

HI·MACS

The shape of your ideas

HIMACS LUCENT COLLECTION

TDS - TECHNICAL DATA SHEET

Solid Surface Material

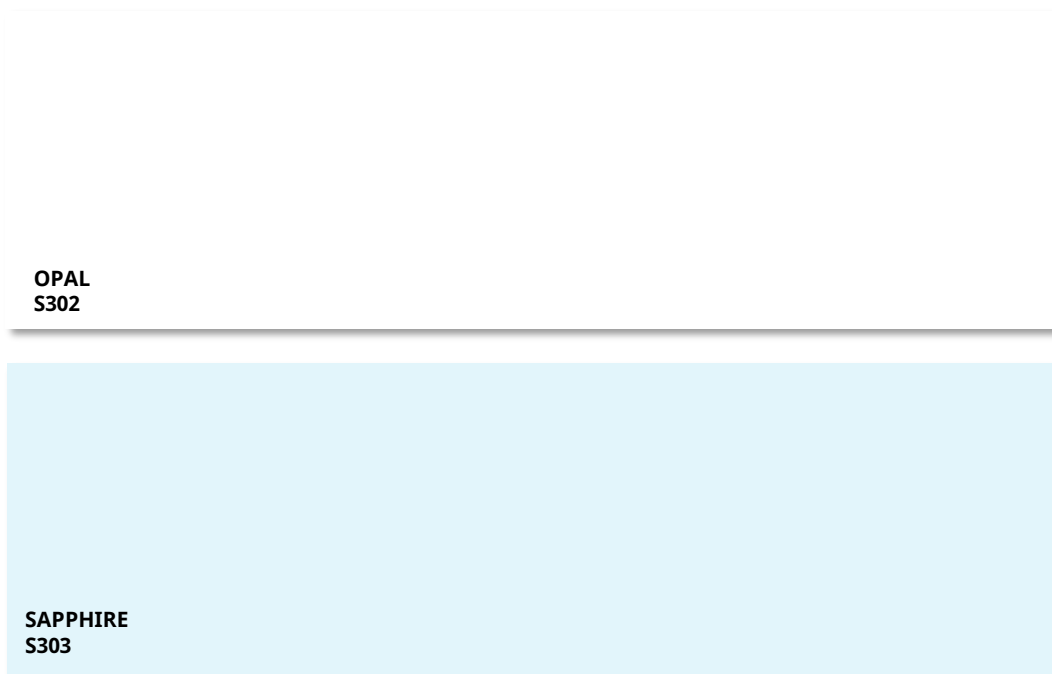
Translucency and effective use of light are decisive design elements of contemporary architecture – the shades of the Lucent Collection, with their exceptional light. This Technical information summarizes specific characteristics and properties of HIMACS translucent material which must be taken into consideration when fabricating or installing HIMACS products.

1. Product Specifications

Available colours



Available colours – Full sheet view



Available colours - Full sheet view



RUBY
S304



EMERALD
S305

2. Sheet Specifications

GROUP	COLOUR CODE	COLOUR NAME	SHEET THICKNESS	SHEET SIZE (Width x Length)	m ² PER SHEET	WEIGHT PER SHEET	WEIGHT PER m ²	SHEETS PER PALLET
Lucent	S302	Opal	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S303	Sapphire	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S304	Ruby	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S305	Emerald	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15

GROUP	COLOUR CODE	COLOUR NAME	SHEET THICKNESS	SHEET SIZE (Width x Length)	m ² PER SHEET	WEIGHT PER SHEET	WEIGHT PER m ²	SHEETS PER PALLET
Lucent	S302	Opal	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

3. Sheet & Matching adhesives

SHEET			ADHESIVE		
GROUP	COLOUR CODE	COLOUR NAME	COLOUR CODE	COLOUR NAME	PACKAGING UNIT
Lucent	S302	Opal	T002	OPAL	45ml / 250ml
	S303	Sapphire	T003	SAPPHIRE	45ml / 250ml
	S304	Ruby	T004	RUBY	45ml / 250ml
	S305	Emerald	T005	EMERALD	45ml / 250ml

4. LRV , PANTONE, RAL Classic & NCS

GROUP	COLOUR CODE	COLOUR NAME	LRV	PANTONE	RAL Classic	NCS
Lucent	S302	Opal	77,45	11-4800TPX	-	S 0502-B
	S303	Sapphire	57,05	544M	-	S 1010-R90B
	S304	Ruby	69,7	373M	-	S 0510-R30B
	S305	Emerald	65,87	317M	-	S 0520-B70G

5. Guidelines for translucent use.

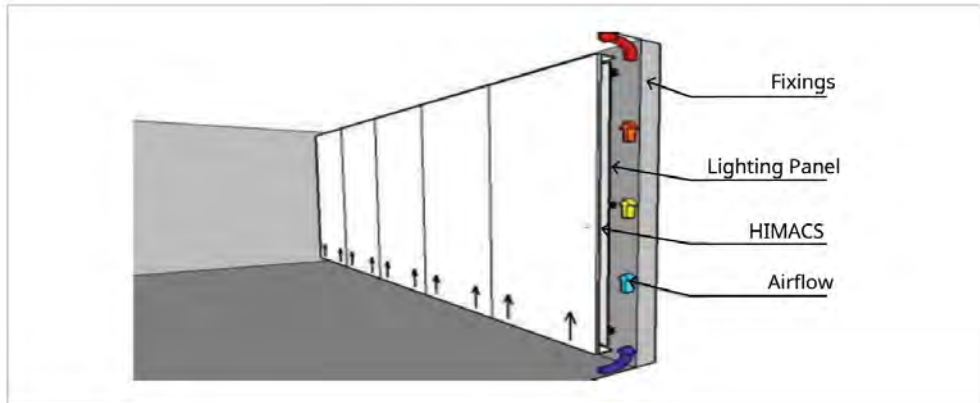
The translucent properties of HIMACS LUCENT gives many opportunities to manage your project, important recommendations have to be taken in account during your building process.

- It is recommended to follow the sequential number of sheets production to ensure the consistency of your work.
- For backlight application with HIMACS LUCENT, the back of the sheet must be re sanded to ensure a perfect aspect.
- As mentioned previously, as backlight application doesn't give any tolerance on the surface aspect, a special care will be paid on the back side to avoid any marks.

Light selection :

As many lighting solution exists on the market, it is recommended check the visual aspect via a prototype. This will confirm or not your expectations.

About the selected lighting it is recommended to check the heat created to adjust the air flow circulation of your project.

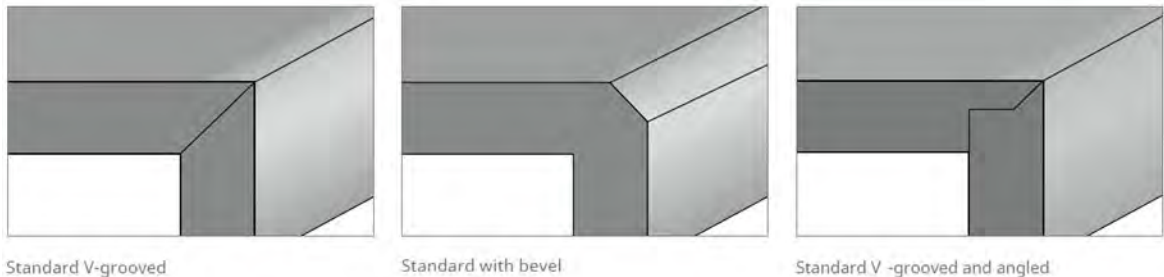


Fabrication with Translucent HIMACS is a precise work who will require all your attention to avoid mistake which could influence the result of your project.

6. Edge & Backsplash

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.

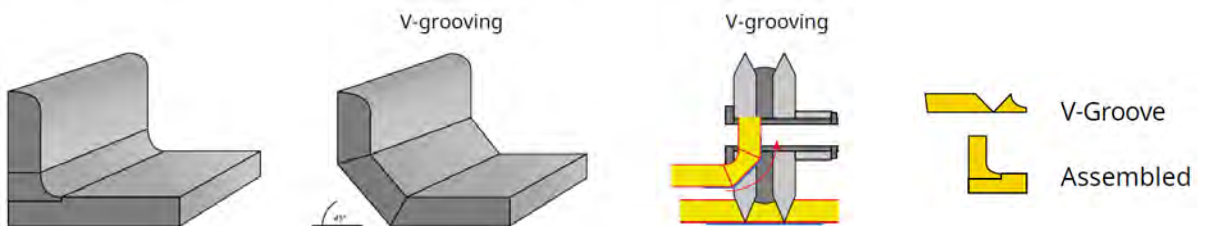


For the bonding process of the edges please follow the instructions of edge treatments.

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.

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.



HIMACS sheets are delivered with a sanded backside, it is strongly recommended for translucent application to sand it smooth or to trim edges to avoid any imperfection. Check all edges before the bonding process, ensure that no cracks or scratches exist. After Sawing, whitening effect can appear.

7. 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

8. 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.



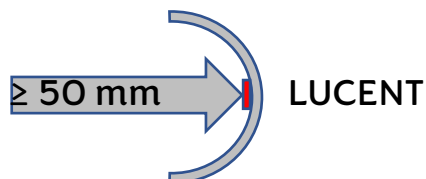
The heating time is equivalent to the general heating time of HIMACS products for the thermoforming process.

- The classification for 2D application, of a minimum radius for LUCENT (12mm) \geq 50mm.
- Be aware that any undertaking of recommended radii can cause some colour change or create some cracks.

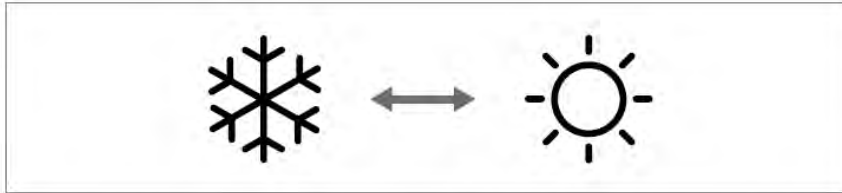
For further details of thermoforming process see also our FM22 EU, section 7.15 THERMOFORMING.

For any technical inquiry contact your local technical support.

For more detailed thermoforming equipment or any thermoforming accessories please contact global@nabuurs.com or visit the web-site: www.globalvacuumpresses.com

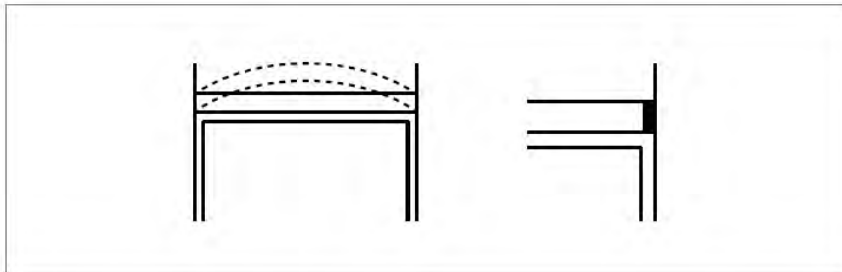


9. Thermal Expansion



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:

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

10. 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.

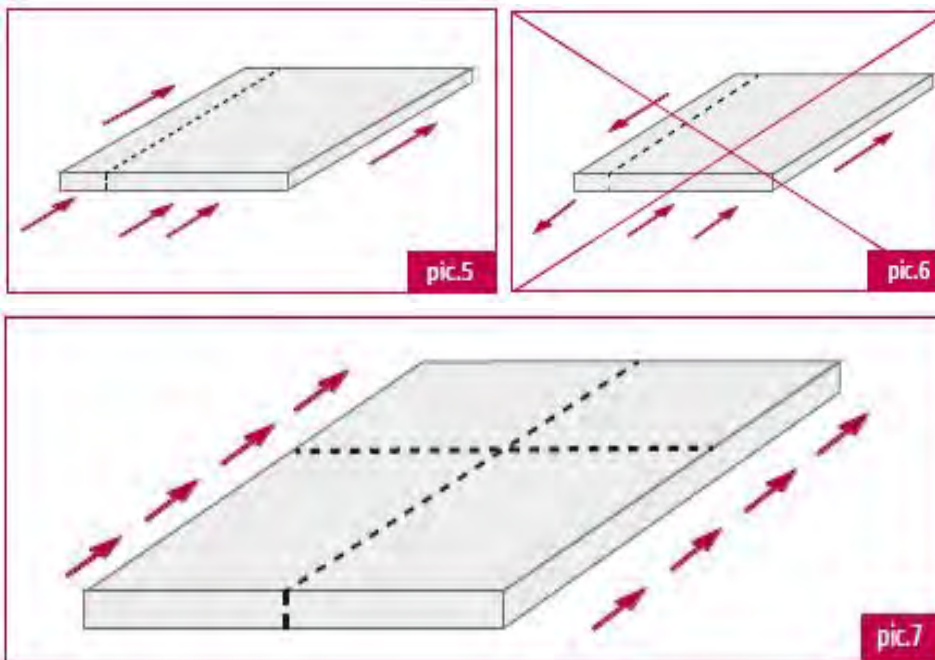
Important information:

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

11. 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°).



- HIMACS LUCENT is equivalent material as any other HIMACS product, but it requires special consideration in order 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 colors to avoid unexpected whitening.

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