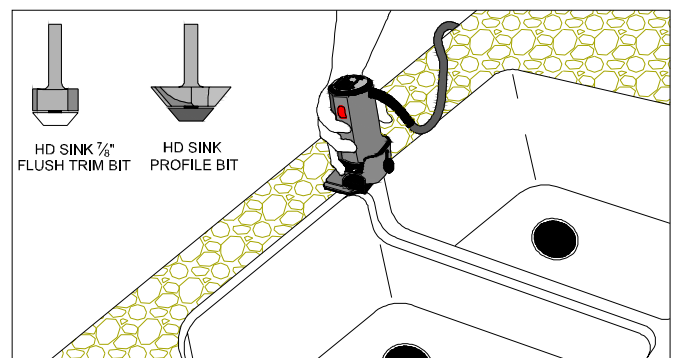


Figure 17D

Custom Tops - Filler Method (cont')

Finishing

- Sand the edge of the laminate and sink wall with a random orbital palm sander. Use a 150 to 220 grit sandpaper. (FIG. 18A)
 - Use only light to medium pressure when sanding.
 - Keep sander at same angle as sink wall.
 - Keep sander moving to minimize the chance of dips or over sanding one area.
- Finish sanded area with a gray 3M® Scotch-Brite™ pad.
 - Use only light to medium pressure in a circular motion.
- Soften the sharp edge of the laminate with a laminate file. (FIG. 18B)

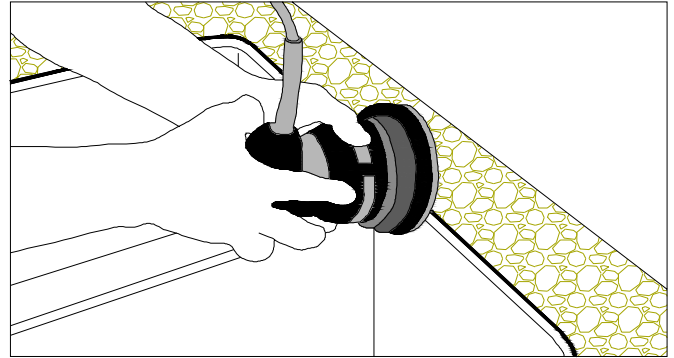


Figure 18A

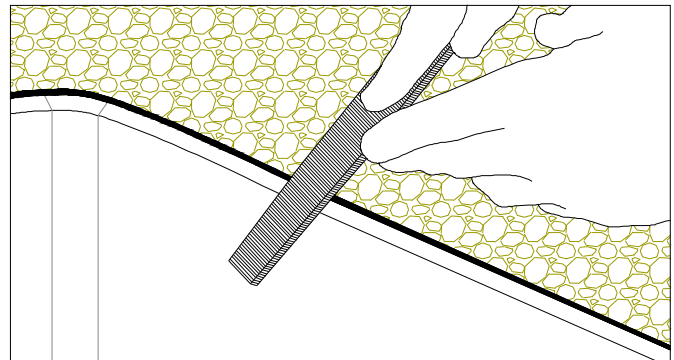


Figure 18A

Custom Tops - Spray Method

The following spray method is an alternative that can be used to install a Wilsonart® HD® sink into a countertop that does not already have the laminate bonded to the substrate.

Prepare the Substrate

- Pencil the sink location on the substrate with a vertical and horizontal cross hair. (FIG. 19A)
- Position sink on substrate, align register marks on the flange with the pencil cross hair.
- With a pencil, trace the sink perimeter leaving a $\frac{1}{8}$ " gap between the pencil line and the rim of the sink. (FIG. 19B)
- Remove the sink.
- Using a jig saw, cut the substrate along the pencil outline of the sink. (FIG. 19C)
 - Keep the cutout for laminate bonding process.
- Place substrate with cutout on the laminate to be bonded.
- With a pencil, trace the inside perimeter of cutout onto the back side of the laminate to be bonded. (FIG. 19D)
 - Once done remove the laminate.
- Center sink upside down in cutout.
 - Insure there is an $\frac{1}{8}$ " gap between the sink flange and the substrate.

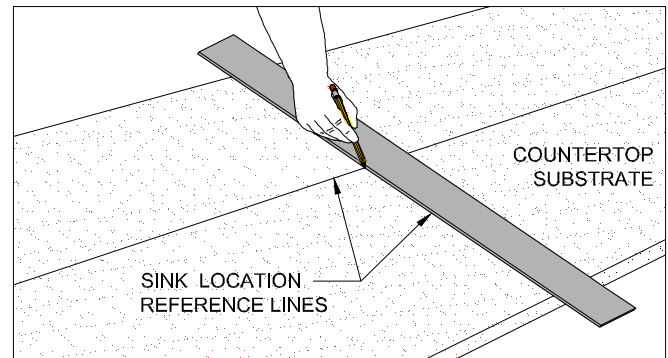


Figure 19A

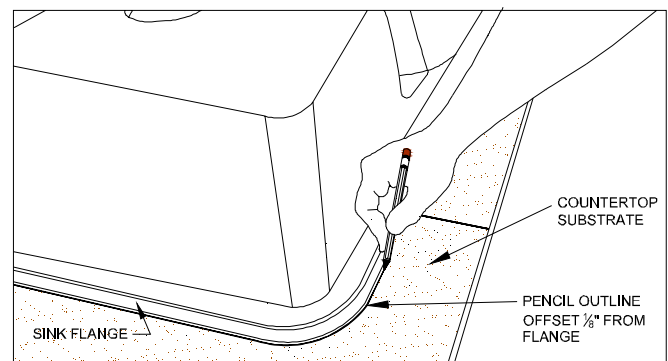


Figure 19B

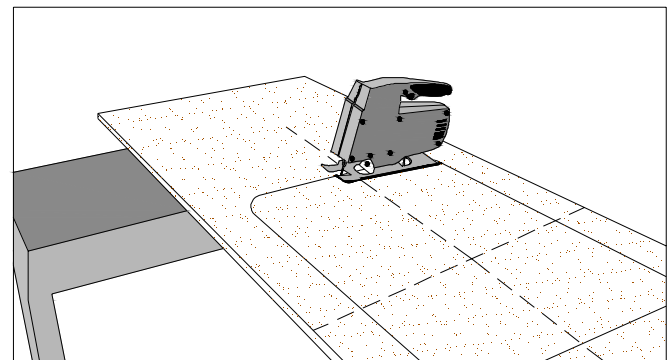


Figure 19C

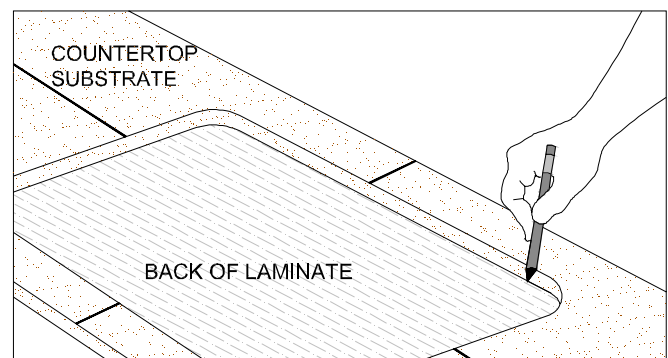


Figure 19D

Custom Tops - Spray Method (cont')

Bonding Process

- Place the substrate cutout of the sink on the backside of the laminate. (FIG. 20A)
 - Align the cutout with the penciled outline to eliminate applying contact adhesive in this area.
- Apply contact adhesive per manufacturer's recommendations to the back side of the laminate. (FIG. 20A)
- Apply contact on the substrate per manufacturer's recommendations. (FIG. 20B)
- Bond laminate to substrate using the manufacturer's recommendations and procedures. (FIG. 20C)

Dry Fit Sink

- Place sink in cutout
 - Insure sink flange does not extend above substrate.
 - Insure there is an $\frac{1}{8}$ " gap between the sink flange and the substrate.
- If not flush with substrate;
 - Re-trim as directed on page 2 of this manual or
 - Use belt sander or surface leveler to remove excess flange.
- Drill a $\frac{3}{8}$ " or larger pilot hole approximately 2" from inside edge of sink cutout. (FIG. 20D)
 - Do not drill pilot hole over faucet deck area.

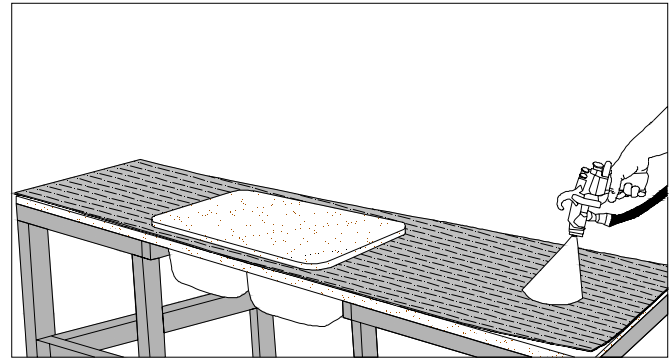


Figure 20A

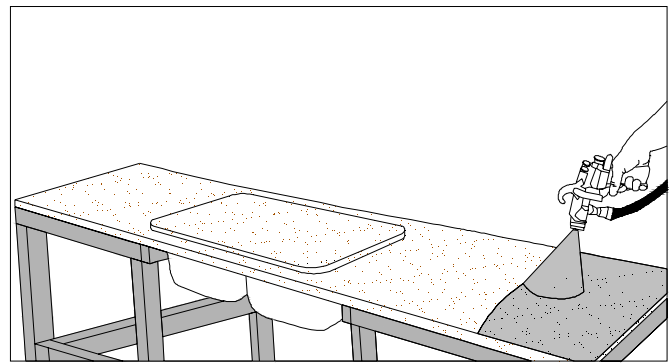


Figure 20B

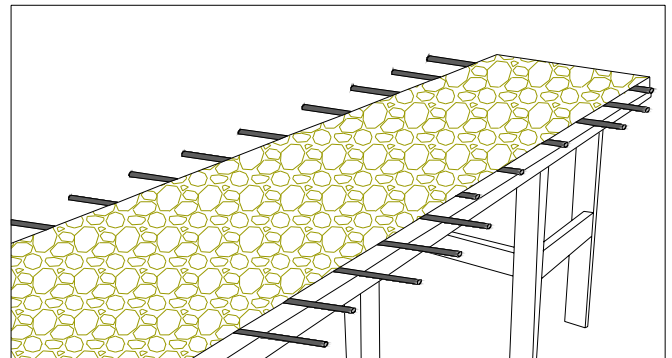


Figure 20C

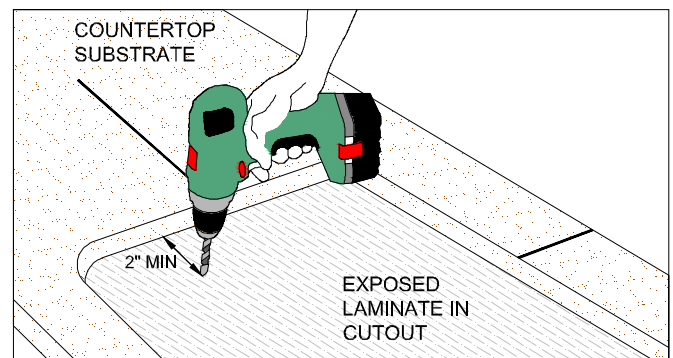


Figure 20D

Custom Tops - Spray Method (cont')

Bonding Process

- Clean the sink flange and exposed laminate with denatured alcohol and a clean white cloth. (FIG. 21A)
 - See Section B page 4 for procedures and precautions.
- Prepare the WA8230 - LS Sink Seam Adhesive to bond the sink to the laminate.
 - See Section B page 4 for procedures and precautions.
- Apply the WA8230 - LS Sink Seam Adhesive to the HD sink flange. (FIG. 21B)
 - Apply one $\frac{3}{16}$ " bead of adhesive $\frac{1}{16}$ " from the inside edge of sink flange.
- Place the sink in the cutout and move sink to spread the seam kit and apply firm pressure for 5 to 10 seconds.
 - No weight is necessary.
- Align sink with register marks on flange and reference lines on the substrates.
- Fill gap between sink rim and substrate with 100% silicone. (FIG. 21C)
- Allow the seam kit to cure completely before moving or routing.
- Place $\frac{3}{4}$ " thick wood support strips around entire perimeter of sink flange. (FIG. 21D)
 - Minimum 2" wide strips are required.
 - Strips should cover only the area of the flange that was previously trimmed.
 - In the front and back of the sink, they should extend over the substrate to cover the entire area inside the cabinet base.
 - Secure with wood glue and properly sized screw or staples.

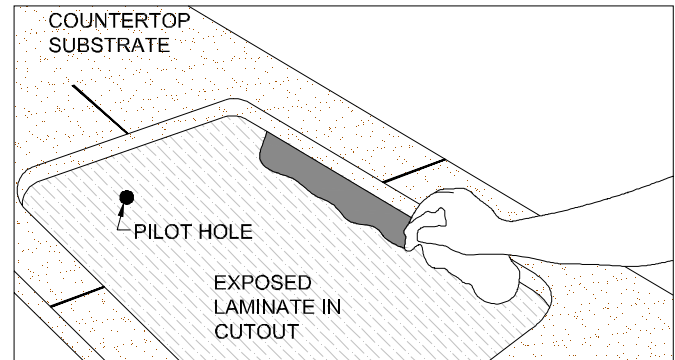


Figure 21A

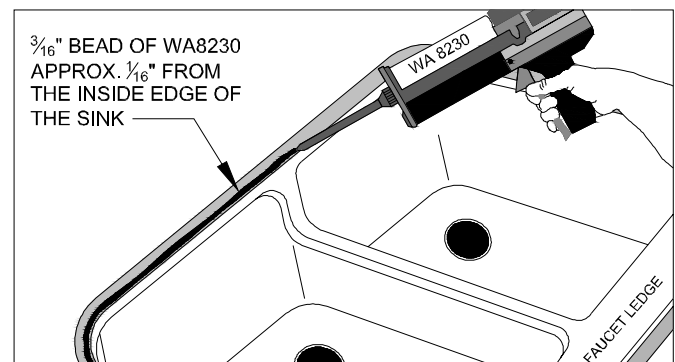


Figure 21B

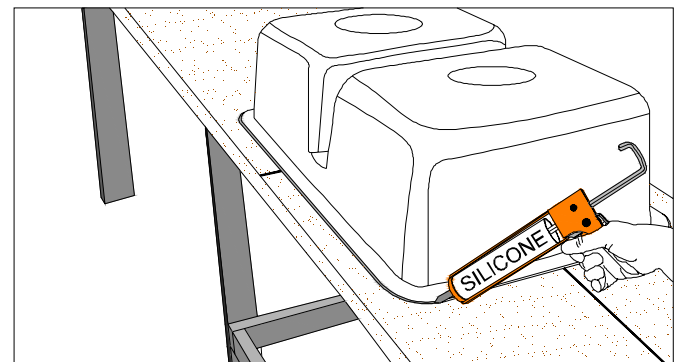
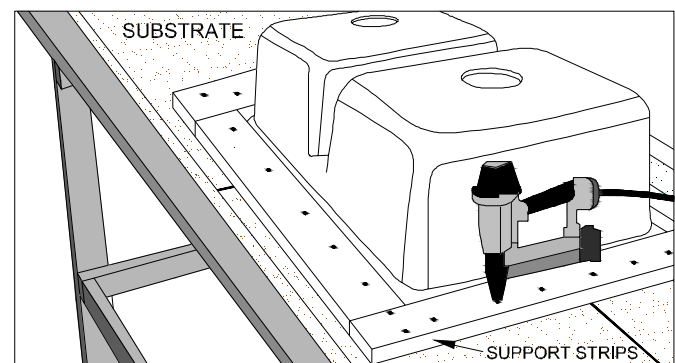


Figure 21C



Custom Tops - Spray Method (cont')

Routing & Profiling the HD Sink

Routing Precautions

- Set depth of bit so that it does not come in contact with the sink plumbing ledge.
- Support the laminate cutout during the routing process.
- Do not allow laminate to sag and drop between the carbide and the bearing.
- Set depth of bits so that they do not come in contact with the sink plumbing ledge.
- Using a variable speed router set at 16,000 to 18,000 rpm will prolong the life of the carbide router bits.
- Clean and lubricate HD bits after each use

Countertop without an attached backsplash

- Use a laminate tilt-base trim router with a $\frac{3}{8}$ " bottom bearing double-fluted flush trim bit, remove the laminate over the sink. (FIG. 22A)
 - Set the angle of the base at approximately 35° - 40°
- Adjust the laminate tilt-base trim router with a $\frac{3}{8}$ " bottom bearing flush trim bit. (FIG. 22B)
 - Set the angle of the base at approximately 45° to 48° .
 - Set bearing to run along level of sink.
- Route around the inside of the sink.
 - Remember to twist the router base in corners to properly follow the radius and eliminate router chatter.

Countertops with an attached backsplash (postform top)

Due to limited space between the sink and the backsplash Wilsonart suggests the following procedures.

- Use a laminate trim router with the HD bottom bearing flush trim bit and flush trim the overhanging laminate. (FIG. 22C)
- Use a laminate trim router with the HD sink profile bit, profile the edge of the laminate with the angle of the sink. (FIG. 22C)

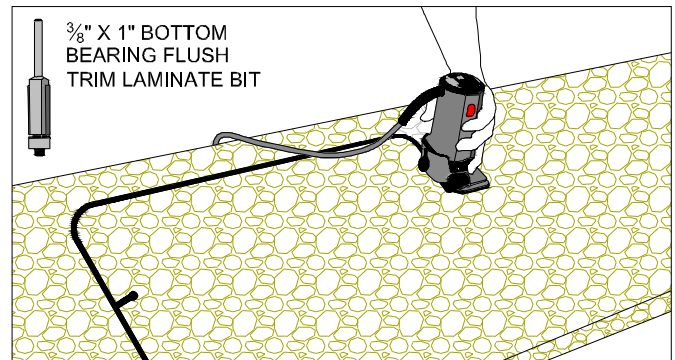


Figure 22A

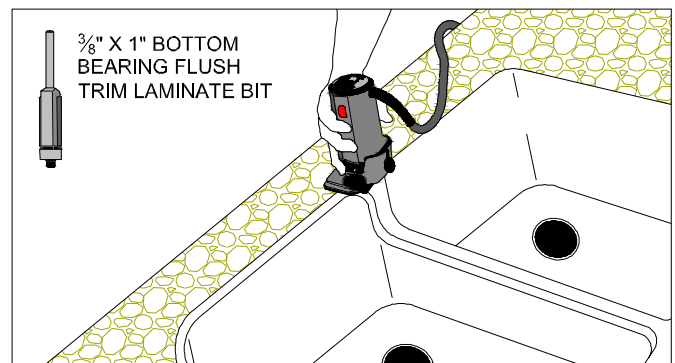


Figure 22B

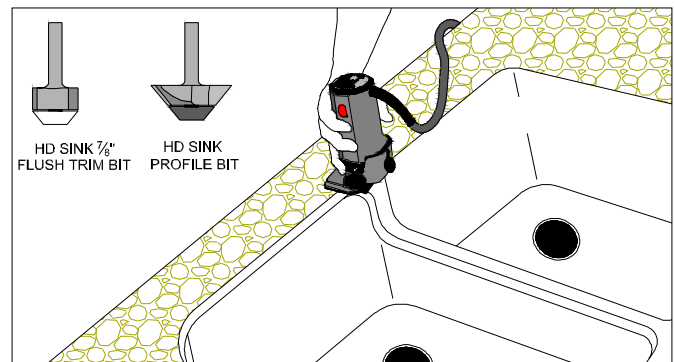


Figure 22C

Custom Tops - Filler Method (cont')

Finishing

- Sand the edge of the laminate and sink wall with a random orbital palm sander. Use a 150 to 220 grit sandpaper. (FIG. 23A)
 - Use only light to medium pressure when sanding.
 - Keep sander at same angle as sink wall.
 - Keep sander moving to minimize the chance of dips or over sanding one area.
- Finish sanded area with a gray 3M® Scotch-Brite™ pad.
 - Use only light to medium pressure in a circular motion.
- Soften the sharp edge of the laminate with a laminate file. (FIG. 23B)

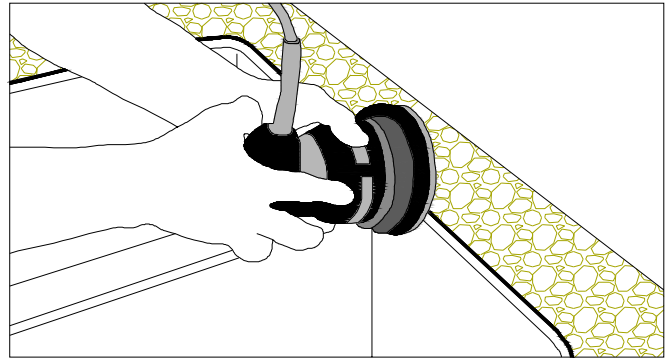


Figure 23A

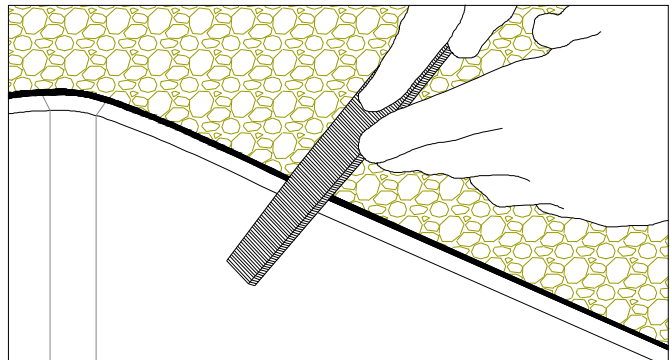


Figure 23B

HD® Two Part Sink Template

The following details one method to construct a two part template for removing the substrate on a pre-bonded or postform laminate top to accept a Wilsonart® HD® sink.

- The template should be constructed of flat, sturdy material such as MDF or phenolic board.
- The length and width should be sized to adequately support a 3¼ hp router.
- Pencil alignment cross hairs on the center of the template material.
 - Include both vertical & horizontal alignment marks. (FIG. 24A)
- Position Sink on substrate, align registration marks on the sink with the pencil cross hair.
- With a pencil, trace the outline of the sink, leaving an 1/8" gap between the pencil line and the flange of the sink. (FIG. 24B)
- Using the dimensions indicated on page 9, Figure 9B for the appropriate gap dimensions, measure and pencil in the line for the inner template. (FIG. 24C)
 - There should be approximately 1¾" gap between the inner template and outer template lines.
- Cut or route along the inner line drawn on the template material. (FIG. 24D)
- Rough cut along the pencil reference marks of the inner template.
- Using a disk sander, sand down the edges of the inner template to the pencil reference marks.
- Using 100 micron (150 grit) sand paper, smooth the edges of both templates.
- Drill countersink screw holes and place routing direction arrows on finished template as indicated.

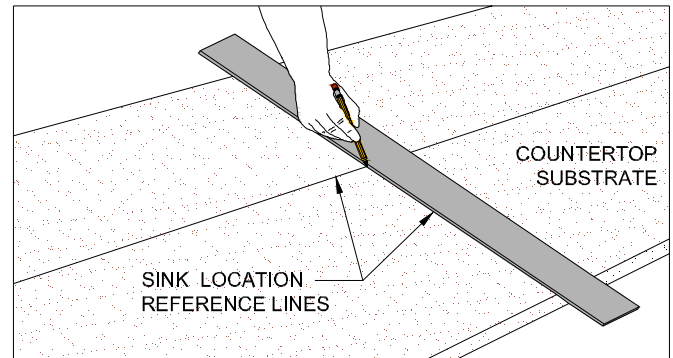


Figure 24A

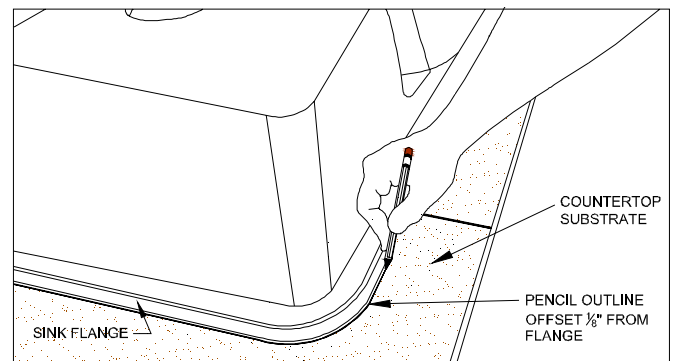


Figure 24B

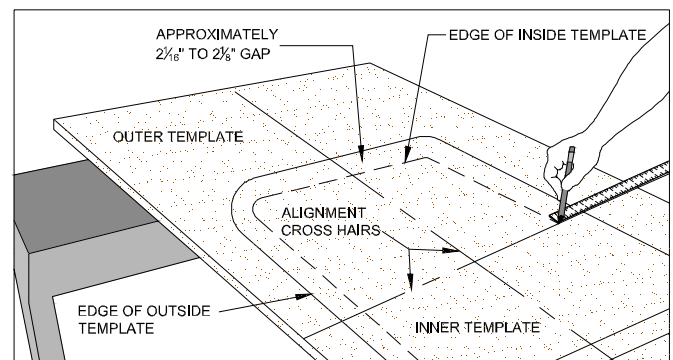


Figure 24C

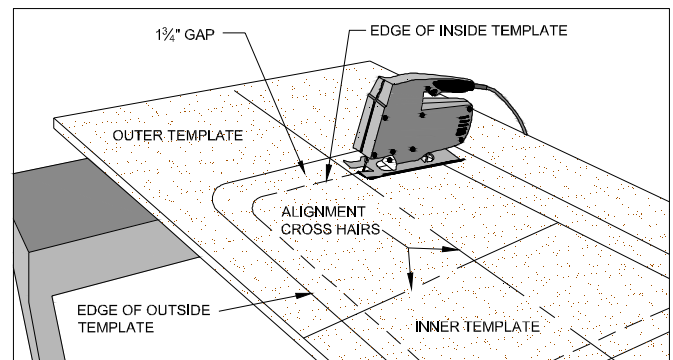


Figure 24D

Installation Tips

Plumbing Holes

In an effort to minimize and/or eliminate moisture issues with a wood core substrate, four plastic sleeves for plumbing holes have been included in all the Wilsonart® Durasteel sink boxes except for sinks that contain a plumbing ledge.

The following recommendations should provide protection for the substrate against moisture.

- Once the faucet and any additional plumbing holes have been drilled, completely seal the exposed substrate with 100% silicone. (FIG. 25A)
 - Silicone should seal around the top and bottom of the plumbing hole and extend approximately 1/8" from the edge.
- After applying the 100% silicone, install the plastic sleeve into the plumbing hole and press firmly in place. (FIG. 25B & FIG. 25C)
- Wipe excess silicone away from cap of the sleeve.
 - The silicone must provide a complete seal around cap of the sleeve. (FIG. 25D)

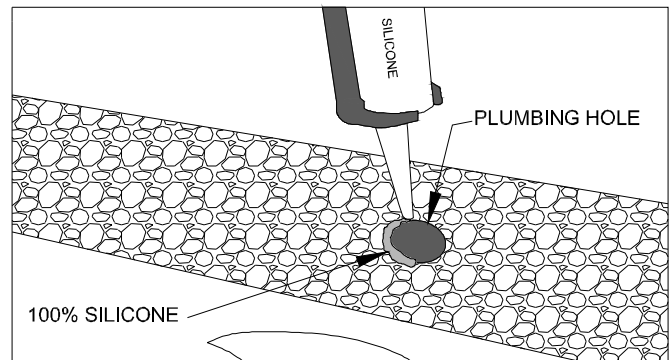


Figure 25A

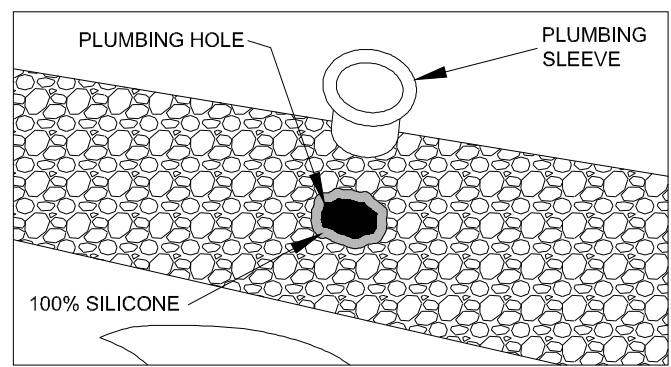


Figure 25B

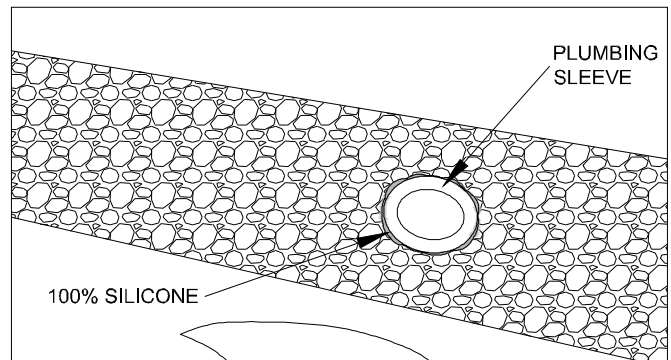


Figure 25C

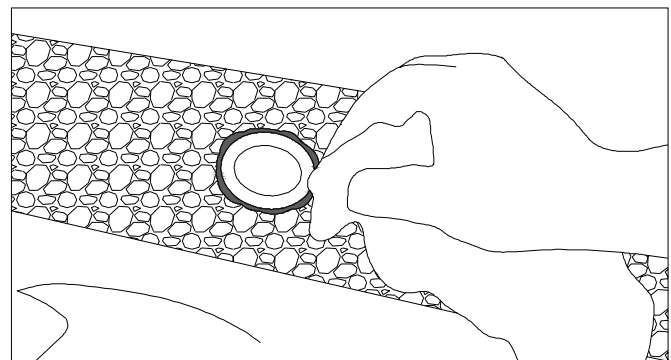


Figure 25D

Postform / Pre-Bonded Laminate Tops

The following process was developed by Wilsonart® to install a Wilsonart Solid Surface Sink Ring into a postform or prebonded laminate top.

For the "Filler Method"

- Follow instructions for sink installation instruction on pages 14-18 of this manual.

For the "Spray Method"

- Follow instructions for sink installation instruction on pages 19-23 of this manual.

Prepare the Wilsonart Sink Ring

- Measure the ring in both directions. (FIG. 1A)
 - Pencil alignment marks at the center of all four sides.

Prepare the Substrate

- Locate where the ring is to be installed into the substrate and draw alignment cross hairs. (FIG. 1B)
- Make a two part template to route the countertop substrate. (FIG. 1C)
 - See page 24 for instructions to make a two part template.
- Align the alignment cross hairs of the template with those on the countertop substrate.
 - Fasten securely to the substrate with screws.
- Index a 3¼ HP or 2½ HP plunge router with a 1½ x 1" top bearing flush trim router bit to remove the substrate. (FIG. 1D)
 - Set the cutting depth to route within 1/32" of the laminate.
 - Adjust the depth to include the thickness of the template and the countertop substrate.
 - Do not set routing depth to reach the laminate.
 - Substrate and adhesive thickness variation may allow damage to the laminate if routing depth is set too deep.

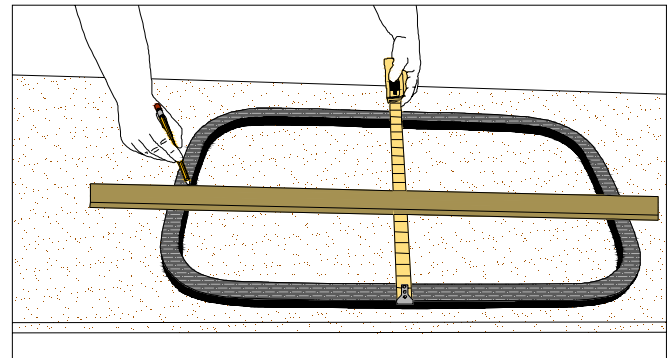


Figure 1A

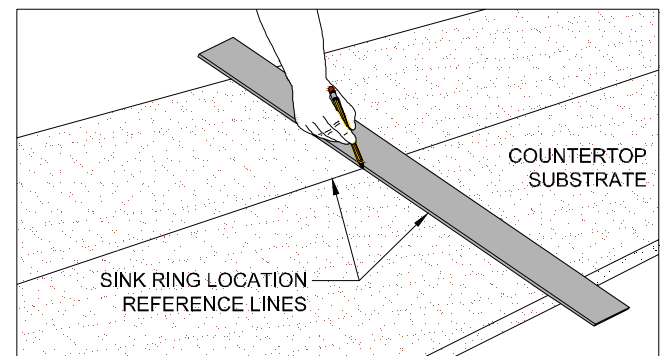


Figure 1B

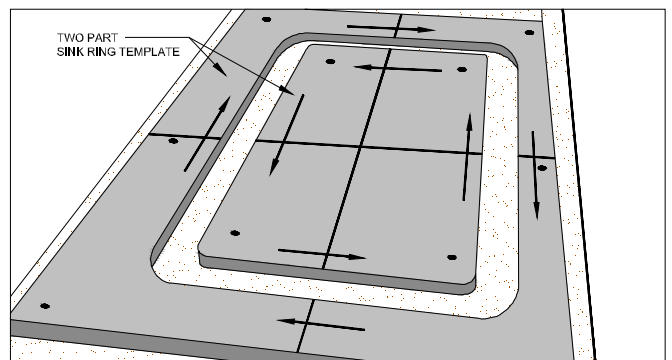


Figure 1C

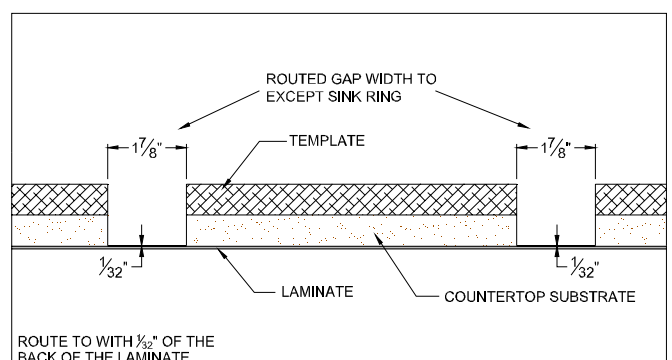


Figure 1D

Postform / Pre-Bonded Laminate Tops (cont')

- Route along the template in the direction indicated.
 - Gradually remove all substrate between the two part template. (FIG. 2A)
- Once this step is complete there should be approximately $\frac{1}{32}$ " of substrate remaining to be removed.
- Remove the template from the countertop substrate.
- Using a sharp chisel remove the remaining substrate and adhesive layer from the back of the laminate.
 - Keep chisel flat, beveled side up, so as not to damage laminate. (FIG. 2B)
- Using a wire brush remove any remaining substrate or adhesive residue from the exposed laminate. Blow off all residue with compressed air. (FIG. 2C)
 - Do not use adhesive solvents which may saturate the substrate or degrade the bond between the laminate and the substrate.
- Drill a $\frac{3}{8}$ " or larger pilot hole through the substrate at the inside of the sink cutout to insert a laminate trim bit to cutout center piece. (FIG. 2D)

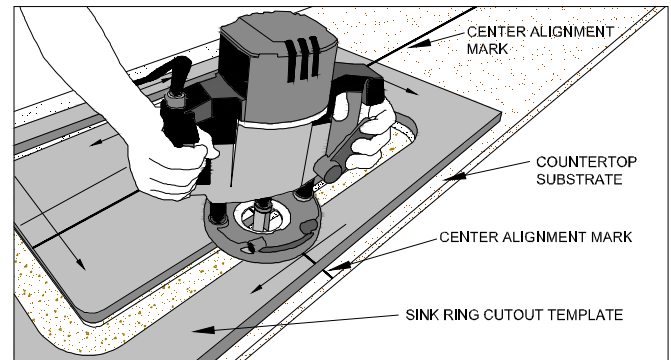


Figure 2A

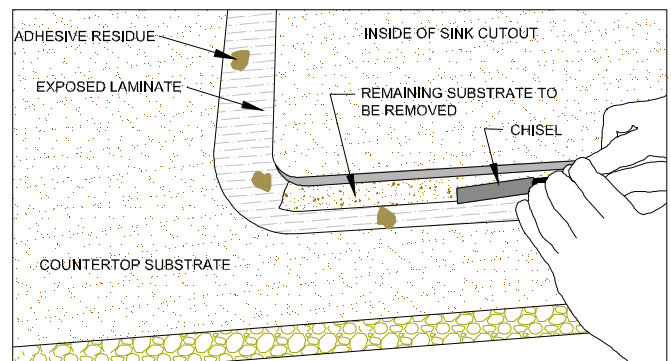


Figure 2B

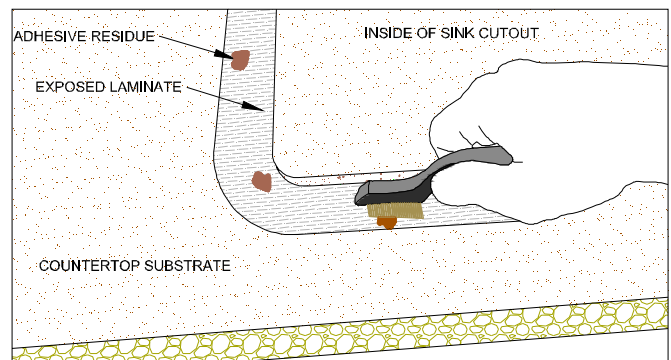


Figure 2C

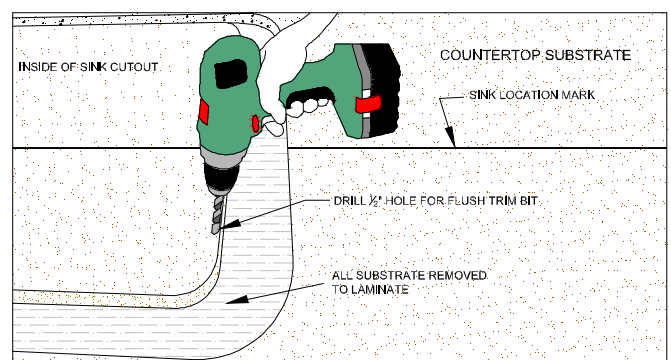


Figure 2D

Postform / Pre-Bonded Laminate Tops (cont')

- Dry fit the sink ring in cutout.
- Align ring with alignment marks on the ring and the substrate. (FIG. 3A)

Bonding Process

- Clean the sink ring and exposed laminate with denatured alcohol and a clean white cloth.
 - See Section B page 4 for procedures and precautions.
- Prepare the WA8230 - LS Sink Seam Adhesive to bond the sink ring to the laminate.
 - See Section B page 4 for procedures and precautions.
- Apply the WA8230 - LS Sink Seam Adhesive to the sink ring (FIG. 3B)
 - Apply one 1/4" bead of adhesive around the inside perimeter of the sink ring.
- Place the sink ring in the cutout and move ring to spread the seam kit.
- Align sink with register marks on flange and reference lines on the substrates. (FIG. 3C)
- Apply pressure directly to the sink ring. (FIG. 3C)
 - Place a sheet of particle board sized to cover the entire sink ring.
- Place weight on particle board cover. (FIG. 3C)
 - 10 lbs. per drain hole.
 - Insure weight is evenly applied on cover board.
- Fill gap between sink rim and substrate with 100% silicone. (FIG. 3D)
- Allow adhesive to cure completely before moving or routing.

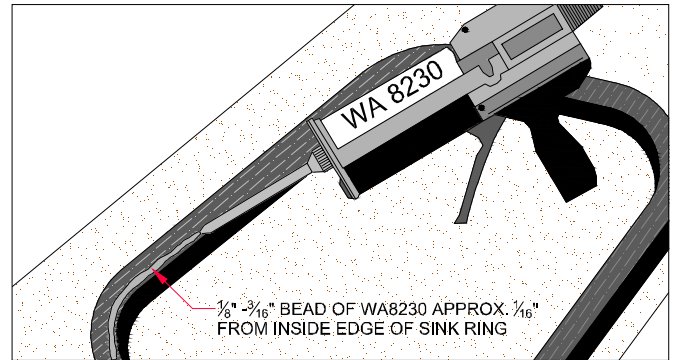


Figure 3A

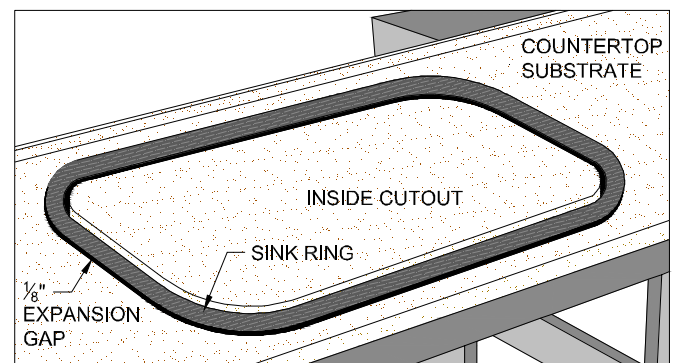


Figure 3B

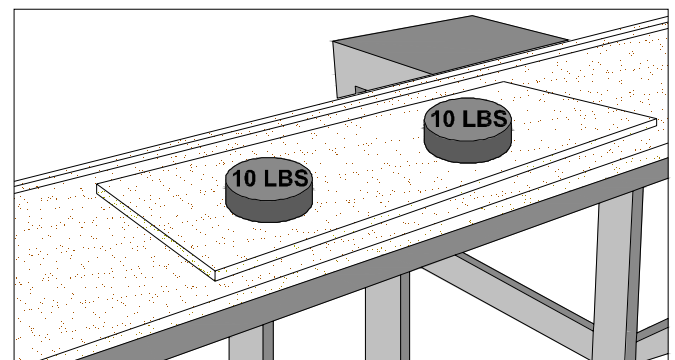


Figure 3C

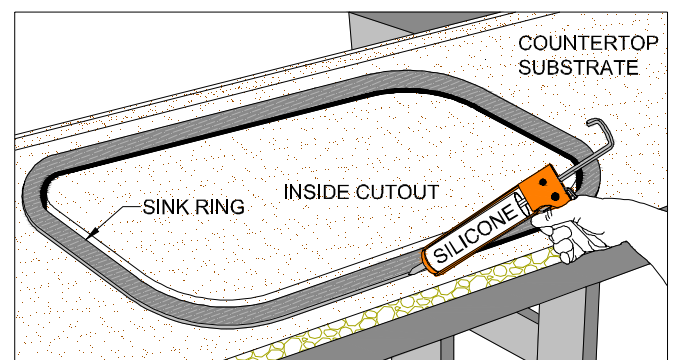


Figure 3D

Postform / Pre-Bonded Laminate Tops (cont')

Routing & Finishing

- Once the adhesive has completely cured, flip top so laminate is facing up.
- Use a laminate trim router with a $\frac{3}{8}$ " bottom bearing flush trim bit. (FIG. 4A)
- Route around the inside of the sink ring. (FIG. 4A)
- Sand the edge on the laminate and sink ring with a random orbital sander. (FIG. 4B)
 - Use 150 grit sand paper to remove scratches on the ring.
 - The use 220 grit paper for consistent finish.

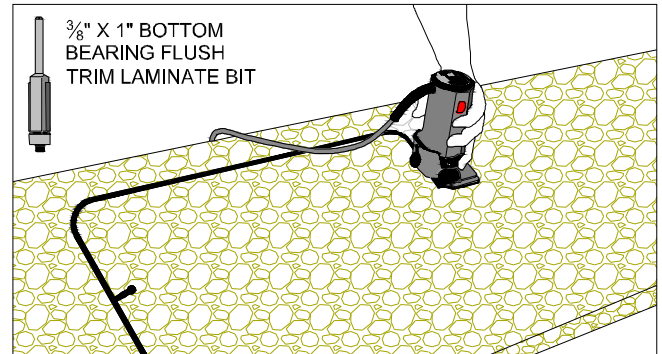


Figure 4A

Pencil Edge

- Soften the sharp edge of the laminate with a laminate file.
 - Lightly file at a 45° angle. (FIG. 4C)
- Finish sanded sink ring with a gray 3M® Scotch-Brite™ pad.
 - Use only light to medium pressure in a circular motion.

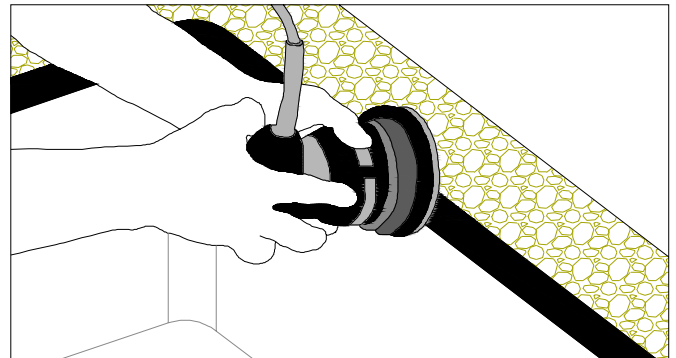


Figure 4B

Profiled Edge

- Route desired profile. (FIG. 4D)
 - Set the profile bit to provide a 90° angle at the edge of the laminate.
 - Do not round over the edge of the laminate.
- Finish routed profile.
 - Use a 220 grit sponge sanding pad.
 - Finish with a 320 grit sponge sanding pad.
 - Use only light to medium pressure with sanding.

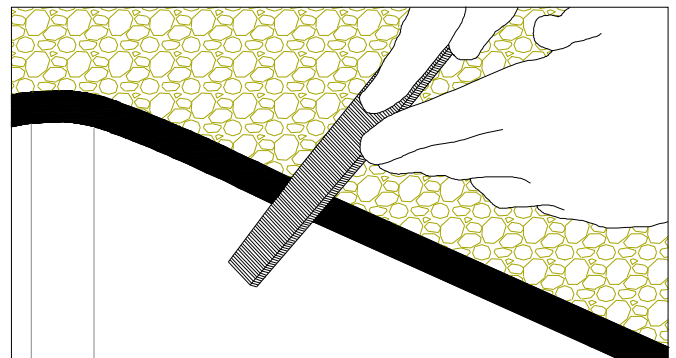


Figure 4C

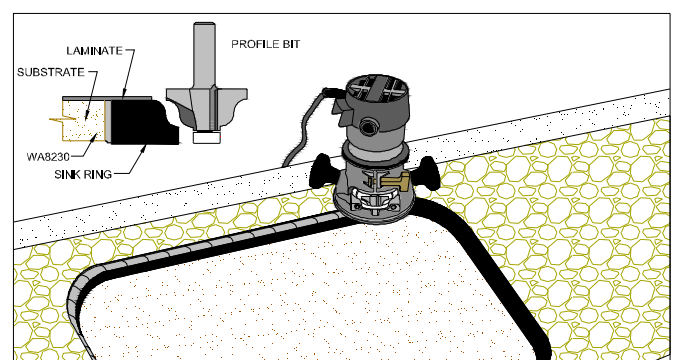


Figure 4D

Durasteel™ Self-Rimming Sink Installation

Helpful Tools

- Drill with 3/8" drill bit
- Jig Saw
- Long shank slotted screwdriver
- Pencil
- Caulking gun with 100% silicone
- 150 Grit sandpaper
- Safety glasses

Installation Instructions

- Position sink upside down on countertop in desired position. Holding the sink in place, trace completely around outside of sink rim. (FIG. 1B)
 - Caution: Make sure the cutout will clear drawer openings and any partitions.
 - Do not use an indelible permanent marker or other product that can't be erased or removed later.
- Remove sink.
- Using a ruler, measure 1/4" inside the sink rim outline and draw a line completely around the entire outline. (FIG. 1C)
 - The countertop will be cut 1/4" inside the sink rim outline.
 - The 1/4" measurement inside the sink rim outline is critical to allow adequate sink support and clearance for the securing hardware.
- Drill a 3/8" diameter hole along the inside edge of the cutout line for the jig saw blade.
- Using the jig saw, cut along the cutout line. (FIG. 1D)
 - Caution: Make sure to follow the cutout line otherwise the sink may not properly fit or be adequately supported.
 - Brace the portion of the cutout to be removed to avoid damage to the edge of the cutout and the jig saw as the cutout separates from the countertop.

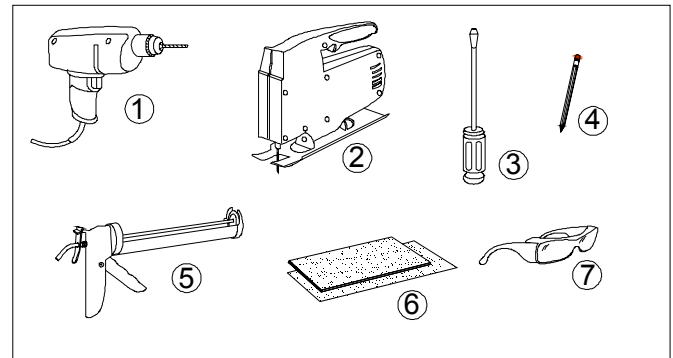


Figure 1A

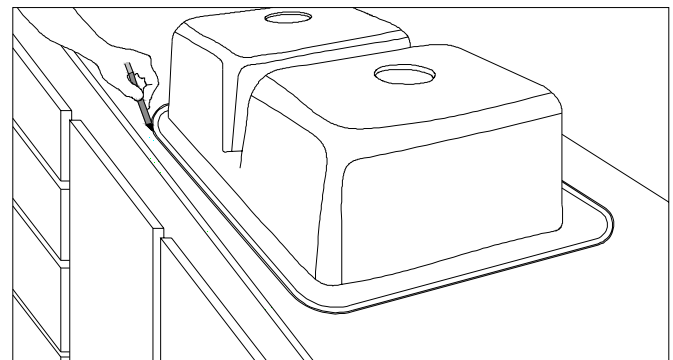


Figure 1B

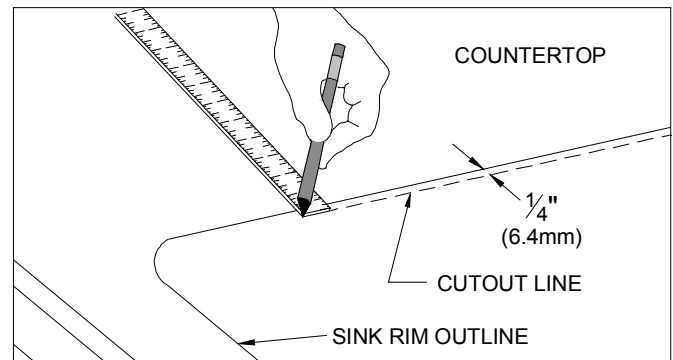


Figure 1C

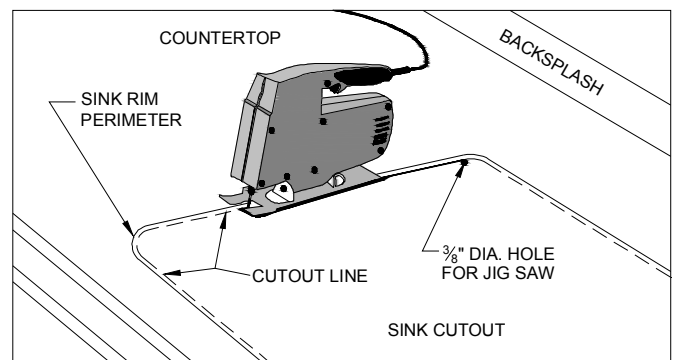


Figure 1D

Durasteel™ Self-Rimming Sink Installation

Sink Installation

- Apply an $\frac{1}{8}$ " to $\frac{1}{4}$ " bead of 100% silicone around the entire cutout approximately $\frac{1}{4}$ " from the edge of the cutout. (FIG. 2A)
 - Caution: Excessive silicone will cause difficulty to properly seal the sink cutout and clean up.
- Prior to setting the sink, install attaching hardware into the securing channel under the rim of the sink.
 - 3 along the front and back
 - 2 along both sides
 - Thread screws into clamps as indicated in FIG. 2B
 - Slide screw head into channel from either open end and turn clamp side ways to clear edge of the cutout.
- Place sink into cutout and position clamps at each end of the channel and one in the center along all the front and back.
- Hand tighten clamps working from the center out.
 - Make sure to check sink is still positioned correctly.
- Tighten all clamps, working from the center out, an additional quarter turn with the slotted screwdriver. (FIG. 2C)
 - Do Not over tighten
 - Over tightened clamps can warp the sink causing an uneven appearance and an inadequate seal.

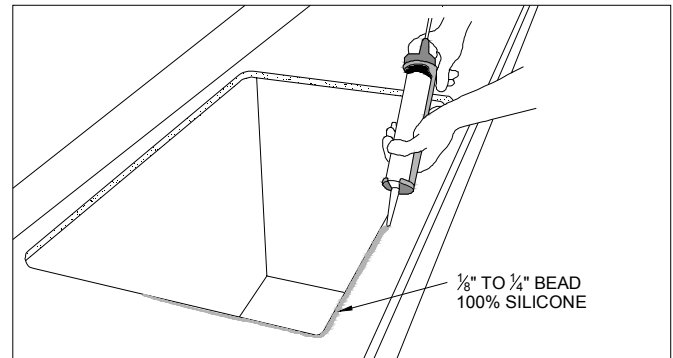


Figure 2A

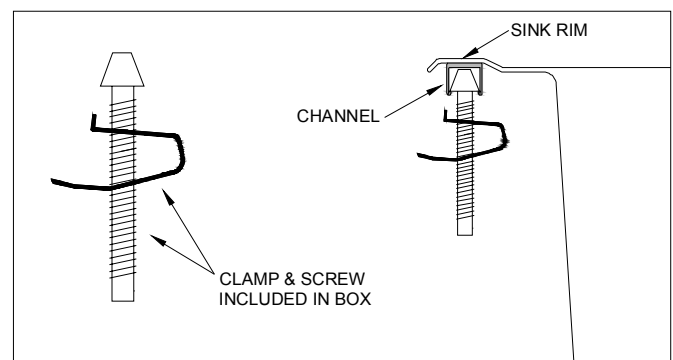


Figure 2B

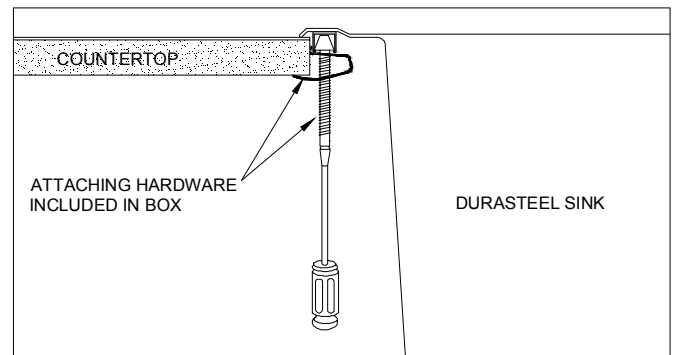


Figure 2C

Durasteel™ Undermount Sink Installation

Suggested Materials

There are various methods to attach a Durasteel undermount sink to a hard surface countertop. Wilsonart suggests the following materials and tools for conventional fabrication to supply a properly installed stainless steel sink.

For automated routing equipment, please visit the Wilsonart B2B website or contact your local Wilsonart distributor representative for Durasteel sink DXF files.

Materials

- Support clip (FIG. 3A)
 - Included in sink box
- Sink clip base plate and wing nut (FIG. 3A)
 - www.rotaloc.com
 - www.specialtytools.com
- 100% Clear Silicone (FIG. 3B)
- Seam Kit dispensing gun (FIG. 3B)

Tooling

- Routers (FIG. 3C)
 - 3½ HP with ½" (13mm) collet
 - 1½ HP with ½" (13mm) collet
- General Router Bits (FIG. 3C)
 - 1" (25.4mm) Top bearing flush trim bit
 - Rounding over bit ¼" (13mm) max.
- Jig Saw (FIG. 3D)
- Sanders
 - Random Orbital (FIG. 3D)
 - Dust collection system (suggested)
 - Sanding Disks (Micron)
 - Scotch-Brite® pads
- Clamps

NOTE: You may require different, more specialized tools to install this sink to countertop materials other than Wilsonart Solid Surface. Refer to countertop material manufacturers recommendations.

WARNING: When using electrical tools, please use caution to prevent electrical shock.

CAUTION: Always follow product, equipment and/or tool manufacturer's recommendations and instructions carefully.

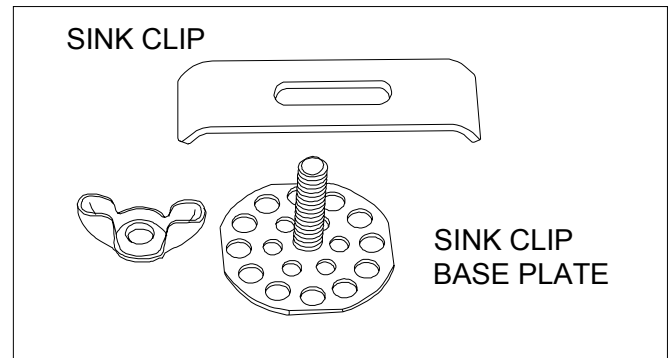


Figure 3A

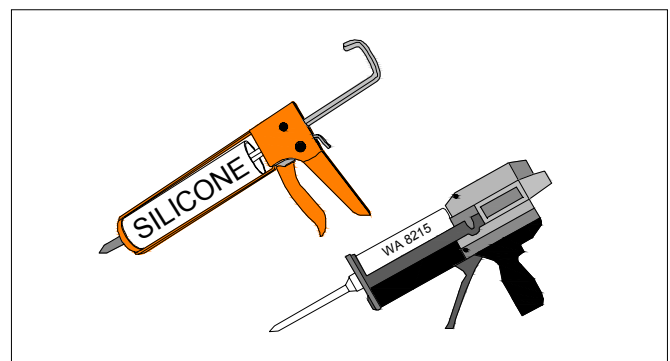


Figure 3B

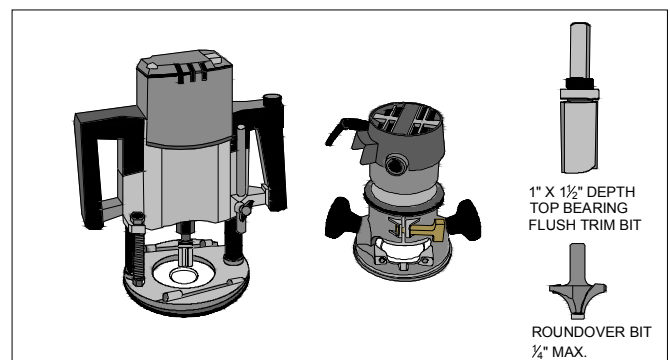


Figure 3C

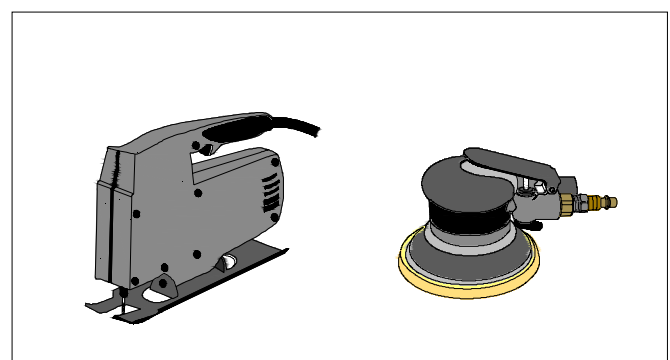


Figure 3D

Durasteel™ Undermount Sink Installation

Before You Begin

- Please refer to the Wilsonart Durasteel Sink Warranty for complete coverage details.
- For automated routing equipment, please visit the Wilsonart B2B website or contact your local Wilsonart distributor representative for Durasteel sink DXF files.
- Observe all local plumbing and building codes.
- Prior to installation, unpack the new sink and inspect it for damage. Return the sink to its carton until you are ready to install it.
- Plan the sink installation so future removal from underneath the countertop is possible without damaging the countertop.
- Multiple-bowl installations
 - A minimum distance of $3\frac{3}{8}$ " (8.6 cm) is required between the cutouts.
 - Additional countertop support is required between multiple-bowl installations.

Sink Template (Conventional Fabrication)

- The template should be constructed of flat, sturdy material such as MDF or phenolic board.
- The length and width should be sized to adequately support a $3\frac{1}{4}$ hp router.
- Pencil alignment cross hairs on the center of the template material.
 - Include both vertical & horizontal alignment marks. (FIG. 4A)
- Using the paper template provided in the sink box, select type cutout desired. (FIG. 4B)
 - Flushmount installation, use paper template as provided.
 - Reveal type installation, remove the perforated outer edge.
- Align paper template with penciled cross hairs on the MDF or phenolic board template material and trace outer edge. (FIG. 4C).
- Cut along the penciled outline of the cutout. (FIG. 4D)
- Using 100 micron (150 grit) sand paper, smooth the edges of the template.

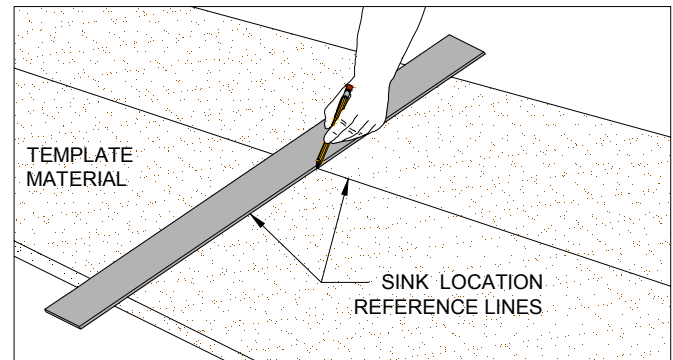


Figure 4A

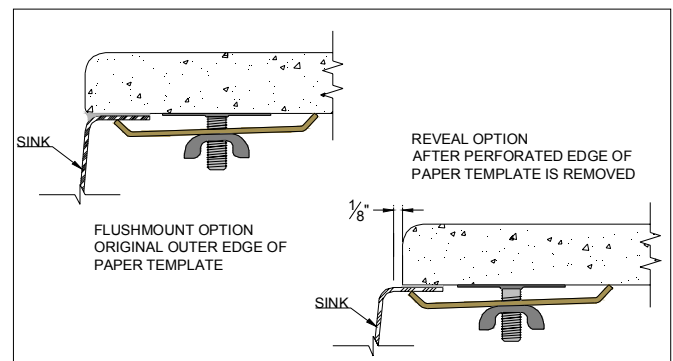


Figure 4B

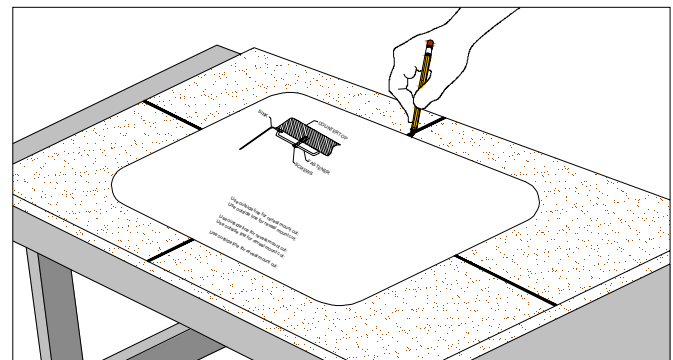


Figure 4C

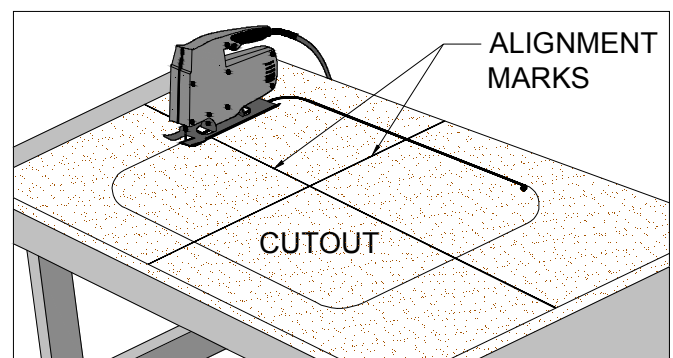


Figure 4D

Durasteel™ Undermount Sink Installation

Sink Cutout

- Locate where sink is to be installed on the top side of the countertop and draw reference lines. (FIG. 5A)
- Align the cross hairs of the sink cutout template with the reference lines on countertop.
 - Fasten template securely to the countertop.
- Index a 3¼ HP or 2½ HP plunge router with a 1" x 1½" top bearing flush trim router bit. (FIG. 5B)
- Route along templates in the direction indicated. (FIG. 5B)
- Once completed remove sink cutout template.
- Profile top side of cutout.
 - Do not exceed ¼" radius for ½" thickness.
- Sand the edge of the cutout with a random orbital sander. (FIG. 5C)
 - Begin with 180 grit (80u micron)
 - Continue with 220 grit (60u micron)
 - Keep sander moving to minimize the chance of dips or over sanding one area.
- Finish sanded area with a gray 3M® Scotch-Brite™ pad.
 - Use only light to medium pressure in a circular motion.
- Flip countertop over facing down.

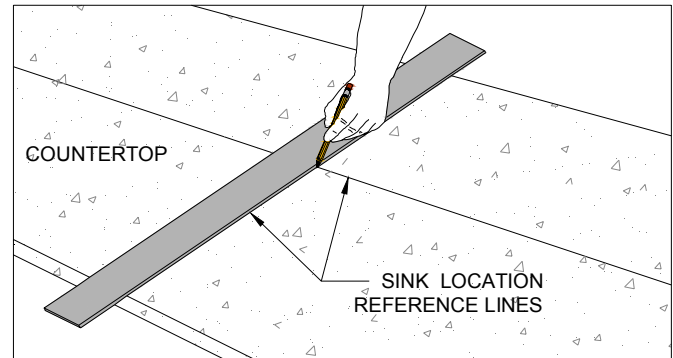


Figure 5A

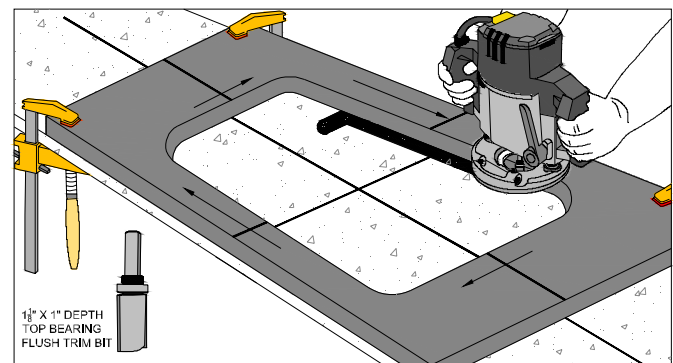


Figure 5B

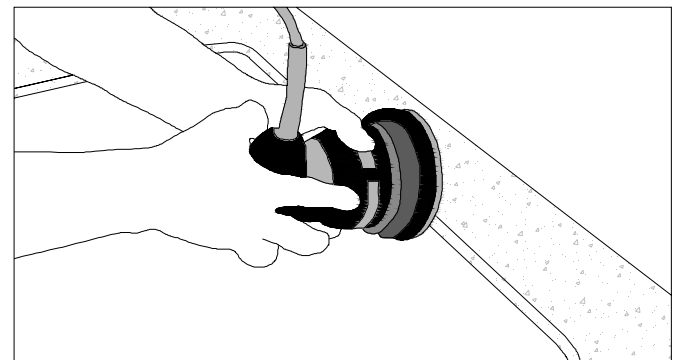


Figure 5C

Durasteel™ Undermount Sink Installation

Sink Installation

- Position and align sink over sink cutout.
- Locate sink clip bases around perimeter of sink flange and mark location with pencil. (FIG. 6A)
 - Equally space sink clip base plates along length and width of sink flange.
 - Locate base plates to allow sink clips to contact center of sink flange or closer to the sink well.
- Clean under side of countertop around sink perimeter with a nonabrasive cleaner. (FIG. 6B)
 - For solid surface use denatured alcohol and clean white cloth.
 - Do not use lacquer thinner, acetone or other solvents.
 - Colored or printed towels will contaminate the seam material and cause a weak or stained bond line.
 - For stubborn residue use a Scotch-Brite® pad and denatured alcohol.
- Apply ample WA 8215 where base plates were marked. (FIG. 6C)
- Place sink clip base plates into WA 8215. (FIG. 6D)
 - Insure WA 8215 completely covers base plate.
 - Apply additional WA 8215 as necessary to cove entire base plate.
- Allow adhesive to cure complete before continuing.

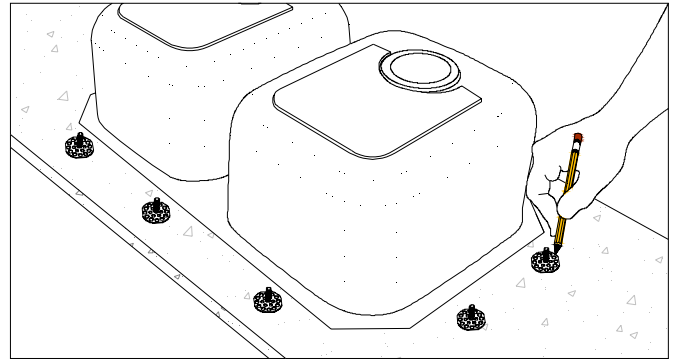


Figure 6A

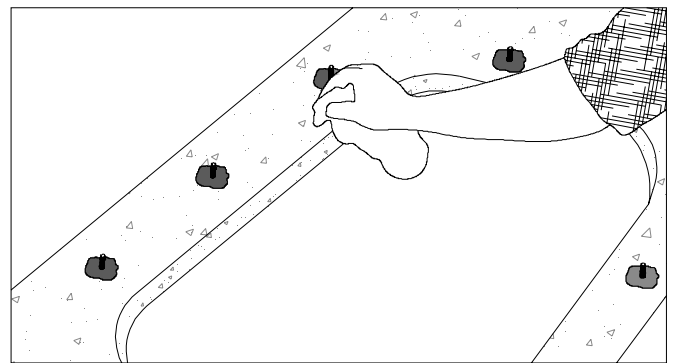


Figure 6B

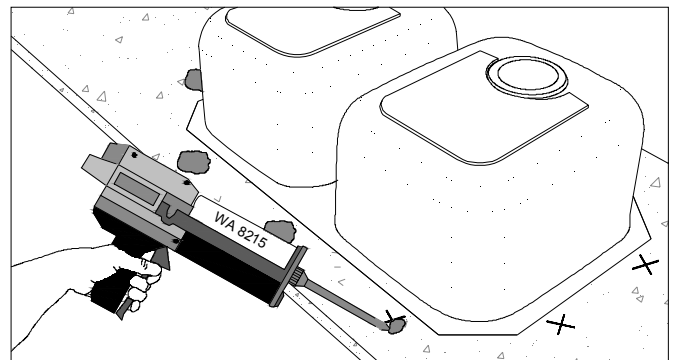


Figure 6C

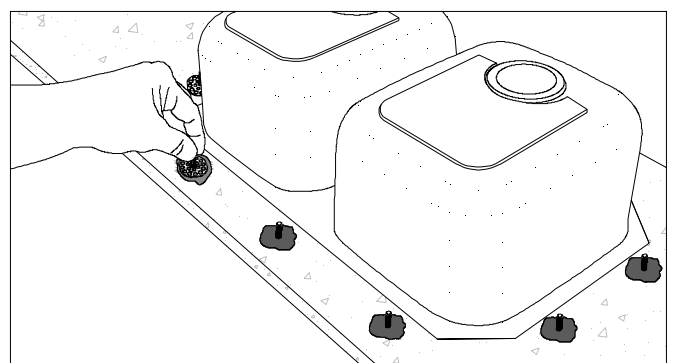


Figure 6D

Durasteel™ Undermount Sink Installation

Sink Installation

- Clean top of sink flange with denatured alcohol and clean whitecloth.
 - Make sure the surface is smooth, clean, and free of defects. (FIG. 7A)
- Apply a generous bead of 100% clear silicone to the top surface of the sink rim. (FIG. 7B)
 - To insure adequate seal, apply sufficient silicone to allow squeeze out around inside and outside sink perimeter.
- Reposition and align sink over sink cutout.
- Check the alignment of the sink with the cutout. Then securely tighten the clamps. (FIG. 7C)
 - Tighten only hand tight.
- Wipe away any excess silicone, and fill any voids as needed.
- Allow the silicone to cure before proceeding.

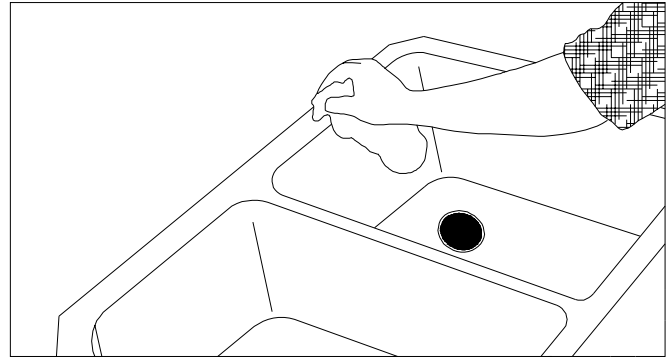


Figure 7A

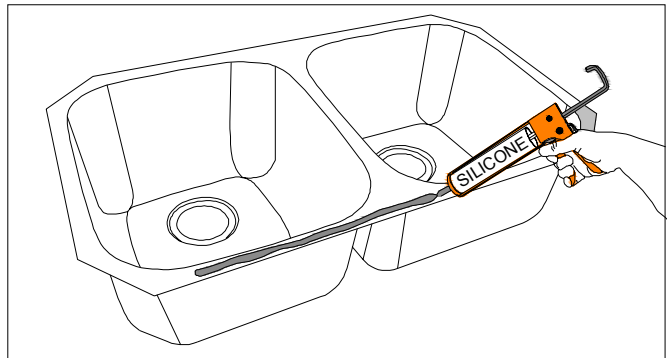


Figure 7B

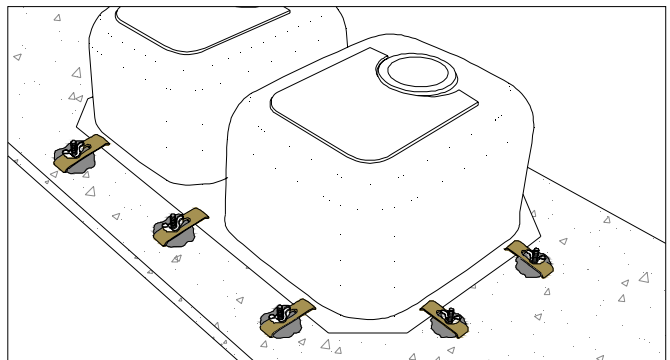


Figure 7C