



**BB** encore  
installation instructions



Mocha Stone  
breakfast bar.





Thank you for choosing Encore. You have made an excellent choice and we know you will be proud of the result you will be able to achieve for your clients.

The big idea with Encore was to provide beautiful and desirable worksurfaces at affordable prices.

Pretty obvious really!

But the problem with traditional solid surface is that so much of the value is in artisan templating, fabrication and installation by specialist third party companies. So the retailer waits for the delivery, the customer pays more and the traditional kitchen fitter loses out.

The trick was to invest in quality manufacturing; and we did to the tune of £1.5million, but equally important, to ensure that we could build on traditional fitting skills to deliver best value for everyone including the fitter. The unique and exclusive nature of Encore's 5mm reinforced surface provides a great technical foundation to do just this.

So the consumer pays less, the retailer creates more value and the fitter develops more earning potential. It can't be that simple can it? Read on.

### **Getting started**

All professional kitchen installers have the skills to install Encore. If you're regularly installing laminate worktops to a high standard, the move to Encore is straight forward. As with any new product the best advice is held in the instruction guide. Please take the time to thoroughly read this guide before starting work taking special note of the tooling necessary especially for the sanding stages and our advice on checking the worktops for colour compatibility before commencing installation. Time spent understanding Encore's simple processes now will ensure a delighted customer later!

We run regular training days at our Northamptonshire factory. These days are free and include lunch and a factory tour. Please call 01933 232 272 for more details and dates.

Front cover:  
Mountain Haze breakfast bar with  
an Encore one and a half bowl white  
acrylic sink and straight drainer  
grooves.

# before you start

When working with Encore we strongly recommend relevant personal protection equipment is used.

## Temperature conditioning

Encore is reinforced and compression moulded to 1200 tons; producing a material that is both stable and tolerant during fabrication. However you must ensure your Encore is brought up to room temperature before commencing installation. Harmonising Encore to room conditions ensures a stable product suitable for fabrication and adhesion. This is especially true during the winter months where transit to site may lower the storage temperature below the recommended level. Ensure that all Encore materials are stored in line with the instructions and brought to room temperature of at least 18°C before commencing work. This may mean delaying fitting for up to 24 hours in the winter. Should incorrect storage cause a slight bow in the worktop, this is usually remedied by correct storage of the worktop face down until the correct temperature is achieved.

## Colour compatibility

It's a feature of all solid surface products that on occasion there may be a slight variance in colour between components. A simple final colour check by the installer is necessary immediately prior to installation; clearly the best place to accept the components for installation is the final room and lighting conditions.

Every worktop arrives with a polythene protective coating, this should be fully removed. Open your installation kit and sand a small area on each component using a random orbital sander and a scotchbrite pad. After removing any dust apply a coat of Professional Worktop Polish and compare to adjacent components.

Should the materials appear to have an unacceptable colour variance, please **do not** commence installation. Contact us for advice (01933 232 272): we will endeavour to resupply materials as rapidly as possible. By continuing to install your worktops you confirm that the materials are acceptable. Claims for subsequent reinstallation labour charges cannot be met.

## Ice – Mountain Haze – Mocha Stone

The nature of these marbled designs is that joints will be more obvious than non-directional designs. At joints a seamless finish is achievable, but the nature of the design may make joints more obvious; this is not a fault, but a feature of the directional nature of the design. Colour will vary within the design along

each worktop and at joints a change in colour between two worktops may be more obvious; this is normal and is not considered to be colour variance.

## Layout and design considerations

Encore worktops are available at 27mm or 44mm thick. Consideration should be given to wall unit heights where a design includes both tall housings and dresser units. Advice should be sought from the furniture supplier.

**Belfast, butler or undermount ceramic sinks:** Encore should never be used around a Belfast or butler sink. Similarly ceramic undermount sinks must not be used. You may however use traditional inset ceramic sinks.

**Agas:** allow a 50mm gap between the edge of an Encore worktop and a heat retaining appliance like an Aga. However freestanding or large range cookers need no allowance.

**Maximum unsupported span:** the maximum unsupported span between units is 800mm. Larger spans should use support legs or end support panels, especially between two freestanding appliances. Side by side integrated appliances are acceptable to a maximum span of 1200mm.

## Health and Safety

Encore materials are not known to be associated with any hazards. Safety data sheets are available on request; please call our customer service team.

We recommend sensible health and safety precautions are taken when working with Encore materials. Ensure adequate dust extraction and ventilation when cutting, sanding and using adhesives and solvents.

We strongly recommend relevant personal protective equipment is used:

- Dust mask: when cutting, routing, gluing and sanding.
- Safety goggles: when cutting, routing, gluing and sanding.
- Protective gloves: when using denatured alcohol and adhesives.

## Storage and handling

Please consider the weight of Encore before handling and allocate sufficient manpower. Always carry worktops long edge up and never flat. Take extra care

once a worktop has a sink or hob cut-out. Consider bracing the weakened area with a sheet of MFC and G-clamps to provide extra strength.

Ensure Encore worktops are stored in a dry, well-ventilated area at above 10°C. Store Encore worktops face up, on a flat surface using batons 100mm in from the ends and every 1000mm. Never store Encore worktops on their factory edges.

## Planning for joints

To achieve a secure and inconspicuous joint ensure that carcasses are perfectly aligned, levelled and well secured.

Positioning of joints is important, both designer and installer should consider the following:

- Always try to plan worktop runs and joints to enable ease of assembly with bolts and jointing biscuits.
- Joints should run away from sink or hob cut-outs wherever possible: avoid running the joint alongside the cut-out. Where a joint runs alongside a cut-out, it is recommended that the cut-out be offset by at least 100mm to ensure worktop bolts are fully seated.
- Joints must not extend through sink or hob cut-outs. Similarly joints must not extend through undermount sink draining areas. Try to avoid situations where draining boards extend into a corner. Never cut drainer grooves through joints.
- Joints must not be formed over heat radiating appliances, dishwashers or washing machines.
- When forming diagonal corner solution joints ensure that the 135° angle is bisected and all void wall areas are battened for adequate support. Never insert a wedge at the front edge of a 90° corner to produce a diagonal solution.

# product data

Encore's unique structure and 5mm surface gives it great performance characteristics.

## Composition

Encore face material: 5mm reinforced solid surface – colour consistent through its entire thickness.

Core material: PEFC environmentally preferred chipboard to BS EN312:2010  
Rear face: decorative white high pressure laminate to BS EN438

Rear face 2050mm worktop: decorative laminate in plain colour complimenting the face to BS EN438

## Sizes for 44mm Encore

### Worktops

4100 x 650 x 44mm finished on 3 edges  
Weight approx. 83kg

3000 x 650 x 44mm finished on 3 edges – available in four decors only - Weight approx. 65kg

2050 x 650 x 44mm finished on 1 edge  
Weight approx. 42kg

## Sizes for 27mm slimline Encore

4100 x 650 x 27mm finished on 3 edges  
Weight approx. 64kg

2050 x 650 x 27mm finished on 1 edge  
Weight approx. 42kg

## Breakfast bar

2400 x 900 x 27mm breakfast bar  
Finished on two long edges and one short, plus a 1050mm radius bow end at the other end. Simply choose the end that works best with your design. Usable long edge length 2294mm. Weight approx. 50kg

## Island worksurface

2400 x 1200 x 27mm Island worktop  
Finished all four edges – available in Ice/Mountain Haze/Mocha Stone only - Weight approx. 65kg

## Upstand

3600 x 100 x 12mm solid 12mm thick Encore upstand. Sand prior to bonding to wall. Weight approx. 7kg

## Splashbacks

Solid 5mm thick Encore sheet. Sand prior to bonding to wall.

4100 x 600 x 5mm midway height. Weight approx. 18kg

1200 x 1200 x 5mm hob panel. Weight approx. 10kg

## Edging strips

### All 44mm decors

#### Straight edge strips

2400 x 5mm

1350 x 5mm

#### Radius and curve edge strips

1350 x 1.7mm

### All 27mm decors

One edge strip size for all straight, radius and curve ends

1350 x 45 x 1.7mm

## Adhesives

### Encore colour coded seaming adhesive: two part 50ml

Requires the reusable Mixapak gun available from your supplier (Encore part no. 460066). One 50ml cartridge will complete either:

- Two 650mm joints or two 650mm edge strips or one of each
- One 900mm end
- One 650mm radius end
- One 1200mm end
- One mitred slab end panel joint
- Two 650mm splashback seamless joints.
- One undermount Encore acrylic single bowl sink, add an extra half a cartridge for a one and a half bowl sink. (use adhesive matching the worksurface not white)

Do not use to undermount stainless steel sinks.

Do not use to fix and seam upstands or splashbacks.

### BB Complete adhesive – one part 290ml

Use your standard mastic gun.

Used for general sealing and installing stainless steel undermount sinks.

Do not use in place of Encore seaming adhesive.

Do not use for acrylic sinks.

## Encore Installation Kit

The boxed Encore installation kit includes all necessary materials to install one kitchen:

Solvents to cleanse prior to applying adhesive, all sanding materials, aluminium hob tape and professional worktop polish and cloths. You should allow one kit per installation. The kit does not include adhesives or jointing bolts.

## Consumer Care Kit

A handy under sink bag containing buffing materials, Bushboard Professional Worktop Polish and our care leaflet. We advise a home owner buys one to help keep their Encore worktops looking pristine. The kit includes Scotchbrite sponges to help remove scuffs and scratches.



Glacier White worksurface with a slab end. Shown with an Encore one and a half bowl white acrylic moulded sink and straight drainer grooves.

# essential installation tools & materials

The use of good tools will ensure a superior, professional finish.

It is vital that the installer uses the correct hand tools of the correct power rating for the job. Failure to do so will degrade the final finish and extend the completion time.

**Random orbital sander** with integrated vacuum dust extractor: to sand worktop, splashback and upstand faces a sander of the correct power rating is vital. Use one rated at least 500watts power with a 5mm sanding stroke. The base should fit 150mm round discs. We recommend running the sander at 8500rpm on 180grit and moving up to 11000rpm for finer grits (we recommend: Festool ROX150FEQ)

It is vitally important that the sander is used with a vacuum dust extractor. Failure to do so will create unmanageable levels of dust whilst quickly clogging the sanding discs degrading the final finish.

**Palm sander** also with integrated vacuum dust extractor: to sand edges where a random orbital sander is too unwieldy or aggressive. As with the random orbital sander the palm sander should be of good quality rated at 500watts power and a 2mm sanding stroke.

**Hand held circular saw:** a circular saw is ideal to cut Encore to size. Use a good quality saw with at least 1600watts of power and at least a 65mm cut depth capacity. Use good quality, sharp, tungsten carbide triple chip tooth blades.

Circular saw cut edges are perfect as the final cut edge - Encore cannot crack or chip around saw cuts following installation. There's no need to router cut or power plane the cut face smooth.

**Jigsaw:** a jigsaw is ideal for forming sink and hob cut-outs and scribing around boxing or sockets. Because Encore is reinforced the cut edge cannot crack, simply use the saw as you would with laminate worktops. Use a jigsaw of at least 650watts with an adjustable pendulum action. Use only Bosch blade T127D which is readily available and will cut 4 meters of Encore.

**Edge trimming and profiling:** after applying an edge strip, the resulting edge will need trimming back and re-profiling. Whilst this is possible with a palm sander we strongly recommend use of a trimmer for a professional finish. We recommend use of a power trimmer for a professional finish. We recommend a straight fixed tip-guide cutter for trimming back flush (Titman BGT90S or Trend C116) or a 3mm cutter to replicate the 44mm worktop factory profile. (Titman ROCB3 or Trend C074)

**Hand router:** joints cut in Encore are identical to laminate; it is therefore highly likely that your existing router is perfect for the job. Use a variable speed router of 2000watts power rating. Use high quality double-flute, tungsten carbide tipped cutters running at around 18,000 rpm: one cutter should cut 10 meters of Encore before replacement.

**Worktop jointing jig:** use your usual worktop jig in exactly the same way as you do for laminate worktops. Use your usual 150mm connector bolts to clamp final joints.

**Biscuit jointer:** as with laminate worktops biscuits provide accurate alignment and vertical strength. Use a jointer with a 100mm diameter blade to cut 20mm deep pockets to suit no20 biscuits.

**Drills:** use high speed bits to drill holes into Encore, 10mm is ideal to introduce jigsaws to each corner of a cut-out. Tap holes should be cut with a tungsten carbide tipped hole saw of the correct diameter for the tap.

**Edging clamps:** use type A spring clamps to hold edge strips in place as adhesive cures. Use one per 100mm for 5mm strips or one per 70mm for 1.7mm strips.

**Card or laminate scraper:** made on site to remove excess adhesive from the inner joint face by trimming off a 45° x 2mm corner.



# cutting, edging and jointing encore

Encore is a hardwearing surface and as such the correct use of good quality power tools and the correct sharp cutters will produce a professional finish.

Encore worktops can be cut in much the same way as laminate worktops, however please ensure that you use the correct, good quality power tools. The solid surface material will wear cutters faster than laminate worktops; therefore the use of good quality sharp cutters of the recommended type will save time and effort in producing a professional finish. (See the 'Essential tools and materials' section.)

When cutting Encore ensure the full length of the worktop is supported on trestles. To prevent damage to the worktop, use one trestle every 1000mm.

The Encore surface material is compression moulded and reinforced: there is no need to refinish saw cut edges with a hand router or power plane, simply saw to size and fit. However where you plan to fit an edge strip, the final cut should be by hand router to assure a smooth mating face.

Use your vacuum extractor nozzle to remove all dust and debris from cut edges in preparation for gluing up later.

## Direction of cut

Always cut into the factory front edge, never out of it. Take special care when cutting a breakfast bar to length. Whether cutting with a circular saw, hand router or even jigsaw, please never cut out through the edge.

## Cutting with a circular saw

Only use a circular saw to rough cut Encore to size.

Cutting face up: Always cut in two passes; first cut set the blade depth at 15mm to clear the solid surface: making the second cut with the blade set to protrude by around 10mm.

Cutting face down: the cut can be made in a single full depth cut.

Ensure that you cut into the factory edge, NEVER out.

If using a fixed, slide table dimension saw set the height to no more than 65mm off the bed.

When rough cutting for a final router trim, allow a 5mm oversize.

## Cutting with a hand router

Use a hand router with a good quality, sharp, tungsten carbide, double flute cutter. When routing, the golden rule is to cut into the factory fitted edge with waste material to the right, the worktop can therefore be either face up or face down to ensure you cut into the factory edge and not out of it.

When routing, we recommend a cut depth of no more than 15mm in each pass. Use two or more passes for 27mm Encore and three or more passes for 44mm Encore. Never use a router to rough size Encore.

## Scribing into a wall

Just like laminate worktops, Encore can be scribed to an uneven wall using a jigsaw with the recommended Bosch T127D blade. As Encore is reinforced, saw cuts can be left as the final finish before installation.

## Setting out worktop joints

The methods for setting out and cutting worktop joints in Encore are exactly the same as you already use for laminate worktops.

**90° and 135° butt and scribe joints:** use a purpose made jig. Follow the jig manufacturer's instructions for cutter/guide bush combination, mitre depth allowance and setting method.

**Straight end to end butt joints:** use a straight edge guide offset to suit the router.

**Full diagonal mitre joints.** First determine the angle of the corner then equally bisect it and transfer the angle onto both worksurfaces and mark with pencil. Use a straight edge guide, offset to suit the router.

## Bolts and biscuits

Use of the correct number of bolts and biscuits are a condition of the Encore guarantee.

### Connector bolts

We recommend Zipbolt brand connector bolts in slimline 27mm Encore

Using a connector bolt jig, router the bolt slots no deeper than the following depths from the reverse face of the worktop

- No deeper than 19mm for 27mm Encore.
- No deeper than 25mm for 44mm Encore.

Position the slots 100mm in from ends and spaced equally in the centre.

Up to 500mm depth – use two connector bolts

Up to 700mm depth – use three connector bolts

Up to 900mm depth – use four connector bolts

### Jointing biscuits

The use of jointing biscuits will strengthen a joint in the vertical plane and ensure level surface alignment. Use a biscuit jointing machine to form pockets to suit No 20 biscuits. Cut pockets 1/3 worktop thickness down from the top face between the bolt slots. Do not cut pockets over bolt slots. Use one biscuit between each pair of connector bolts.

### Hob cut-outs and cut-outs for inset sinks

Unlike other solid surface materials, Encore can be cut with a jigsaw, making cut-outs as easy as they are in laminate worktops. Use the recommended type of jigsaw and Bosch blade T127D.

Following the same method as you use for laminate worktops: mark out the desired size cut-out using a pencil. With a high speed bit, drill four 10mm diameter holes on the internal corners of the marked cut-out. Using the holes to introduce the jigsaw blade cut along the inside of the marked line between the holes leaving a radius at each corner.

When forming cut-outs offsite it is advisable to form a blind cut-out with a router and jig, leaving 5mm of chipboard intact at the bottom of the cut. This will ensure the worktop remains rigid and undamaged in transit. Once the worktop is in place, the cut-out can be completed using a jig saw.

**Tip:** take the sink and hob cut-out waste material and save it behind the plinth line under the base carcasses. This exact colour match material may come in useful in later years should a patch repair be necessary.

### Sink cut-out edges

All cut edges need to be carefully waterproofed using BB Complete colour matched sealant. Apply at least a 2mm thick coat.

### Hob cut-out edges

Protect the edge using the self-adhesive heat reflective tape from your installation kit. Fold the overhang over equally above and below the worktop.

### Hob bars and heat studs

Do not router hob bars or heat studs into Encore worksurfaces, use self-adhesive versions.



## Using Encore colour coded seaming adhesive

Use Encore seaming adhesive to make joints in worktops, splashbacks and upstands or to bond edging strips. The use of any other adhesive will invalidate the warranty. Do not use Encore seaming adhesive to bond upstands or splashbacks to walls or to seam upstands or splashbacks to worktops. Do not use this adhesive to bond stainless steel or granite undermount sinks.

*Moulded acrylic sinks do however use this adhesive and its use is covered later.*

The adhesive bonds both the Encore solid surface material and the chipboard core. It must be applied with the correct applicator gun to assure a correctly metered mix of adhesive and hardener. The reusable gun is available from your Encore supplier. (Encore part number 460006)

The cartridge only comes with two nozzles; being designed to be used for a maximum of two applications per 50ml cartridge. The nozzles are not reusable.

Check that the adhesive cartridge has the same colour name as your worktops.

Now carefully follow the cleansing process explained in the following sections for each application type. Where joints are very visible, it is generally a failure to follow the cleansing advice that causes a dirty or contaminated adhesive line.

Load the cartridge into the applicator gun only when you are absolutely ready to apply the adhesive. Remove the protective cap by turning anticlockwise 90° and pulling, then attach a nozzle and tighten. (keep the cap for later)

To reduce the risk of an imbalanced mix always run off and dispose of the first 3-5 ml of adhesive.

Now work rapidly, the adhesive has started to cure. Apply the adhesive as described in the following sections. It is vital that the correct amount of adhesive is used at every application, reducing the amount used will cause problems later which may prove costly.

Encore adhesive has a joint open time of 6-8 minutes; useful to make any final adjustments. However plan on closing the joint immediately. Encore adhesive is generally fully cured in 40 minutes. However on a warm day the joint open time may be reduced, whilst on a cooler day the curing time may need to be extended.

## Applying edge strips

Both short ends of Encore worksurfaces arrive ready finished saving time re-edging onsite. On occasion a design will call for the installer to re-edge a worktop. The operation is simple and produces an excellent inconspicuous finish. Always apply an edge strip on a work bench; it is difficult to apply after the worktop is screwed in place.

Cut the worktop to length and trim to final size with a hand router for a finer mating face. Please remember that an edge strip will add either 1.7mm or 5mm to the worktop length depending on the strip you are using.

Cut the edge strip to length with a hack saw allowing a 5mm overhang past the front edge(s).

Use your vacuum extractor to remove all dust from the cut edge and edge strip.

Now wash your hands, the adhesive process calls for clean bonding faces, dust and grime will taint the adhesive causing a grey line after sanding.

From the installation kit you will need the white lint free wipes and Imanol industrial denatured alcohol. Using a wipe thoroughly cleanse the jointing face and localised top face of the Encore solid surface material with Imanol; taking care not to dampen the chipboard. Next repeat the process on the scarified rear face of the edge strip. Take extra care on pale decors and white, perhaps even cleansing twice.

Allow the cleansed edges to evaporate dry and assemble without delay to prevent contamination. If you touch the cleansed faces repeat the cleansing process!



Apply three 5mm beads of adhesive along the length of the scarified face of the edge strip. Top and bottom 5mm in from the edge and one centrally. Next apply two beads of adhesive 5mm in from the rear and front vertical edges of the worktop.



Working quickly, firmly apply the edge strip and align flush to the bottom and rear faces allowing the edge strip to stand proud of the top and front faces. Ensure that an unbroken bead of adhesive squeezes out all around. Finally secure the edging using Type 'A' spring clamps, one at each end and the others spaced approximately 100mm apart. (70mm apart for 1.7mm edge strips)



Allow at least 40mins adhesive cure time before commencing further finishing work. Using a power hand trimmer fitted with a straight fixed tip-guide cutter, trim away the excess material. If the edge is to fit against a tall housing or wall then further profiling is not necessary. To produce a profile to match the factory finish for 44mm worksurfaces, change the cutter to a 3mm radius trimmer and profile the end of the worktop. For 27mm worksurfaces carefully hand sand the pencil round profile with 320grit sandpaper. The edged worksurface is now ready to install; sanding will be completed as part of the final finishing process.

# radiused ends to match curved doors

Encore is ideal when it comes to producing cost effective worktops to match in vogue curved doors. With a flexible edge strip, onsite curved ends are simple to produce.

## Additional tools and materials

**Encore 1.7mm Radius End Edging Strip:** Do not use the standard 5mm edge strip. Carry out a colour variance check between worktop and edge strip.

**50ml Encore Colour Coded Seaming Adhesive:** one per radius edge strip.

**Encore Radius End Jig:** an Encore jig is available and cuts radii 230, 300, 400, 450mm. For others you may need to make your own remembering to allow for your guide bush radius.

**Clamps Type 'A' :** use at least one for every 70mm of edge strip.

**Edge Profile Cutter for 44mm worktops (3mm radius):** we recommend Titman ROCB3 or Trend C074.

## Encore radius ends can be formed using two different methods:

**Option 1:** Simple overlapping radius edge. This is a much simpler option but take care not to over sand when sanding the radius edge to blend with the front edge. Over sanding will reduce edging thickness possibly making it translucent. On occasion it may be possible to see an adhesive line at the point of overlap.

**Option 2:** The radius edge strip is inlaid into the 5mm factory edge strip. This option requires greater degree of accuracy, both during cutting and hand sanding to ensure an accurate joint.

With both of the above options you must remove the entire factory fitted short edge, replacing it entirely with the new radius edge strip. Ensure that at least 17mm is cut from the end during sizing by router.

## General rough sizing

Refer to the cutting instructions when general sizing Encore, paying special attention to the direction of cut. Always cut into the factory fitted edge and never out of it.

Please allow for:

- 1.7mm edging strip thickness
- joints or end caps at the opposite end

We recommend you work on a bench and form radius ends in oversized worktops, final sizing including joints should be undertaken afterwards. Do not attempt to apply radius ends after the worktops are fixed.

## Option 1: Simple overlapping radius edge

Work with the factory fitted front edge facing toward you and the end to be routed to the right, with worktop face up or down depending on the desired handing of radius end.

Oversize and cut the worktop to the required size.

Place the jig in position, square up and align the short front leg of the jig flush with the front edge of the worktop and secure the jig in place using two 'G' Clamps.

Set your cutter depth to 15mm and position the router on the worktop front edge, plunge and push the router along until you reach the offset point at the front edge. Carefully follow the jig as it steps in - you will start cutting at this point.

Finish the cut, reset the cutter depth twice more in increments of 15mm and complete the cut.

Remove the jig, thoroughly vacuum clean the routed edge and face of all debris.

Leaving the polythene coating intact, cut the edging strip to the required length using a hacksaw, ensuring the start point at the front edge overlaps the router cut start point by around 2mm and 5mm overhangs at the back edge.

Wash your hands thoroughly to ensure grime cannot taint the joint. Using Imanol and a white lint free wipe, thoroughly clean the solid surface edge and face of the end to be edged. Repeat for the scarified back edge of the edging strip. Consider repeating for lighter colours to assure absolute cleanliness. Do not touch the cleansed faces again. If by accident you do, repeat the cleaning process.

### Assembly

Load up the adhesive gun with Encore colour coded adhesive.

Take a wooden spatula from the installation kit and thoroughly clean it with Imanol and a clean wipe, allowing it to dry.

Apply 3 generous beads of adhesive to both worktop and edge strip. Then using a cleaned wooden spatula evenly spread the adhesive so that chipboard and solid surface is fully covered.

Working quickly apply the edge to the worktop, ensuring the start point at the front edge front overlaps the router cut start point by 2mm.

Ensure adhesive squeezes out along the entire joining face of the edging strip.

Temporarily secure the edge in place at the front edge using an 'A' clamp, followed by two more equally spaced around the radius and one at the rear edge.

Next apply an 'A' clamp directly over the 2mm front edge overlap.

Apply 'A' clamps at least every 70mm around the entire edging strip. Applying plenty of

clamps ensures an accurate fit following the cut edge.

Allow the adhesive to cure for at least 40 minutes at room temperature.

Trim away the overhanging edge along the face, bottom and rear edge using an electric hand trimmer with a fixed tip guide cutter.

The front overlap needs to be sanded and blended in carefully. Using 180grit sand paper and a random orbital sander carefully sand the bulk away at the edge/worktop joint, taking care not to over sand.

Once the bulk has been sanded away use a palm sander to carefully blend the edges together. Take care not to over sand the edge. Use 240 grit paper.

To produce a profile to match the factory finish for 44mm worksurfaces, use a hand trimmer with a 3mm radius trimmer and profile the worktop. For 27mm worksurfaces carefully hand sand the pencil round profile with 320grit sandpaper. The edged worksurface is now ready to install; sanding will be completed as part of the final finishing process.

The radius end is now complete; final finishing is covered on page 23.

## Option 2: The radius edge strip is inlaid into the 5mm factory edge strip

Work with the factory fitted front edge facing toward you and the end to be routed to the right, worktop face up or down depending on the desired handing of radius end.

Place the jig in position and square up. However, the short front leg of the jig is set back from the front edge by no more than 2mm to allow a rebate to be cut and for the edging strip to later locate into the factory front edge rebate.

NB : Router cutters / guide bush diameters do tend to vary between machines. Bearing this in mind the jig may need to be reset if the desired rebate is not achieved.

Follow procedures as described in Option 1 to router cut the radius end. To prepare the edging strip, start with an oversized edge strip.

To prepare the edging strip, start with an oversized edge strip.

To ensure the edge fits snugly into the rebate, the rear face of edging strip will need to be carefully hand sanded to match the inner radius of the routed rebate, sand edge using 180grit sand paper attached to solid block. Once happy cut the edging strip to length allowing for 5mm overhang at the back edge.

Now follow the procedures as described in Option 1 except that the edging will not overlap the front edge, but locates within the rebate during assembly to form a neat joint. A small clean softwood block can be temporarily attached to front of worktop edge as a stop for the edge strip to locate accurately against; preventing the edge from mis-locating during assembly.



Crystal Black  
worksurface and  
upstand.



# the encore undermount sink solution

Now you can complete the look with our innovative undermount sink solution.

## Additional tools and materials

**Special Encore reusable sink jigs:** available from your Encore distributor. A unique two part jig system developed by Bushboard specifically for each model of sink on the range. Each jig set cuts the face and rear cut-outs to match one sink model. The jigs are reversible to create left and right hand solutions. Sink jigs for Encore brand seamless moulded acrylic sinks are available as one pack including both models and a blending cutter.

**Drainer groove reusable jig:** use to form horizontal drainer grooves in the Encore surface. Each jig has one slot for straight grooves and two dog leg slots, enabling drainer design to suit the home owners requirements.

**Router guide bushes:** standard 30mm and 40mm guide bushes are usually required to enable sufficient material to be removed from the rebate. Non original guide bushes may need reducing in height to suit the jig thickness.

**Edge profile cutter 3mm radius:** to form the radius edge over the sink. We recommend Titman ROCB3 or Trend C074.

**Drainer groove cutter:** use a 1/2 inch diameter bottom radius cutter such as Trend CO54. Do not use a flat base cutter, a radius is vital to ensure easy hand sanding.

**Encore undermount sink clips:** always use sink clips with every installation and only use for Encore.

**Sink adhesive for granite and stainless steel sinks:** only use BB Complete colour matched adhesives. This strong aviation grade product is specially designed to bond and seal. Silicone is not acceptable. Do not use Encore colour coded seaming adhesive.

**Sink adhesive for Encore brand seamless moulded acrylic sinks:** only use Encore colour coded seaming adhesive in the same colour as the worksurface. Use one cartridge for single bowl sink and one and a half per bowl and a half sink. Do not use any other adhesive.

We recommend working on trestles close to the final position for installation: the worktop will become weakened due to the cut-out. Use three trestles for <2400mm worktops and four for 2400-4100mm worktops.

**Important** - Bushboard Encore sink clips, adhesives and jigs are not suitable for use with any other solid surface materials. This will void manufacturer's guarantees and product support agreements.

## Stainless steel and granite sinks

### Calculating centres

We recommend that you calculate and work from the total sink centre as opposed to the bowl centre. Sink centres will always line up with cut-out jig centres.

### Forming the face cut-out

We recommend working on trestles near the final position of the sink installation. Use a rigid support board to provide support as you work through each process; the worktop will become weakened as the cut-out is formed.

Start by making the full depth cut-out in the face of the worktop using the 'FACE' jig. Work with the worktop face up.

Using a pencil, mark out the sink centre onto the Encore worksurface.

Ensuring the jig handing corresponds with the desired sink handing, centralise the 'FACE' jig and clamp in place using four G-clamps, one at each corner.



Using a 30mm guide bush and 1/2 inch router cutter, form a full depth cut-out, ensuring the waste section is supported to prevent damage as it falls away. Router cut in stages at 15mm depth.



Using a router or hand trimmer fitted with a 3mm radius profile trimmer, profile the inner edge of the cut-out. The finished inner edge profile and any draining grooves should be completed before turning the worktop over to work the back face. Sand and finish the cut-out inner edge using a palm sander and 320 grit paper followed by grey Scotchbrite. We recommend finishing the radii by hand.

If no drainer grooves are required, next follow the surface sanding process for Encore worktops around the entire sink area to eliminate the need to sand and possibly damage the final installed sink later. However do not apply Professional Worktop Polish until the entire installation is complete. Now move on to the section titled 'Forming the back clearance cut-out'.

### Forming drainer grooves

Encore solid surface is compression moulded, reinforced at 5mm thick allowing drainer grooves to be routed on site. Use good quality cutters and work smoothly for an excellent finish. Sharp cutters will reduce final finishing time. For Stainless Steel and Granite sinks form grooves after the cut-out inner edge has had the 3mm profile applied, but before the back face has been machined to remove the waste chipboard. For Encore brand seamless acrylic sinks the drainer grooves are machined as the last process. Do not attempt to machine a fall in grooves.

### Marking out drainer groove centre lines

The jig allows the installer to design layouts with more or less grooves, full length or shorter grooves, with or without dog-legs. To aid design flexibility the universal drainer groove jig is designed to form one groove at a time and includes left and right hand dog-leg slots and one straight slot.

Using a pencil, mark out groove centre lines ensuring they are parallel to the front edge of the worktop. Laying masking tape on the surface prior to marking out centres may aid visibility.



### Cutting drainer grooves

Centralise the required slot in the jig over the previously marked out centre line and firmly clamp in place using at least x2 G-clamps.

Use a hand router fitted with a 30mm guide bush and a Trend CO54 radius cutter. Accurately set the plunge depth to 2mm (+/- 0.2mm). Never cut deeper than 2.2mm.

Starting from the open end of the jig slot nearer to the sink, plunge the router and lock and run smoothly up to the fixed end staying to the left of the guide then return back staying to the right producing the groove. Smooth use of the router will minimise hand sanding after completion.



Repeat the steps above to complete other grooves.

### Finishing drainer grooves

Sand the drainer grooves by hand using 240grit, 320grit and finally grey Scotchbrite. Be careful not to over sand the edges, whilst taking care to maintain the routed groove shape.

Next follow the surface sanding process for Encore worktops around the entire sink and drainer area to eliminate the need to sand and possibly damage the final installed sink later. However do not apply Professional Worktop Polish until the entire installation is complete.

### Forming the back clearance cut-out

Using a rigid support board to strengthen the worktop and cut-out, carefully turn the worktop face down.

Accurately centralise the 'BACK' jig to the cut-out on the back of the worksurface, clamp in place using four G-clamps one at each corner of the jig. Ensure the jig handing corresponds with the cut-out. Take care to protect the face material from the clamps using a soft packer.

This next stage removes waste chipboard, leaving a solid surface overhang. Accurate setting of the router depth stop to the exact depth is vital.

Accurately measure the total thickness of the worksurface and the jig. Accurately set the router cutter depth to the total thickness as measured less 4.5mm. Set and lock the depth stop.



Waste removal has two stages using two different guide bushes:

Stage one - use a 40mm guide bush and standard 1/2 inch router cutter to cut back the chipboard.

Stage two - use a 30mm guide bush and standard 1/2 inch router cutter to further cut back the chipboard to the final finish. If necessary carefully scrape or chisel away any uncut ridges of chipboard. Thoroughly remove all loose dust or debris.

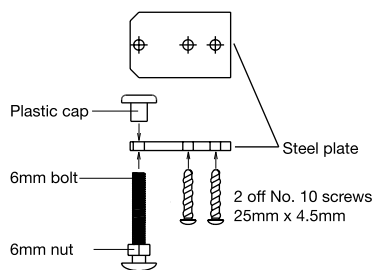
Best results are achieved by routing 27mm Encore in two 10 mm depths leaving around 2mm of chipboard in place before carefully machining it away to leave a clean solid surface face. For 44mm Encore cut in three 12mm depths before removing the remaining chipboard. Take care to keep the router vertical and work steadily. To ensure the router remains

level use the inner cut out waste as support for the router by replacing it into the cut out once the worktop is turned over.

### Test fit the sink and sink clips

Before commencing work ensure that the mating face of the chosen sink is flat and not deformed. A deformed edge is unlikely to be pulled flat during installation due to the strength of the steel. Applying excess pressure to remedy a deformed sink is likely to damage the sink or the surface. Installing a deformed sink may not produce the expected neat seal between the steel and the solid surface overhang.

To check the sink fit, a test assembly is necessary. Place the inverted sink into the cut-out to confirm it centres when viewed from the face and clears the surrounding chipboard from the back.



Assemble the sink clips following the recommended drawing (above). Sink fixing clips must be centralised on radius corners and all straight edges. Use at least nine clips for a 1.5 bowl steel sink. Assemble the sink clips and drill 3mm diameter x 10mm deep pilot holes in the worktop back face for the screws. Consider the position of any tap hole when positioning sink clips.

It may also be necessary to recess the clips into the back face of the worktop to clear carcass tie-rails or gables. Hack-sawing bolt heads off after the lock nuts are tightened will provide further clearance if required.

At this stage we recommend overflows are trial fitted to assure clearance from the surrounding worktop. It may be necessary to cut clearance around the overflow.

Once satisfied with the final fit and clip location, remove all clips and the sink in readiness for final installation.

### Final sink installation

The following process can take place either face up or face down. For ease, face down is best but care is needed to ensure the sink is centred in the cut-out when viewed face up.

Using Imanol and white lint free wipes, thoroughly clean the two mating faces of the sink and worksurface.



Apply an unbroken, 4mm diameter bead of BB Complete colour coded adhesive to the outermost edge of the sink mating face. Follow with a similar bead to the mating face of the solid surface overhang within the sink cut-out.

Gently place the sink in position applying gentle pressure all round to ensure the sink is fully bedded and adhesive squeezes out on both back and face edges of the cut-out.



Re-affix the sink clips, tightening the self-tapping screws fully.

Centralise the sink and then hand tighten the sink clip bolts. Do not use a spanner to tighten the bolts; over-tightening will cause damage to the sink and the worksurface. Finally, lock off the locking nuts with a spanner.

Remove excess adhesive immediately using an appropriate soft non-metal scraper with a square corner. Spills and smears can be cleaned off using a minimum amount of white spirit on a clean wipe.

Seal all bare chipboard faces of the sink cut-out using BB Complete.

Do not use water until the adhesive has fully cured. The sink may be used after a 24 hour cure time has elapsed.



Glacier worksurface. Shown with an Encore one and a half bowl white acrylic moulded sink and straight drainer grooves.

# encore seamless moulded acrylic sinks

Contemporary styling affordably priced.

## Additional Tools and Materials:

**Special Encore undermount reusable jig set for seamless moulded acrylic sinks:** available packed with both single and bowl and a half jigs and including a cutter to form the seamless edge on up to six installations. The cutter is also available as a replacement item, whilst the jigs are reusable. The jigs cut face and back cuts outs and allow for left or right hand versions.

**Special angled trim and profile cutter:** special all in one cutter to blend the sink into the worktop seamlessly whilst forming a 3mm radius to the top edge. The cutter is included in the jig set and is also available as a replacement tool. One cutter should install up to six sinks (Encore part no. 460136).

**Overflow cutter** (if required): use a standard 25mm or 1" hole saw cutter. Do not use spade drill bits.

**Encore undermount sink clips:** always use sink clips with every installation and only use for Encore.

**Sink adhesive for Encore brand seamless moulded acrylic sinks:** only use Encore colour coded seaming adhesive in the colourway matching the worktop colour. This being the same used for joints and edge strips. Do not use any other adhesive.

We recommend working on trestles close to the final position for installation: the worktop will become weakened due to the cut-out. Use three trestles for <2400mm worktops and four for 2400-4100mm worktops.

## Calculating centres

We recommend that you calculate and work from the total sink centre as opposed to the bowl centre. Sink centres will always line up with cut-out jig centres. Use a pencil to mark out the sink centre onto the Encore worksurface.

*The installation sequence differs from that used for stainless steel and granite sinks; you will cut the drainer grooves after the sink installation is complete.*

Use a rigid support board to provide support as you work through each process: the worktop will become weakened as the cut-out is formed.

Start by making the full depth cut-out in the face of the worktop using the 'FACE' jig. Work with the worktop face up.

Ensuring the jig handing corresponds with the desired sink handing, centralise the 'FACE' jig and clamp in place using four G-clamps, one at each corner.



Using a 30mm guide bush and 1/2 inch router cutter, form a full depth cut-out, ensuring the waste section is supported to prevent damage as it falls away. Router cut in three stages of 15mm depth each. Remove the off cut and clean.

## Forming the back clearance cut-out

Using a rigid support board to strengthen the worktop and cut-out, carefully turn the worktop face down.

Accurately centralise the 'BACK' jig to the cut-out on the back of the worksurface, clamp in place using four G-clamps one at each corner of the jig. Ensure the jig handing corresponds with the cut-out. Take care to protect the face material from the clamps using a soft packer.

This next stage removes waste chipboard, leaving a solid surface overhang. Accurate setting of the router depth stop to the exact depth is vital.



Accurately measure the total thickness of the worksurface and the jig. Accurately set the router cutter depth to the total thickness as measured less 4.5mm. Set and lock the depth stop.

Waste removal has two stages using two different guide bushes:

Stage one - use a 40mm guide bush and standard 1/2 inch router cutter to cut back the chipboard.

Stage two - use a 30mm guide bush and standard 1/2 inch router cutter to further cut back the chipboard to the final finish. If necessary carefully scrape or chisel away any uncut ridges of chipboard. Thoroughly remove all loose dust or debris.

Best results are achieved by routing 27mm Encore in two 10 mm depths leaving around 2mm of chipboard in place

before carefully machining it away to leave a clean solid surface face. For 44mm Encore cut in three 12mm depths before removing the remaining chipboard. Take care to keep the router vertical and work steadily. To ensure the router remains level use the inner cut out waste as support for the router by replacing it into the cut out once the worktop is turned over.

**Test fit sink and sink clips:** by following the instructions within the stainless steel instructions. (page 13)

## Final sink installation

Installation of seamless moulded acrylic sinks has to be carried out with worksurface face down on a clean and perfectly flat backboard. Care is needed to ensure the sink is centralised in the cut-out.

Using Imanol and clean white wipes from the main installation kit thoroughly clean both mating faces of the sink and Encore



solid surface. Any dirt or dust trapped in the joint will compromise both mechanical and aesthetic quality of the seamless edge.



Adhesive will need to be applied to both worksurface cut-out and the mating flange of the sink. Due to limited workable time, adhesive application and assembly should be carried out speedily. Use adhesive that matches the worktop colour.



Apply two unbroken 4mm beads of Encore colour coded seaming adhesive to the inner corner of the cut-out and approximately 4mm in from the cut-out edge on the solid surface.

Also apply two unbroken beads of adhesive, one to the middle of the sink mating flange and 2nd to edge nearer to the bowl.

Gently place the sink in position pressing firmly down and rocking sideways to ensure the adhesive squeezes out, however do not scrape the adhesive away.



Refix the sink clips using the supplied screws. Evenly hand tighten the bolts and lock the nut ensuring you only tighten the bolts by hand. Tighten the lock nuts with a spanner.

Allow the sink adhesive to cure for at least 45 minutes.

#### Blend worktop and sink flush

Gently turn the worksurface and sink over with the back board in place supporting the cut-out to prevent stress. Place on trestles before removing the back board.

The next process trims the worktop and the sink itself to create a blended seamless finish. The special cutter takes care of these operations and is a vital tool designed for the job.

Using a hand router with a 1/4" collet and the special angled trim and profile cutter from the jig set, set and trim back the overhang so that the cutter skims the face of the worksurface, the bearing takes care of the sink side wall placement.

A slight feather cut into surface or the bowl is normal, this can be easily sanded out later.



Try to trim back in several light passes to minimise cutter/bearing wear. We recommend extraction to reduce dust.

All inner sink corners will need to be completely sanded by hand, it's best to sand these first. Use 240 + 320 grit papers.

The straight edges can now be sanded using a random orbital palm sander and combination of 240, 320 grit papers and fine scotchbrite.



#### Cutting an overflow hole:

Encore sinks do not include a pre-drilled overflow. One can be fitted simply in the main bowl if required.

We recommend that the position of an overflow be central to the back facing wall of the large bowl and 40mm down from the top of the Encore worksurface.

Using a standard 25mm hole saw make an overflow hole. Refer to the diagram provided within the waste kit to install the overflow.

#### Drainer grooves for Encore brand seamless moulded acrylic sinks

Always cut drainer grooves for seamless moulded acrylic sinks after the sink is complete.

**Cutting and sanding drainer grooves for seamless acrylic sinks:** Follow the instructions for stainless steel sinks on page 13.



#### Tap holes for all sink types

Cut tap holes through the intact Encore worktop ensuring that the full chipboard substrate is in place to support the tap.

Position the tap as necessary, ensuring any sink clips have previously been positioned to clear the desired tap plumbing or hole.

Cut the tap hole using a suitable hole-saw of the correct dimension to suit the chosen tap.

Fully seal the exposed chipboard within the tap hole using BB Complete sealant. Ensure the tap is installed using its seal, grommet or O-ring to prevent moisture entering the tap hole. We recommend the application of additional high modulus silicone to further seal the tap body to the worksurface face to prevent water penetrating the tap hole.

We recommend the installer take time to seal the tap hole well. With the heavy use a tap can undergo, it is best practice for the installer to ensure extra sealing to prevent future problems from leaks or condensation on the cold water feed. Adequate prevention from moisture entering the tap hole is the responsibility of the installer.

*\* Advise the customer to never pour boiling water into the sink without first turning on the cold tap to cool the water.*





Chocolate Sparkle  
worksurface and upstand.  
Shown with a Deca 100 sink  
and straight drainer grooves.

# flushmount sinks

Flushmounted sinks are the ultimate in designer styling and with Encore you can achieve it easily.

The material is first routed and the sink set in so that it sits perfectly flush. Smooth lines to the touch. Beautiful to look at, a delight to work with and another great example of style and quality for less.

The rebate for a flushmounted sink is cut with a hand router; you will need to produce a jig to match the sink allowing for your 30mm router guide-bush.

Stage one: Router the through cut out for the sink using a 40mm guide bush and a ½" inch cutter\*.

Stage two: Router the flush rebate using a 30mm guide bush and a ½ inch cutter\*.

\*Do not use 12mm cutters.

The through cut out at stage one could also be formed using a plunge saw for straight cuts and a jigsaw for radius corners; however a router is far simpler.

## Stage one: Forming the through cut out using a router

We recommend working on trestles near the final position of the sink installation. Use a rigid support board to provide

support. As you work through each process the worktop will become weakened as the cut-out is formed.

Position your jig in the desired position and clamp in place using G-Clamps.

Using a 40mm guide bush and ½ inch cutter router cut in stages of 15mm depth forming a full depth cut-out. Ensure the waste section is supported to prevent damage as it falls away. Remove the off cut and clean. **Do not remove the jig or move the worktop.**

## Stage Two: Forming the rebate for the sink

Fit the router with a 30mm guide bush and ensure you use a sharp ½ inch cutter.

Accurately set the cutter depth to suit the steel thickness of the sink. Plunge and gently router the flush rebate taking care not to tilt the router.

Clean and trial fit the sink; if necessary spacers may be used to pack the sink flush. Only when happy remove the jig.

## Final installation

Thoroughly clean the solid surface face in the cut out using Imanol then clean the underside sink flange using Imanol.

Apply a single bead of matching BB Complete adhesive of 4 to 5mm diameter to the centre of the solid surface rebate. Promptly place the sink in position and gently push down all around. Check for alignment both at face level and central to cut out. Adjust if necessary and tighten the sink clips taking care to not over tighten and then recheck the alignment.

Excess BB Complete can be removed from the face face using a soft scraper. Final cleaning must only be with white spirit and a clean lint free cloth before rechecking alignment. Adjustments can be made within 10mins of initial application of BBcomplete adhesive. Voids should be refilled promptly. Allow to cure for 24hrs prior undertaking any further plumbing work and use.





# final worktop installation

## Dry fit trials

Once all components are cut and machined carry out a full dry fit trial prior to commencing installation. It is extremely difficult to resolve any problems once joints are glued, secured and set.

During the dry fit check for areas where later access for sanding could be difficult, perhaps in corners or at the rear of a diagonal corner solution. Consider sanding these areas before installation to make life easier.

## Areas to check

- Lengths are correct especially where you have applied edge strips.
- Worktops are level to a spirit level.
- Joints are a perfect fit and close fully. Any gaps will make the final joint more visible. Ensure that the 45° scribe section closes and the male section can be pulled forward.
- Hob and sink cut-outs are in the correct place.
- Undermount sinks drop into their recess without fouling carcasses, take special care to check the sink clips clear all obstructions.
- Connector bolts are accessible and biscuits can be easily inserted.

## Sealing against moisture before installation

Once satisfied with the dry fit ensure that all raw edges are completely sealed against moisture. We recommend a 2mm coat of BB Complete colour matched adhesive.

Apply additional moisture protection in vulnerable areas within the kitchen layout. For example in front of the sink or on the lower face of all joints to protect against spills and overflowing sinks. BB Complete is the ideal sealant.

## Dishwashers

Always install additional moisture protection above dishwashers & washing machines. (see page 23)

## Assembling joints

Prior to commencing work ensure all required tools and installation items are to hand:

- Glue applicator gun loaded with Encore colour coded adhesive.

- Sufficient connector bolts and biscuits are ready and set for rapid use.
- Spanner and a clean card or laminate scraper with a 2mm 45° angle cut from one corner.

Use your vacuum dust extractor to ensure the jointing faces and nearby surfaces are completely free of dust.

Now wash your hands, the adhesive process calls for clean bonding faces; dust and grime will taint the adhesive causing a grey line after sanding.

From the installation kit you will need the white lint free wipes and Imanol industrial denatured alcohol. Using a wipe soaked in Imanol thoroughly cleanse both jointing faces and localised top face of the Encore solid surface material; taking care not to dampen the chipboard. Take extra care on pale decors and white, perhaps even cleansing twice.



Allow the cleansed edges to evaporate dry and assemble without delay to prevent contamination. If you touch the clean faces repeat the cleansing process!

Dispense a small amount of adhesive into the biscuit pockets on one side of the joint and insert the biscuits.



Apply two 5mm beads of adhesive along the entire length of the joint.

The first bead should be applied just above the biscuits, 20mm down from the top face.

The second bead should be applied 5mm up from the bottom face.

Finally run vertical beads 5mm in from the front and rear faces.



Without delay, bring the two joints together briefly, then gently open the joint leaving a 2mm gap.

Holding the dispensing gun slightly off vertical and working from back to front apply a continuous unbroken final bead into the open 2mm gap.

Bring the two worksurfaces together. If assembling a mason's mitre ensure the short 45° section is pulled closed by ensuring the male section is pulled fully forward.

Insert the connection bolts and tighten. Do not over tighten, generally two to three full 360° turns after the pinch point should be ample.

Check that you have an unbroken bead at all edges of the joint including the lower face. Squeeze out in this area is vital to protect against moisture entry into your cut edge in the event of a spillage.

Using your clean card scraper, scrape away the squeezed out adhesive in the inner internal joint faces. This will leave a neat bead and save much time in sanding this less accessible area.



Do not attempt to remove any other excess squeezed out adhesive at this time; it may shrink as it cures. Any adhesive overspill on the surface or in the carcass below should be wiped away promptly using Imanol.

Allow at least 40mins adhesive curing time before commencing finishing work.

Joint sanding is covered later.



Mountain Haze island with a slab end. Shown with encore acrylic white seamless undermount sink and straight drainers.



# slab end panels

Contemporary styling affordably priced.

To produce worktop slab end feature panels use the Encore 2020mm worktop: the rear of this worktop is faced with a plain decorative laminate to blend with the face colour. At all stages take care to protect the inner plain laminate finish as it can be scratched by hand tools.

There are two acceptable methods for installing a slab end panel.

**Option 1: Simple 90° butt joint.** This option allows a slight 1mm overhang for ease of installation. Please do not use this method if you intend an inconspicuous seam finish.

**Option 2: 45° mitre joint for a less conspicuous joint.** This version is technically more demanding but can produce a seamless finish.

## General rough sizing

When rough sizing for a slab end please allow for the worktop/slab end thicknesses, final router trim cut and edge strip thickness.

## Installation

### Option 1: 90 degree butt joint

Trim the worktop to the final length and apply an edge strip as necessary: ensuring that you colour match the edge strip and slab end panel. We recommend the slab end be cut to allow a worktop overhang at the front and end of at least 1mm.

Cut the slab end to the required height and depth; it's best to router finish the ends for a neater finish. Seal all raw edges well against moisture, additionally sealing the bottom edge against water spillage and everyday mopping.

Drill the carcass side panel ready to screw the slab end in place.

Carry out a dry fit trial to ensure best alignment and then clamp in place. Thoroughly clean the upper cut edge removing chipboard dust.

Apply a generous continuous bead of BB Complete colour matched adhesive to the top edge of the slab end. Lower and accurately align the worktop, applying downward pressure ensuring adhesive squeezes out from all edges.

Securely screw the slab end and worktop to the carcass before removing the clamps.

Carefully wipe off excess adhesive using a minimum amount of white spirit and a clean cloth. Finally, run a bead of BB Complete around the base of the slab

end to further protect against water spillages.

### Option 2: 45 degree mitre joint:

Carry out a colour variance check, then cut the worktop and slab ends over length allowing excess for the 45° mitre.

Using a fixed, slide table, dimension saw set at exactly 45°, mitre the ends of both worktop and slab end. It is vital that the saw blade enters the front edge of the worktop in all cutting processes. Do not cut out of the front edge.

Drill the carcass side panel ready to screw the slab end in place.

Excepting the actual 45° slab end and worktop mitre joint, seal all raw edges well against moisture, additionally sealing the bottom edge against water spillage and everyday mopping.

Carry out dry fit trials to ensure a good fit and alignment without gaps or fouling. Once happy with the dry fit, remove the slab end and screw the worktop to the cabinets in the usual manner.

Thoroughly remove chipboard dust from both mitred edges and thoroughly clean the solid surface using Imanol following the instructions for Encore joint assembly.

Apply three generous unbroken beads of Encore colour coded seaming adhesive to the mitred edge of the slab end. Aim to use one 50ml cartridge:

1st bead – central to the core of the slab end

2nd bead – 5mm in from the inside/back edge of slab end

3rd bead – at the outside edge of slab end covering the entire Encore solid surface cut edge around to the front face.

Promptly place the slab end in position ensuring a good squeeze out of adhesive, making sure there are no gaps. Align and temporarily clamp the slab end in place, before screwing the slab end securely in place.

Allow at least 40 minutes for the adhesive to cure.

Now follow the sanding instructions for joints and edge strips. Take care not to over sand the front faces during this process. For 44mm a 3mm radius can be applied to the top edge using a 3mm cutter. For 27mm hand sand a pencil round edge to match the worktop profile.

Finally run a bead of BB Complete around the base of the slab end to further protect against water spillages.

# final finishing

The consumer should be left with an Encore care kit and advised to follow the instructions with relation to care and maintenance.

## Sanding

Encore is available in three families of décor. Sanding process will vary depending on the general colouration of the décor or the family being installed. In general sanding darker, plainer and black decors will take more care and relies on the correct sanding equipment. Paler and cream decors are simpler to sand. It is vital that the final finish is achieved with the sander before any polish is applied.

We stress that the use of a good quality random orbital sander; integrated vacuum dust extraction is vital to produce a professional finish, refer to 'Essential installation tools and materials' section for specifications. DIY style machines cannot produce a professional finish and may lead to a dissatisfied customer.

Vacuum dust extraction is paramount for both health & safety reasons and quality of final surface finish. Failure to extract dust during sanding allows it to rapidly clog and form a barrier between surface and sanding disc making it difficult to achieve a good finish.

Ensure the sander is moved constantly during sanding operations, especially when sanding a joint. Holding the sander in one place can generate excessive heat and create a depression in the worksurface.

Ensure the worksurface is thoroughly wiped clean between each sanding operation to remove debris and grit. We recommend this be done with fresh clean water and a clean cloth, the benefit of which is to remove all traces of dust to judge progress at each stage.

### Sanding joints

Adhesive should always be sanded away, never scraped.

Set the sander to fine mode and using a 180grit sanding disc, carefully sand away the joint adhesive bead. Ensure the sander is level and kept moving along the line of the adhesive. Try not to sand the surrounding surfaces at the initial stages to avoid dishing at the joint.

At this stage the adhesive bead should have now been removed and the area "seamless".

Next fit a 240grit disc to refine the area sanded above, increase the sanding area slightly to ensure full coverage of the previously sanded area. You should now move on to the section 'Final all over finishing'. The final all over sanding process now completes the sanding process for the adhesive areas.

### Sanding edge strips

Follow the above procedure for joints. Sanding using 180grit may not be necessary if the quality of trimming is to a good finish. To protect the front profile, take care not to allow the sander to leave the surface and bevel the edge as you sand.

### Final all over finishing

Crystal Black, Espresso Glass and the Sparkle family. The darker nature of these decors means that the final finish relies on the correct power tools and carefully following the instructions. Set the sander to fine for the following processes.

### Final all over finishing standard and crystal families

Once all joints and on site applied short ends are seamlessly sanded to 240grit you can move on to sand the entire surface area using 320grit sanding discs.

To achieve a patch free and even finish overlap previous sanded areas by at least 30mm. Sand both sideways and back to front, finishing off with a circular motion.

Using a palm sander sand the front and return edges using 320 grit sand papers. It is not necessary to sand the 3mm profile as this is factory finished.

Thoroughly wipe off the dust and wash the entire surface using a clean cloth and fresh water, then allow to dry.

The next process is recommended for all decors, but vital for decors such as Anthracite or Crystal Black. Using grey Scotchbrite pads, repeat the procedure above. The aim being to bring up the final colour and finish before any Bushboard Professional Worktop Polish is applied. Scotchbrite polishes rather than sands the surface. The Scotchbrite process should not be rushed; as a rule it generally takes twice the time spent

sanding using 320grit.

Once again wipe away any debris and clean the surface using water, allowing drying time. Finally attach a clean folded white wipe from the installation kit to the base of the sander and buff the entire surface to an even finish.

### Final all over finishing Sparkle family

Sparkle decors are in effect a plain colour. Due to this any finishing imperfections may be more obvious; for this reason final sanding procedures should be carried out thoroughly.

Once all joints and on site applied short ends are seamlessly sanded to 240grit you can move on to sand the entire surface area using 320grit sanding discs.

To achieve a patch free and even finish overlap previous sanded areas by at least 30mm. Sand both sideways and back to front, finishing off with a circular motion.

Thoroughly wipe off the dust and wash the entire surface using a clean cloth and fresh water, then allow to dry. Next repeat the process using 400grit discs.

Using a palm sander sand the front and return edges using 320 and 400grit sand papers. It is not necessary to sand the 3mm radius profile as this is factory finished.

Thoroughly wipe off the dust and wash the entire surface using a clean cloth and fresh water, then allow to dry.

Next use grey Scotchbrite pads and repeat the procedure above. The aim being to bring up the final colour and finish before any Bushboard Professional Worktop Polish is applied. Scotchbrite polishes rather than sands the surface. The Scotchbrite process should not be rushed; as a rule it generally takes twice the time spent sanding using 400grit.

Once again wipe away any debris and clean the surface using water, allowing drying time. Finally attach a clean folded white wipe from the installation kit to the base of the sander and buff the entire surface to an even finish.

### Upstands

Encore upstands are solid 12mm solid surface material factory finished to a 320 grit linear sanded finish.

Upstands should be installed after the worktops have been sanded to their final all over finish, but before any finishing polish is applied. It is however important that prior to installation the upstand is sanded to the final finish following the instructions at "sanding". Once installed it is difficult to achieve an acceptable finish.

	All decors	Sparkle family
180 grit	Bulk adhesive removal	Bulk adhesive removal
240 grit	Refine adhesive areas	Refine adhesive areas
320 grit	All over sanding process	All over sanding process
400 grit	Not necessary, but advised.	All over sanding process
Scotchbrite grey	Final surface finish	Final surface finish

Upstands can be customised using a mitre saw, router or jigsaw. Mitred corners can be achieved in much the same way as laminate upstands. Finish any visible cut edges with a sander, going through the grits to achieve a good finish. A radius can be sanded onto a finished cut edge to match the top edge. When jointing two upstands together cut with a router to achieve smooth mating faces.

Ensure that the wall is dry, stable and free of any loose debris or dust. We recommend a dry fit trial before applying adhesives. Finally wipe any dust residues from the rear and lower faces using a damp cloth and allow to dry.

Bond the upstand to the wall using BB Complete colour matched adhesive. Run three beads along the length of the rear edge: one centrally and two 15mm in from the edges. Run a third bead on the lower long mating edge. Press the upstand firmly into place ensuring adhesive squeezes out along the full length of the upstand. Promptly remove excess squeezed out BB Complete using a soft scraper, then clean off all final smears using a clean, white cloth moistened with white spirit. Do not use water. Allow to cure for 24 hours.

### Splashbacks

Encore splashbacks are solid 5mm solid surface material factory finished to a 320 grit linear sanded finish. Handle splashbacks with care; carry them holding the short edge vertically and the long edge parallel to the ground. Never carry splashbacks flat, thereby guarding against flex related damage. When cutting splashbacks ensure they are fully supported and clamped.

Splashbacks should be installed after the worktops have been sanded to their final all over finish, but before any finishing polish is applied. It is however important that prior to installation the splashback is sanded to the final finish following the instructions above for worktops sanding: once installed it is difficult to achieve an acceptable finish.

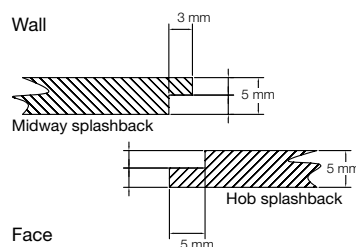
Splashbacks can be customised using a mitre saw, router or jigsaw. Finish any visible cut edges with a sander, going through the grits to achieve a good finish. Cut recesses for sockets using a jig saw introduced through a 10mm hole drilled at each corner.

Ensure that the wall is dry, stable and free of any loose debris or dust. We recommend a dry fit trial before applying adhesives. Finally wipe any dust residues from the rear and lower faces using a damp cloth and allow to dry.

Bond the splashback to the wall using BB Complete colour matched adhesive. Apply blobs to the back of the splashback, approximately 30mm in diameter and 15mm thick, spaced 125mm apart. Apply another seating bead onto the worktop. Press the splashback firmly into place ensuring adhesive squeezes out against the worktop along the full length of the splashback. Promptly remove excess squeezed out BB Complete using a soft scraper, then clean off all final smears using a clean, white cloth moistened in white spirit. Do not use water. Allow to cure for 24 hours.

### Joining splashbacks

A seamless joint is possible by cutting a rebate to ensure a strong well aligned joint. Follow the cleaning, gluing and sanding instructions as for joints to achieve a seamless finish. See figure below.



### Tiling

Never tile directly onto the worksurface, allow a 5mm gap for sealant. Lay a 5mm thick MDF guide strip on the surface and tile down onto it. Fill the resulting gap with robust neat bead of BB Complete colour matched adhesive before grouting. This final finish is waterproof, neat and will last much longer than a thin layer of silicone laid across the face of the tiles. It also simplifies removing the surfaces without disturbing the tiles should it be necessary.

### Sealing

All raw core material must be sealed against moisture. For instance side and back cut edges, within sink cut-outs and tap holes. We recommend a good coat of BB Complete colour matched adhesive.

Encore is backed with high-pressure laminate which will prevent moisture from entering the worktop in normal kitchen conditions. However it is good practice to protect the home owner from costly replacements with a few simple measures:

When assembling joints and applying edge strips ensure adhesive squeezes

out of the lower face to ensure a robust moisture barrier.

Install additional moisture protection above dishwashers & washing machines. It is vital that dishwasher baffles are correctly installed to protect the surface should the dishwasher door be opened or prove faulty.

It is good practice to apply additional moisture protection in front of the sink to protect from spillage. BB Complete is the ideal sealant.

Hob cut-outs should be sealed with the roll of aluminium tape supplied within the Encore installation kit. Ensure that it overlaps top and bottom faces of the worksurface.

Finally it is good practice to run a bead of sealant around the worksurface at its juncture with the wall. We recommend colour matched BB Complete.

### Final application of polish and hand over

Bushboard Professional Worktop Polish is included in every Installation Kit. Applied weekly the polish provides a protective layer that maintains the beauty of the worksurfaces, splashbacks and upstands.

Once the final sanding processes are complete and the finish has been brought fully up to the final colouration, ensure the surface is fully clean, dry and dust free. Next follow the instructions on the Professional Worktop Polish pack, taking special care to apply it generously and to wait ten minutes between the two initial coats.

The consumer should be left with both the Professional Worktop Polish and our Care and Maintenance Leaflet and advised to follow the instructions in relation to care and maintenance and removing scratches. We advise that the home owner applies polish weekly ongoing as part of their normal cleaning regime.

Back cover:  
Espresso glass slimline worktop with Franke undermount sink.



For technical support on Bushboard products, please  
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