

**Below are simplified instructions for forming around a Sink Mold. These instructions illustrate the Wave Sink Mold, with Slot Drain. When using a sink mold with a standard drain (circular), please disregard any parts of these instructions that detail the use of the plexiglass slot to create a drain.**

**Please check out our DIY Videos on YouTube at [www.youtube.com/ExpressionsLTD](http://www.youtube.com/ExpressionsLTD)**

1. Build your countertop form as normal (sides to your mold, etc.). A few of our sink molds may have a slight bow in them, where you would expect a straight edge. Generally the bowing is so slight, you will not notice it in the finished concrete. However, if you want to reduce the bowing, cut a board slightly longer than the inside length of the mold, and wedge the board into the mold. Do not go more than about ¼" longer than the inside dimensions of the mold, or it could add too much stress to the fiberglass. This can also make removing the mold easier, as you can remove the board first and the fiberglass mold will 'shrink' away from the concrete.
2. Place silicone along the bottom of the mold, and then place the sink mold into your formed area. Give that silicone about 30 minutes to set, and then create an even silicone bead all around the perimeter of the mold.
3. Place the Plexiglas slot-drain knockout onto the sink mold (or use the blue foam drain knockout for circular, standard drains). The Plexiglas piece is cut with sloped sides to aid in easy removal from the concrete. Note which direction you mount the Plexiglas, as you will need to push it out of the concrete from the narrow side.
4. Clean up your mold as the next step will make it hard to access parts of the mold later. Also add any other features (such as faucet hole knockouts) to your countertop. We recommend waxing the mold with a carnauba wax, and then applying the Fiberglass liquid release agent which we sell.
5. Next build a form to 'box' in the sink mold. Generally building a simple square or rectangular form is sufficient. You can make angles in your form (as we have done in the pictures) to use less concrete (less weight to move). Make sure the form sides come at least 1" (we usually do at least 1 ½") above the sink mold. When the concrete is done and flipped out of the mold, you want the bottom of the sink to usually be 1 ½" thick or thicker.
6. There are many ways to pour the concrete. We usually just fill the mold with concrete, and then vibrate it all. The concrete around the sink mold will push out under the sides of the form you build around it. We take what oozes out, and put it back in the top and vibrate some more. Generally we do this about 5 times. It seems to get the majority of air pockets out of the sink mold. Depending on the slump of your concrete, you may have kept putting the concrete that oozes out back in the top of the mold for about 30 minutes as it will slowly push out even if you aren't vibrating it. There are other methods which may work better, but this is usually the easiest way.
7. Once the concrete is sufficiently set-up (usually 3 days or more), disassemble the mold. If the concrete is sticking to the mold as you peel it away, it's too green still and needs to set-up before you take off any more of the mold (wait another day or two).
8. Sometimes flipping the concrete piece over will separate it from the sink mold. If it doesn't, it may require some pulling of the mold (thus the fiberglass/wood blocks inside the mold). Occasionally a mold will be difficult to release. If this happens, try not to pry or hit the mold as you could easily damage the fresh concrete or the sink mold. Compressed air is another great way to separate a mold from concrete. Shoot the air between the mold and the concrete, or through the drain hole so it 'pushes' the mold out of the concrete. Be careful to not damage your green concrete from too strong of a blast of compressed air though. You can also fill the fiberglass mold shell with ice and cold water- the quick shrinking of the fiberglass will usually make the most stubborn pieces release. The current Dura-Blu line of Sink Molds from Expressions LTD have a plywood base which can be used to lightly apply pressure to with clamps, to aid in extracting stubborn molds. As a last resort, you can push the fiberglass mold back out through the concrete from the bottom after you remove the drain knockout (foam for regular circular drains). It is tough to remove the plexiglass drain before the fiberglass mold is removed however. Remember which direction the plexiglass was supposed to be tapped out before you do any tapping on it!
9. The drain slot is sloped, so will only come out one way. Once the sink mold is out, you can lightly tap the drain slot (use an object roughly the same size and the thickness on the Plexiglas slot piece. REMEMBER to tap it out according to the sloped sides.
10. For Slot Drains: Once the concrete is finished, and usually installed in place, attach either the ABS or Stainless Steel Drain Kit ([available online www.Expressions-LTD.com](http://www.Expressions-LTD.com)), and then connect plumbing as usual.

