

# HI·MACS

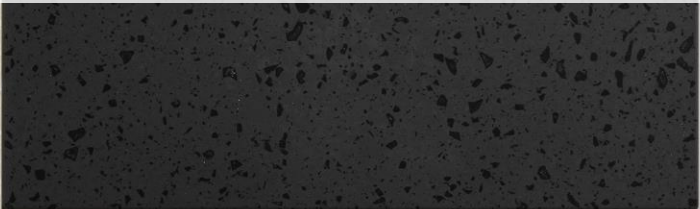
The shape of your ideas



HIMACS GRANITE, SAND & PEARL COLLECTION

## TDS – TECHNICAL DATA SHEET

Solid Surface Material



Colours belonging to the Granite, Sand & Pearl collection exhibit a greater variation in colour, shading, and pattern than is apparent in small size samples. Even A4-size samples and full-sheet photographic images can't fully capture these variations. If possible, allow the customer to view the actual material together with seaming layout examples and have the customer sign a "declaration of understanding" to help assure that the finished countertop is consistent with customer expectations.

When fabricating Granite, Sand & Pearl colours it's important to use consecutive sheets whenever there will be a field seam or a seam creating a "U"- or "L"-shaped countertop. Even with consecutive sheets it's important to visually verify alignments before beginning fabrication. In some cases, rotating one sheet 180-degrees may deliver the desired consistent or uniform alignment. In other cases, it may be necessary to sacrifice some material to join areas that are similar. Either approach can not only deliver a more pleasing appearance but will minimise the visibility of seams and joints.

## 1. Product Specifications

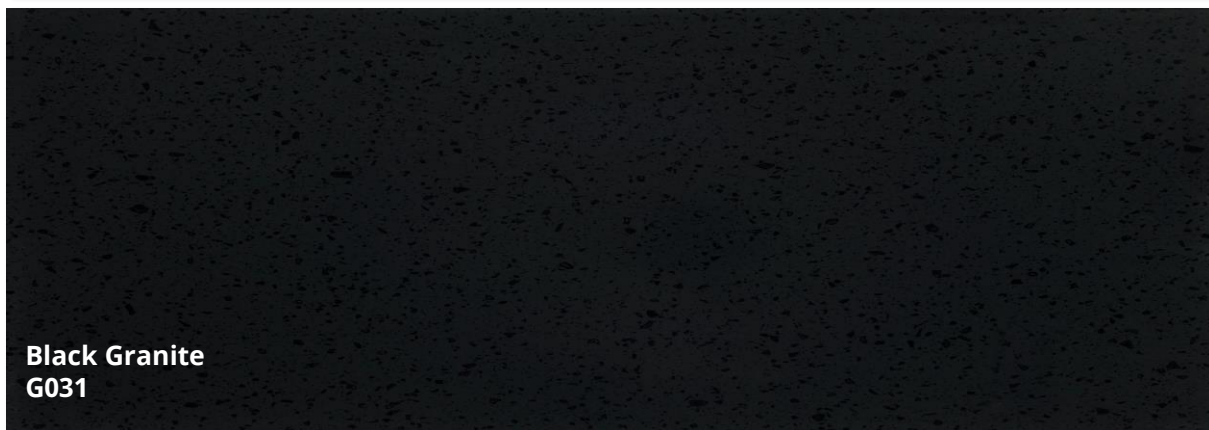
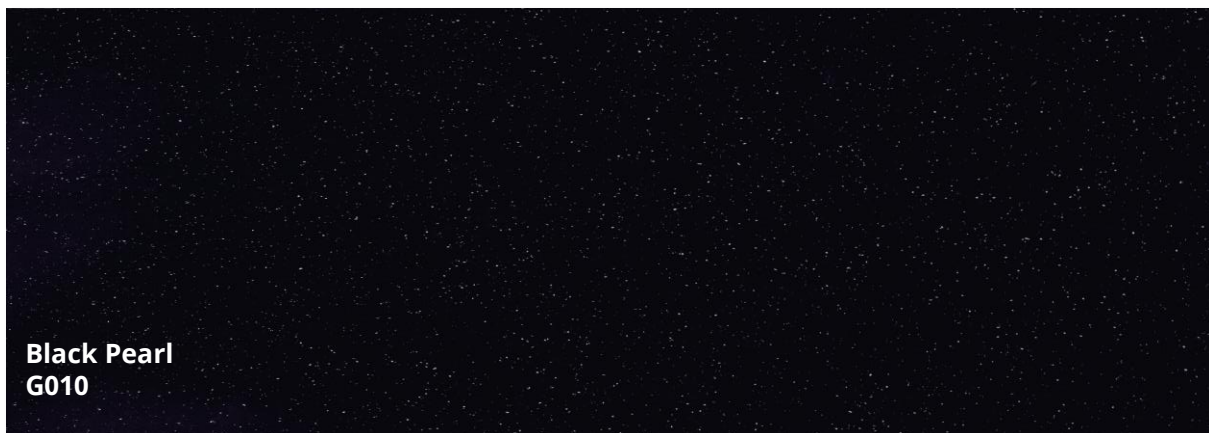
### Available colours



Granite, Sand & Pearl, Available colours :



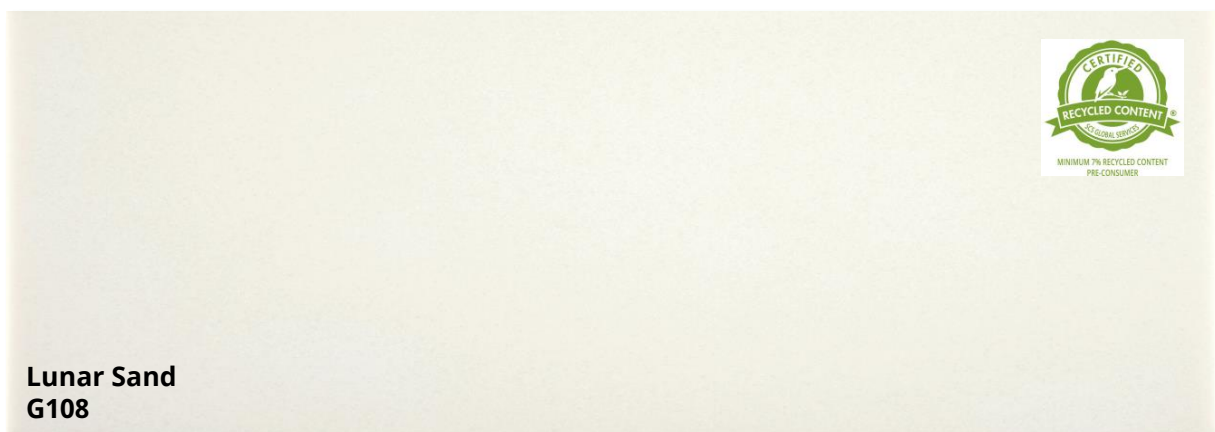
Granite, Sand & Pearl, Available colours :



**Granite, Sand & Pearl, Available colours :**



Granite, Sand & Pearl, Available colours :



Granite, Sand & Pearl, Available colours , recycled content :



## 2. Sheet Specifications

GROUP	COLOUR CODE	COLOUR NAME	SHEET THICKNESS	SHEET SIZE (Width x Length)	m <sup>2</sup> PER SHEET	WEIGHT PER SHEET	WEIGHT PER m <sup>2</sup>	SHEETS PER PALLET
GRANITE, SAND & PEARL	G002	Grey Sand	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	G004*	White Quartz*	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	G009	Black Sand	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	G010	Black Pearl	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	G031	Black Granite	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	G034*	Arctic Granite*	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	G038	Sea Oat Quartz	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	G048	Beach Sand	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	G100	Peanut Butter	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	G101	Crystal Beige	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	G108*	Lunar Sand*	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	G174	Mocha Stone	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	G180*	Cotton Field*	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	G181*	Windy Hill*	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	G183*	Highland*	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15

- \*G004 contains minimum 10% of pre consumer recycled plastic resin (certificate# SCS - RC - 09994)
- \*G034 / G108 contains minimum 7% of pre consumer recycled plastic resin (certificate# SCS - RC - 09992)
- \*G180 contains minimum 14% of pre consumer recycled plastic resin (certificate# SCS - RC - 06283)
- \*G181 contains minimum 13% of pre consumer recycled plastic resin (certificate# SCS - RC - 06284)
- \*G183 contains minimum 12% of pre consumer recycled plastic resin (certificate# SCS - RC - 06285)

## 2. Sheet Specifications

GROUP	COLOUR CODE	COLOUR NAME	SHEET THICKNESS	SHEET SIZE (Width x Length)	m <sup>2</sup> PER SHEET	WEIGHT PER SHEET	WEIGHT PER m <sup>2</sup>	SHEETS PER PALLET
GRANITE, SAND & PEARL	G004	White Quartz	6 mm	760mm x 2490mm	1,8924	19,87 kg	10,49 kg	30
			6 mm	910 mm x 2490 mm	2,266	23,79 kg	10,49 kg	30
	G010	Black Pearl	6 mm	760mm x 2490mm	1,8924	19,87 kg	10,49 kg	30
			6 mm	910 mm x 2490 mm	2,266	23,79 kg	10,49 kg	30
	G034	Artic Granite	6 mm	760mm x 2490mm	1,8924	19,87 kg	10,49 kg	30
			6 mm	910 mm x 2490 mm	2,266	23,79 kg	10,49 kg	30
	G101	Crystal Beige	6 mm	760mm x 2490mm	1,8924	19,87 kg	10,49 kg	30
			6 mm	910 mm x 2490 mm	2,266	23,79 kg	10,49 kg	30

GROUP	COLOUR CODE	COLOUR NAME	SHEET THICKNESS	SHEET SIZE (Width x Length)	m <sup>2</sup> PER SHEET	WEIGHT PER SHEET	WEIGHT PER m <sup>2</sup>	SHEETS PER PALLET
GRANITE, SAND & PEARL	G004	White Quartz	9 mm	760mm x 3680mm	2,7968	43,75 kg	15,64 kg	20
			9 mm	910 mm x 3680 mm	3,3488	52,37 kg	15,64 kg	20

GROUP	COLOUR CODE	COLOUR NAME	SHEET THICKNESS	SHEET SIZE (Width x Length)	m <sup>2</sup> PER SHEET	WEIGHT PER SHEET	WEIGHT PER m <sup>2</sup>	SHEETS PER PALLET
GRANITE, SAND & PEARL	G004	White Quartz	20 mm	760 x 3000 mm	2,28	77,5 kg	33,9 kg	10
	G034	Arctic Granite	20 mm	760 x 3000 mm	2,28	77,5 kg	33,9 kg	10

## 3. Sheet & Matching adhesives

SHEET			ADHESIVE		
GROUP	COLOUR CODE	COLOUR NAME	COLOUR CODE	COLOUR NAME	PACKAGING UNIT
GRANITE, SAND & PEARL	G002	Grey Sand	H003	Gray	45ml / 250ml
	G004	White Quartz	H036	Silver	45ml / 250ml
	G009	Black Sand	H042	Merapi	45ml / 250ml
	G010	Black Pearl	H007	Black	45ml / 250ml
	G031	Black Granite	H007	Black	45ml / 250ml
	G034	Arctic Granite	H036	Silver	45ml / 250ml
	G038	Sea Oat Quartz	H044	Mikeno	45ml / 250ml
	G048	Beach Sand	H004	Peanut	45ml / 250ml
	G100	Peanut Butter	H004	Peanut	45ml / 250ml
	G101	Crystal Beige	H032	Ivovy	45ml / 250ml
	G108	Lunar Sand	H036	Silver	45ml / 250ml
	G174	Mocha Stone	H037	Mocha	45ml / 250ml
	G180	Cotton Field	H002	Alpine White	45ml / 250ml
	G181	Windy Hill	H001	Satin White	45ml / 250ml
	G183	Highland	H123	Semi Trans	45ml / 250ml

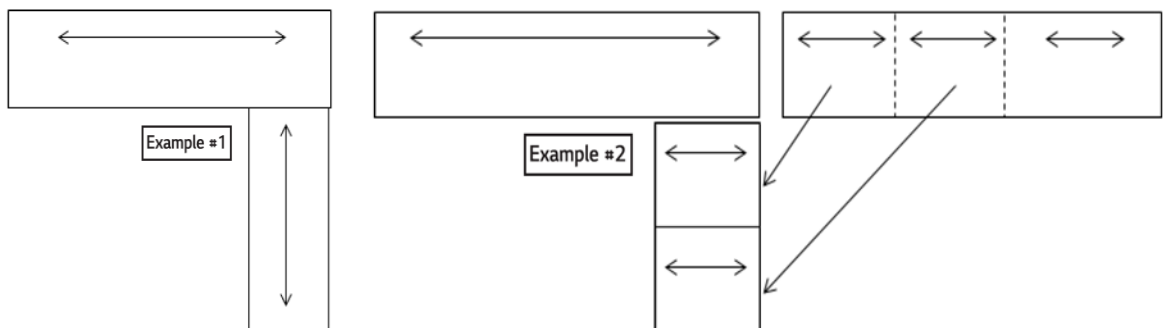
## 4. LRV : Light Reflectance Values

GROUP	COLOUR CODE	COLOUR NAME	LRV
GRANITE, SAND & PEARL	G002	Grey Sand	47.69
	G004	White Quartz	67.98
	G009	Black Sand	10.45
	G010	Black Pearl	7.01
	G031	Black Granite	5.64
	G034	Arctic Granite	76.69
	G038	Sea Oat Quartz	52.18
	G048	Beach Sand	50.49
	G100	Peanut Butter	43.42
	G101	Crystal Beige	68.88
	G108	Lunar Sand	71.86
	G174	Mocha Stone	10.01
	G180	Cotton Field	77.93
	G181	Windy Hill	61.81
	G183	Highland	20.87

## 5. Fabrication

### 5.1. Sheet to Sheet bonding flow:

Fabricating an "L-shape" or "U-shape" countertop presents other challenges. Depending on the character of the HIMACS material, in some cases you may wish to have the "extension(s)" placed perpendicular to the primary surface (Example «1»). In other cases, you may find that placing the "extension(s)" on the same plane as the primary surface works best (Example #2). There's no way to determine which method will work best with any color other than to visually evaluate the configurations.



#### **Note:**

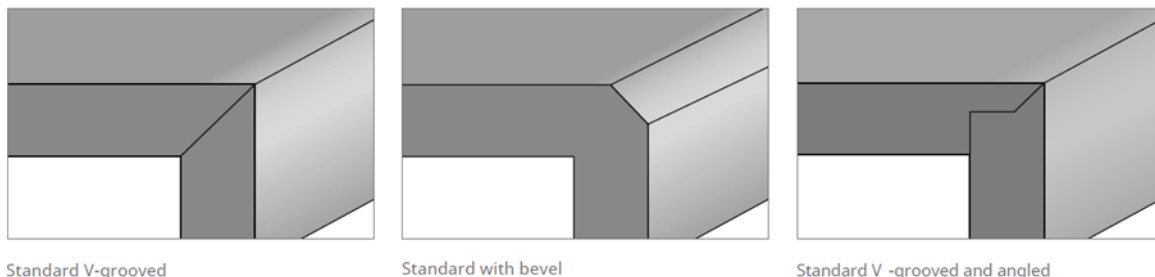
HIMACS adhesive is not developed as filler for repairs. In the case of damage to the surface it is strongly recommended to make a plug repair if possible (tools are available on the market – please contact your local technical support).

Before and during the gluing process between the sheets, check the best possibility of according to the fluidity of the design. Whatever design is chosen visual assessment is the only way to determine the best colour combination.

We strongly advise the fabricator to confirm that the purchaser and the end user understand these considerations before proceeding.

## 5.2. Edge bonding flow:

To let the pattern flow around the edges a 45° angled cut of the edge or an alternative rebate is one of the best solutions.

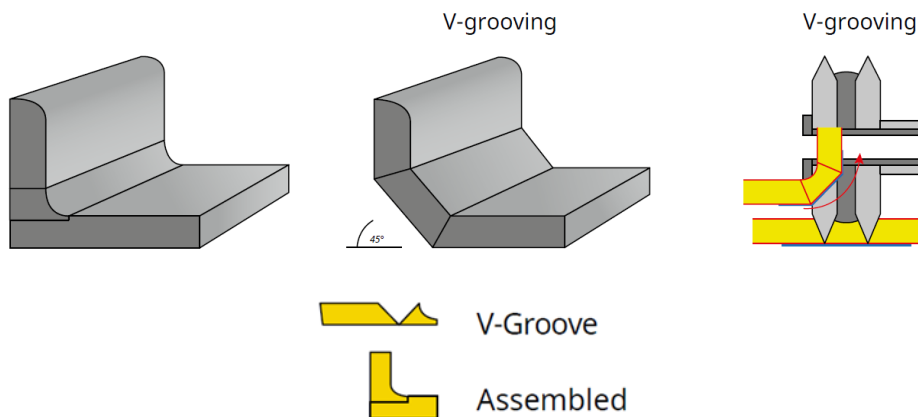


For the bonding process of the edges please follow the instructions of edge treatments.

HIMACS strongly advise the fabricator to confirm that the purchaser and the end user understand these considerations before proceeding whilst best to prepare a sample and let this design sign off.

## 6.3. Backsplash flow:

To let the pattern flow around the edges a 45° angled cut of the edge or an alternative rebate is one of the best solutions.



When preparing a curved upstand or downturn, customers may not accept the result. One may not compare, though with UNI colours mostly used in the kitchen market.

A downturn or an upstand may best achieve with a 45° angle or a profiled folding option – see picture 3

## 6. Sanding (finishing)



### Standard recommendation

FINISH-LEVEL	MATT-FINISH		SEMI-GLOSS-FINISH		HIGH-GLOSS-FINISH	
HIMACS colour family	for all colours		for all colours		for all colours	
Sanding steps	micron-sandpaper	grid-sandpaper	micron-sandpaper	grid-sandpaper	micron-sandpaper	grid-sandpaper
Step 1	100/80 µ	150/180 µ	100/80 µ	150/180 µ	100/80 µ	150/180 µ
	take dust away		take dust away		take dust away	
Step 2	60 µ	220	60 µ	220	60 µ	220
	take dust away		take dust away		take dust away	
Step 3	"useit®" Superpad S/G Scotch Brite™ Maroon 7447	280	40/30 µ	280/320	30 µ	280/320
	take dust away		take dust away		take dust away	
Step 4	industrial paper towel	"useit®" Superpad S/G Scotch Brite™ Maroon 7447	"useit®" Superpad S/G Scotch Brite™ Maroon 7447	380/400	15 µ	380/400
	take dust away		take dust away		take dust away	
Step 5		industrial paper towel	industrial paper towel	"useit®" Superpad S/G Scotch Brite™ Maroon 7447	9 µ	600/800
			take dust away		take dust away	
Step 6				industrial paper towel	Finesse-it™ Finish- component	1200
			take dust away		take dust away	
Step 7						1500
						1800
						2500

## 7. Thermoforming

To prepare the workpieces, follow the standard thermoforming process (for more information's see FM22EU, 7.15 Thermoforming)

For Thermoforming process to recommend best by using a pre-heating oven with double sided heating plates.

**Heating Temperature:**

**155°C - 175°C**



**Heating Time:**

**12 - 30 min.**



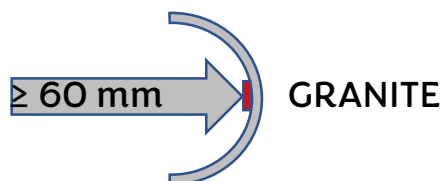
The heating time is equivalent to the general heating time of HIMACS products for the thermoforming process.

- The classification for 2D application, of a minimum radius for Granite (12mm)  $\geq 60$ mm.
- Be aware that any undertaking of recommended radii can cause some colour change or create some cracks.

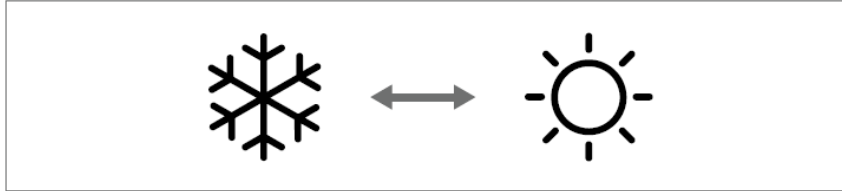
For further details of thermoforming process see also our FM22 EU, section 7.15 THERMOFORMING.

For any technical inquiry contact your local technical support.

For more detailed thermoforming equipment or any thermoforming accessories please contact [global@nabuurs.com](mailto:global@nabuurs.com) or visit the web-site: [www.globalvacuumpresses.com](http://www.globalvacuumpresses.com)

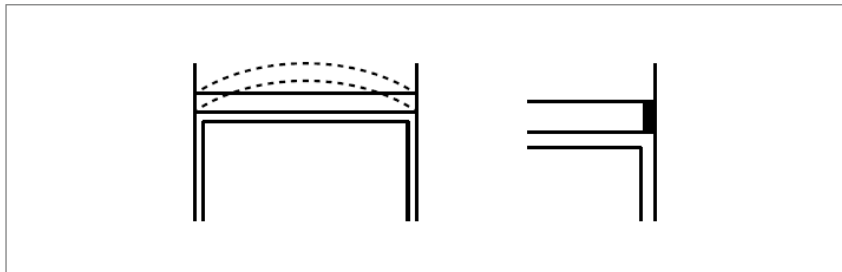


## 8. Thermal Expansion



Sufficient space should be given to compensate for expansion or contraction at the time of installation since this product may expand or contract depending on the temperature.

**Allow 1.5 mm per linear meter for expansion and contraction.**



Expansion coefficient HIMACS according to norm DIN EN 14851:

$$\Delta t = \text{ca. } 38 \times 10^{-6} / \text{K}$$

## 9. Quality Check

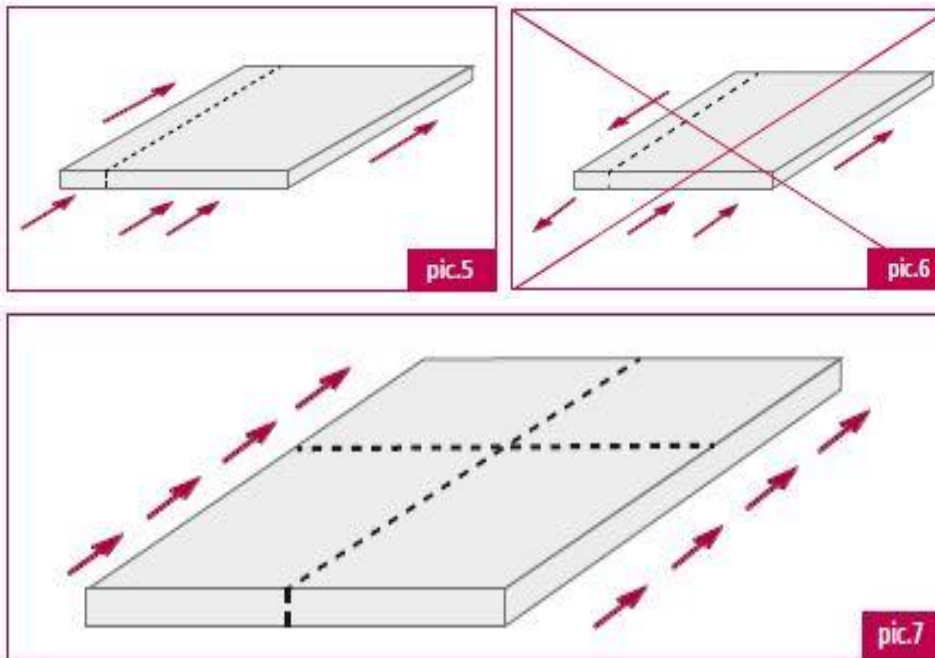
- Check any fabricated item on quality aspects before leaving the workshop.
- In case of any mistakes, it easily can be repaired in the workshop and keeps the time of re-work very low.
- Any damage or any mistake which will be recognized later will make the fixing much more expensive.

### **Important information:**

The 15 Year Limited Installed Warranty does not cover any failures due to fabrication or installation mistakes.

## 10. Summary of important information :

When using several sheets for doing one job ensure a continuous flow of sequential numbers as well as the same production flow. Do not turn one sheet into a different direction from the next or opposite side (**no turn** of any sheet by 90°, 180° or 270°).



- Granite Sand & Pearl are equivalent material as any other HIMACS product, but it requires special consideration to fabricate an aesthetically pleasing finished product. We strongly advise the fabricator to confirm that the purchaser and the end user understand these considerations before proceeding.
- The 15 Year Limited Installed Warranty does not cover any failures due to fabrication or installation mistakes.
- It is Fabricator's responsibility to find the best assembling arrangement of the design, layout as samples show above.
- Design may can change in size when turning into a curve. As smaller the radius becomes as wider the veins gets but even more cautions to be taken, when using dark colours to avoid unexpected whitening.

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