

FabShop by Cambria

Integral Sink Drawing and Fabrication Requirements SOP # 9.2.2.N

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Objective

This document defines drawing requirements and fabrication limitations specific to having an integral solid surface sink placed onto a Cambria countertop piece.

Note: Only solid surface sinks can be used for this process. No hybrid, porcelain, stainless steel, composite granite or etc. sinks can be used

Note: Sinks that are a combination of solid surface material and fiberglass cannot be used for this process

Procedure

1. The sink must be solid surface material that is capable of being blended smooth to the Cambria countertop cutout.
 - a. Radii on the top of the actual sink are not allowed. Sink bowl and sink flange must be perpendicular with no ease or radii.
2. Integral sink are available in 2cm and 3cm thicknesses only.
3. Integral sinks will be adhered to the Cambria countertop at the Cambria FabShop.
 - a. **CIA must insure that the countertop and sink combination can be installed without damage being caused to the Cambria, sink or jobsite.**
4. The integral sink will also have fasteners (nutserts, sink clips and appropriate hardware) already in place on the fabricated countertop.
 - a. CIA must determine and specify on the submitted fabrication drawing the location of the sink fasteners to eliminate interference with existing cabinetry or supporting structure. A separate layout tab in AutoCAD will be created specifically for this callout. See Figure 1.

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Figure 1

- i. Refer to SOP 9.3.3 Installation Requirements for Cambria for recommended fastener location.
5. The Cambria countertop cutout and solid surface sink will be blended to each other which may result in subtle impacts to both the sink cutout and the sink.
6. Inside corner radius
 - a. 1/2" minimum
 - b. Inside corner radii are available in 1/16" increments from 1/2" to 1 7/16".
 - i. These radii are done by hand-work for an additional fee. In addition, the following statement must be included within the cutout, "Small inside radii, Cambria Hand Polish".
 - ii. One hour of handwork time will be charged per integral sink with small radii.
7. Available Profiles;
 - a. Tapered
 - i. This polished profile will have a 1/8" top radius and a 3°-6° taper after fabrication. See Figure 2.

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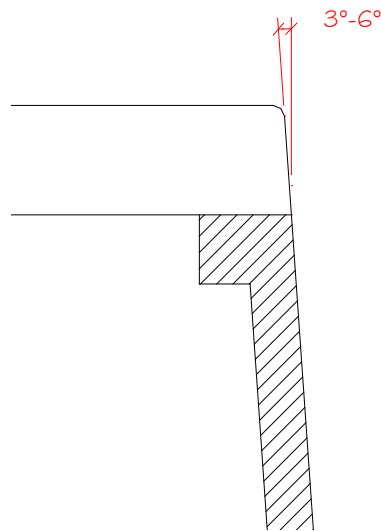


Figure 2

8. The solid surface sink **must be measured exactly** by the CIA and **the exact geometry will be submitted at actual size** to ensure the countertop or sink are not negatively affected during the fabrication process. The **exact geometry** will be the digital template that is placed on the Cambria countertop drawing and that the CNC will use as a tool path.
9. The CIA will label the cutouts on the drawings per SOP 9.2.2 with the additional information added to the cutout; “Integral Sink / Cambria to hand polish). Integral Sink Application must also be stated on the layout. See Figure 3.

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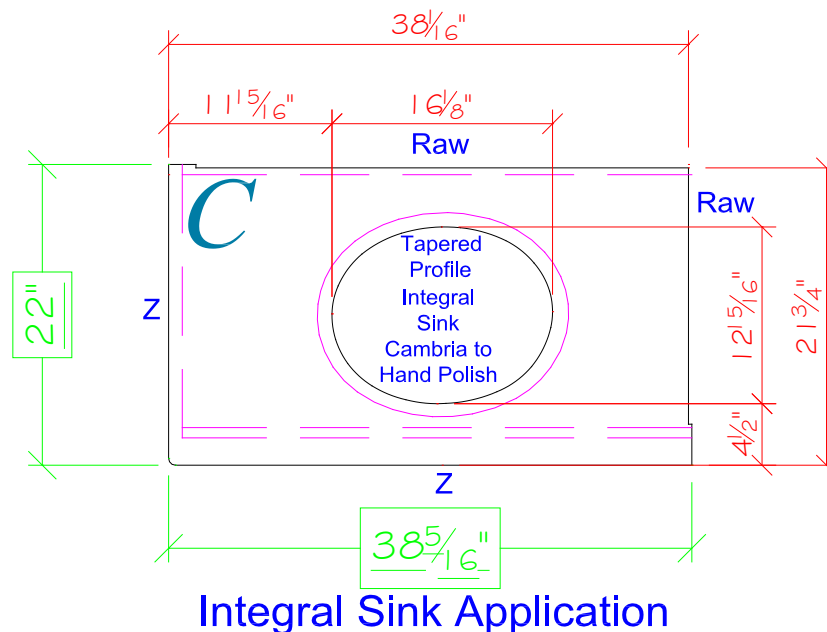


Figure 3

10. The actual sink will be provided to the Cambria FabShop once the drawing has been submitted.

Note: Job will not be dated until the actual sink arrives at the Cambria FabShop and verification of size has been completed. The following information must clearly label on the sink box and or actual sink.

- a. Cambria Job # or CIA PO #
 - b. CIA information along with piece information sink will mount to.
 - c. Overall size of sink as well as template date and sign off by CIA.
11. The Cambria FabShop will verify the size of the template vs. the actual sink.
 - a. If template is acceptable, job will be moved into production.
 - b. If template is not acceptable;
 - i. CIA can measure the sink at the Cambria FabShop location.

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1. Updated sink template will be placed onto the revised Cambria AutoCAD drawings and submitted for approval.
 - ii. Sink can be shipped back to the CIA for measuring.
 - iii. Updated sink template will be placed onto the revised Cambria AutoCAD drawings and submitted for approval.