



Any fabrication procedure or technique not contained within the Wilsonart® Solid Surface Fabrication Manual will not be recognized by Wilsonart, LLC as an approved method of fabrication. Deviations from these techniques must be approved in writing by a Wilsonart Representative.



## General Safety:

Safety is a critical concern for any shop and key to 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 are the responsibility of the facility owner and the shop employees.

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

- Read directions carefully before fabricating/installing Wilsonart® Solid Surface.
- Read and follow the instruction manual before operating the different tools.
- Keep all guards in place and in working order.
- Ensure 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. 4A & 4B)
- Wear the proper apparel, no loose clothing or jewelry.
- Secure all work with the proper clamp or vise 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 used when cutting, routing and sanding. Tools should be used with dust collection at all times.



Figure 4A



Figure 4B

# INTRODUCTION

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For installation of the Wilsonart® Solid Surface Farmhouse Sink, Wilsonart recommends a soft seam undermount. For the best installation results, cabinet preparation and support are required. During the entire fabrication and installation process, proper support should be applied to the thin portion of countertop located behind the sink.

## TOOLS REQUIRED

- Safety glasses
- Tape measure
- Level
- Jig saw
- Router
- Sander
- 2" (51 mm) spring clamps
- Caulk gun
- 36" (914 mm) bar clamps (3)

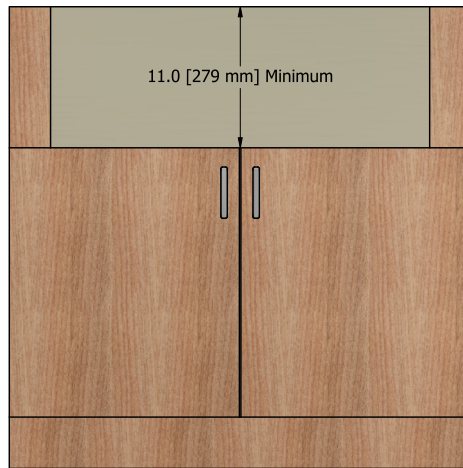
## CONSUMABLE SUPPLIES REQUIRED

- Masking tape
- Construction adhesive
- 1" x 4" x 36" (25 x 102 x 914 mm) pine board
- 2" x 4" x 36" (51 x 102 x 914 mm) lumber (2)
- 12" x 20" x ½" (305 x 508 x 12 mm) plywood (2)
- 1" (25 mm) drywall screws (16)
- 2" (51 mm) drywall screws (18)
- Template sheet (cardboard or heavy paper)

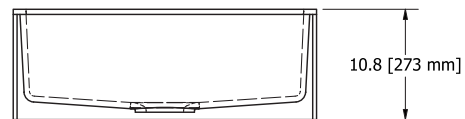
# PREPARATION

## SINK FIT

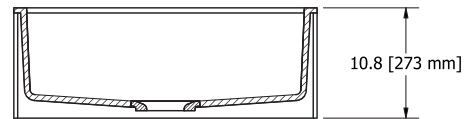
- The Wilsonart® Solid Surface Farmhouse Sink is intended to mount under the countertop as an apron sink base on the cabinets.
- The cabinet apron must be higher than the height of the farmhouse sink apron.
- It is recommended by Wilsonart that the sink base should be at least 33" (840mm) or wider.
- Installation on a 30" sink base requires in-depth alterations to the side wall, making this size sink base highly discouraged.



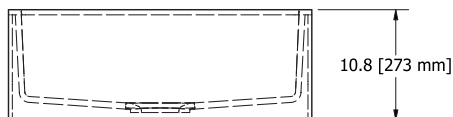
**Figure 7A**  
"Apron" type Sink Base Cabinet



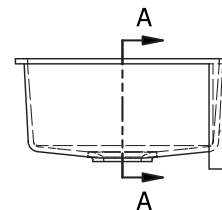
REAR VIEW



SECTION A-A



FRONT VIEW



END VIEW

**Figure 7B**  
Wilsonart® Solid Surface Sink

# PREPARATION

## TEMPLATE

Due to each sink having its own slightly unique shape, you must create your own template for each farmhouse sink installation by setting the sink front-face down and tracing the sink dimensions onto the material.

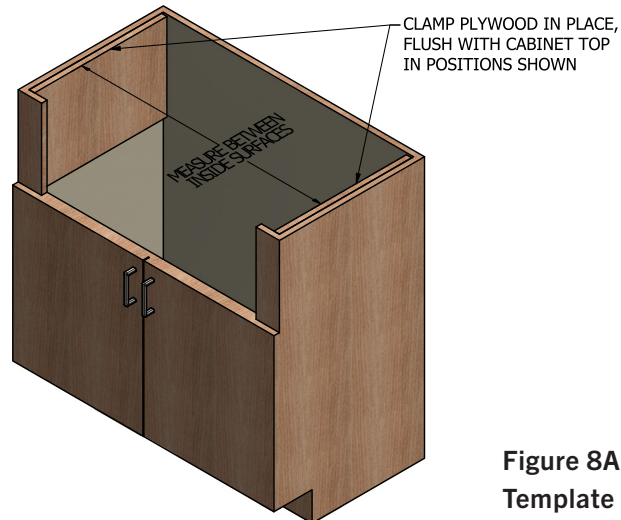


Figure 8A  
Template Example

## CABINET WORK FOR THE APRON

To protect from scratching and scuffing during fabrication, adhere a painter's grade masking tape to the front face of the cabinet where the template will be cut.

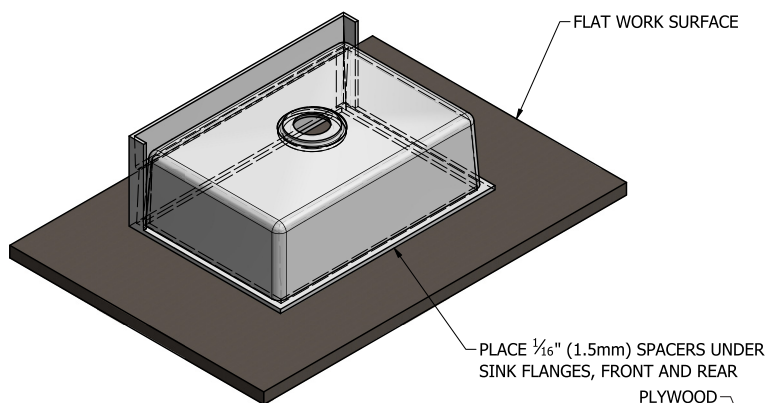
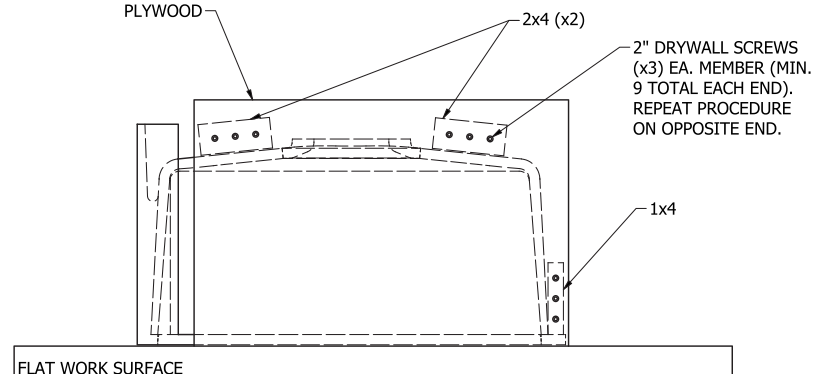


Figure 8B  
Painter's Tape Example





# BUILDING A CRADLE

## CABINET WORK FOR THE APRON CONTINUED

- Ensure that the template is centered to the cabinet face.
- To make sure the sink will reside  $1/16"$  (1.5 mm) below the bottom surface of the countertop, we recommend placing the top edge of the template  $1/16"$  (1.5 mm) below the top edge of the cabinet.
- Allow for edge buildup when measuring and account for any additional thickness during the templating phase.
- It is always better to cut a smaller opening at first, allowing a gradual change in size rather than cutting too large of an opening.

## BUILDING A CRADLE

Due to the Wilsonart® Farmhouse Sink's weight and size, we recommend supporting the sink with a cradle made from plywood and 2 x 4s. The following steps are to assist in the cradle assembly:

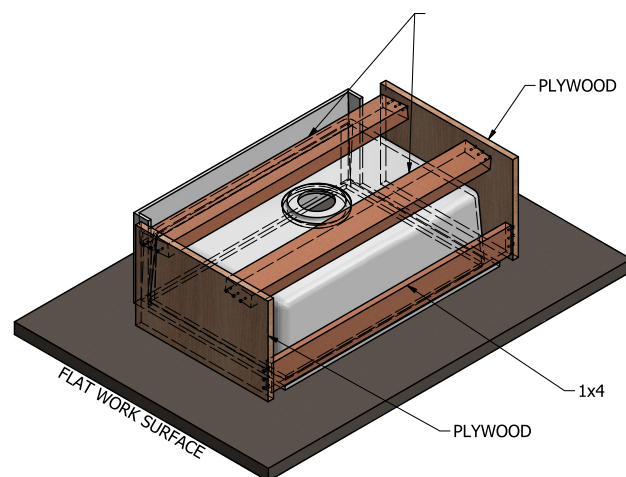
**Step 1:** Cut two pieces of  $\frac{1}{2}"$  (13 mm) thick plywood 12" x 20" (305 mm x 510 mm)

**Step 2:** To make sure the plywood is flush to the top of the cabinet, create clearance notches for future cabinet hardware

**Step 3:** Clamp the plywood pieces to the insides of the side walls

**Step 4:** Measure the distance between the insides of the plywood

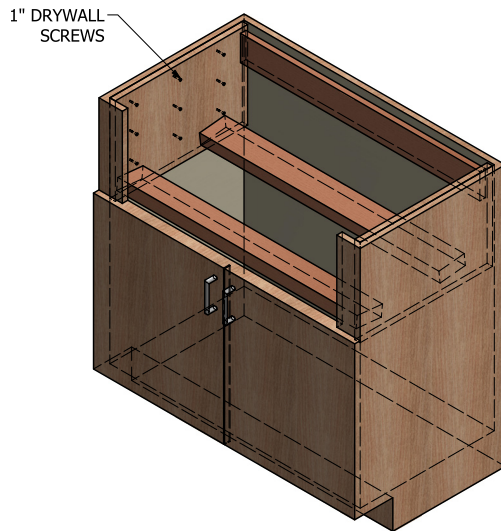
**Step 5:** Cut two 2 x 4s and one 1 x 4. About  $1/16"$  shorter than the inside dimensions.



**Figure 9A**  
**Cradle Example**

# BUILDING A CRADLE

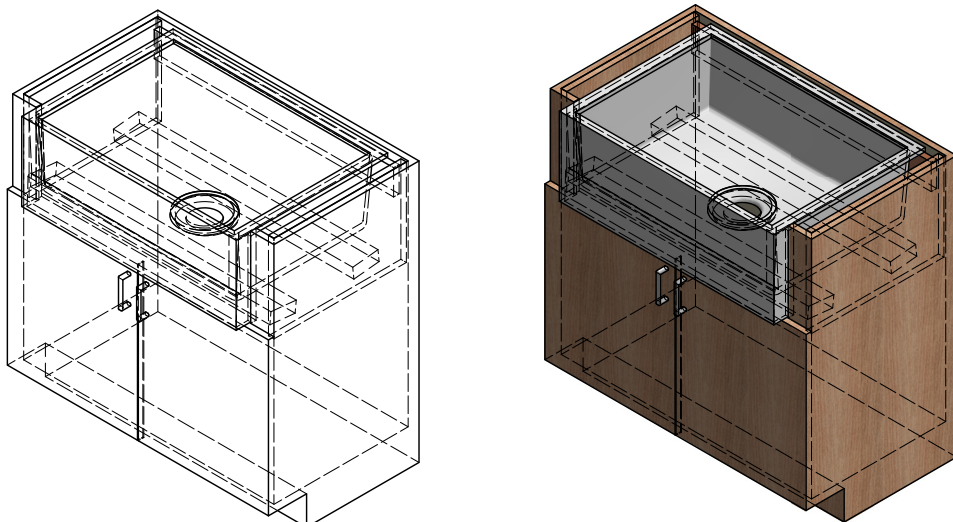
To leave a gap for silicone during countertop installation, lay the sink upside down on a table and place a 1/16" spacer under the flange.



**Figure 10A**  
**Use of Spacers Example**

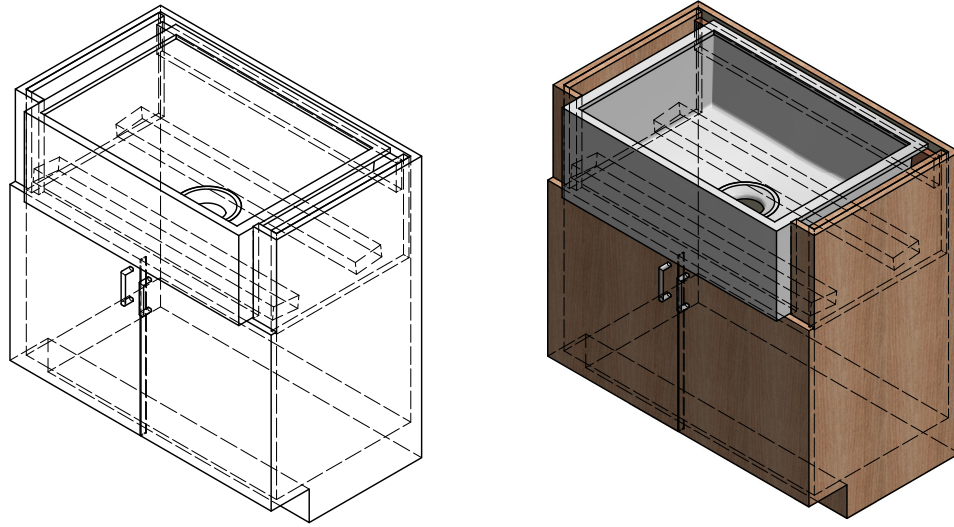
- Place the plywood removed from the cabinets on either side of the sink and set the previously mentioned 2 x 4s on the bottom of the sink.
- Using bar clamps, secure the 2 x 4s to the plywood and make sure they are leveled.
- Next, take the 2" (51mm) dry wall screws and assemble the pieces by following Figure 6B and 7A.
- Place the 2 x 4s far apart to allow drain hardware access, especially if a disposal will be installed.

**Figure 10B**  
**Assembly of Pieces**





# BUILDING A CRADLE



**Figure 11A**  
**Assembly of Pieces**

- To attach the cradle to the cabinet, use construction adhesive and apply a thin layer to the inside cabinet walls.
- Next, slide the cradle in the correct position and use spring clamps to hold it in place.
- Use 1" (25 mm) drywall screws on the cradle for added support.
- When finished, remove any extra adhesive.

## SINK INSTALLATION

- Check to see if the sink fits in the cabinet and make changes where needed.
- Create marks where the countertop will cover the top flange, as well as where the front apron will be exposed.
- To remove any sharp edges from the exposed front rim, use a router to sand the rounded edges as needed.
- Remove the sink during sanding and routing so there is no damage done.
- Add several dots of silicone where the sink will sit on the 2 x 4s.
- Next, put the sink in place and add a bead of silicone where the sink will be covered by the countertop.
- Once the countertop is installed, clean up any excess silicone.
- Apply silicone around the perimeter of the apron and at the cabinet face.
- Finally, clean any excess silicone and allow it to set.

# INSPECTION CRITERIA

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Every effort has been made to supply high quality materials, free of defects. However, the fabricator must conduct a final (pre-cut) inspection for color match, manufacturing defects or damage to continue the quality control process prior to fabrication. Wilsonart® Solid Surface sheets are color matched by lot numbers only. Lot number is located on edge of sheet material.

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