

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

1. Build your countertop form as normal (sides to your mold, etc.).
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. For 'Slot Drains' as pictured, place the Plexiglas slot-drain knockout onto the sink mold with a few dabs of silicone. (For normal drains, place the drain hole knockout on the mold and silicone in place) The Plexiglas piece can be cut easily on a chop saw to sloped the ends, 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 3-5 coats of our Mold Release Wax, and then applying a very thin, even coating of 880 Spray Release.
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 to use less concrete. Make sure the form sides come at least 1" (we usually do at least 1 1/2") 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 around 1-1/4" to 1-1/2" thick.
6. There are many ways to pour the concrete. We have a Concrete Mix Recipe section on our website under RESOURCES (top right of our site) to help assist with making high strength concrete mixes. 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 box form around the sink mold. We take what oozes under 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 and countertop. Depending on the slump of your concrete, you may have keep putting the concrete that oozes out back in the top of the mold for about 30 minutes as it may slowly push out even if not vibrating it. There are other methods which may work better, such as GFRC and skipping the whole 'box around the sink mold' part, but this is usually the easiest way.
7. Once the concrete is sufficiently set-up (usually 2-3 days), 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). Wet curing (covering form with plastic and pouring water on the concrete periodically over the first 2 days) will help strengthen the concrete and reduce shrinkage cracking.
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 to release it. 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. Pushing the sink mold out of the concrete through the drain hole is one of the easiest ways to free a stuck mold.
9. If using a slot drain mold, as pictured, and you sloped the ends of the plexiglas slot piece, remember that it 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. Finish the concrete as desired (sand with 200 grit, slurry any voids/pinholes, color with acid or waterbased concrete stains, and seal with a good Countertop Sealer (all these are on our website).
11. For Slot Drains: Once the concrete is finished, and usually installed in place, attach either the ABS or Stainless Steel Drain Pan (available online www.Expressions-LTD.com), and then connect plumbing as usual.

