

HI·MACS

The shape of your ideas

HIMACS SOLIDS COLLECTION

TDS - TECHNICAL DATA SHEET

Solid Surface Material

- The classic in terms of solid surfaces; a wide range of attractive shades of white lies at the heart of this collection. Complemented by colourful, dynamic uni-shade accents from Lemon Green to Orange. The timeless collection offers the perfect colour for every design.

1. Product Specifications

Available colours

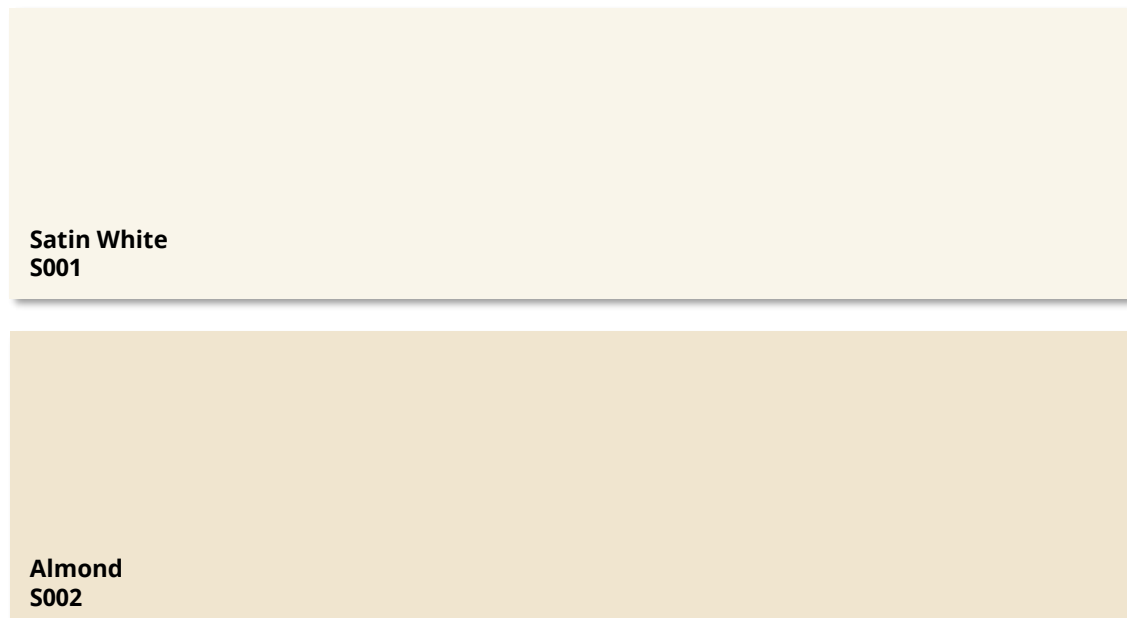


1. Product Specifications

Available colours



Available colours – Full sheet view



Available colours - Full sheet view



Grey
S005



Artic White
S006



Cream
S009



Fiery Red
S025

Available colours - Full sheet view



Banana
S026



Orange
S027



Alpine White
S028

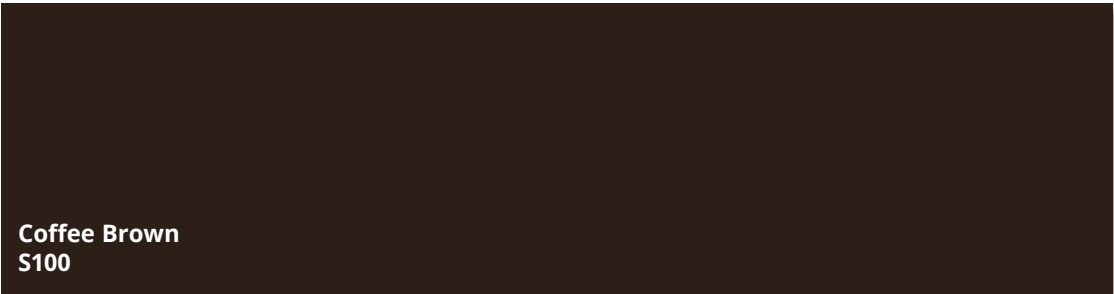


Ivory White
S029

Available colours - Full sheet view




Diamond White
S034



Coffee Brown
S100



Babylon Beige
S102

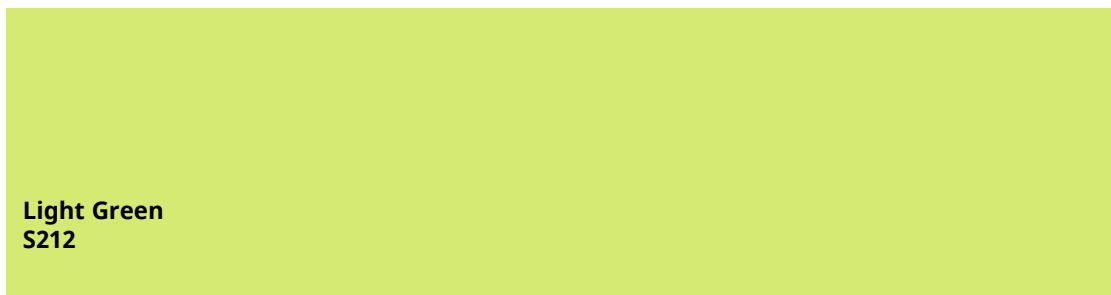
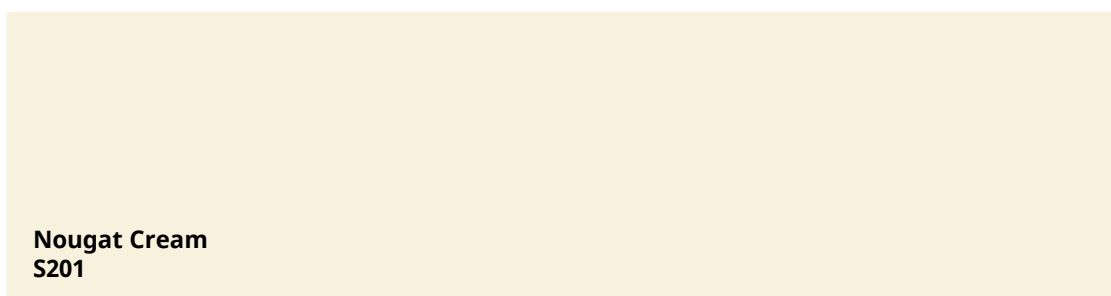


Concrete Grey
S103

Available colours - Full sheet view



Available colours - Full sheet view



Available colours - Full sheet view

Pink Leia
S233

Alpine White
S028E



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
Solids	S001	Satin White	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S002	Almond	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S005	Grey	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S006	Arctic White	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S009	Cream	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S025	Fiery Red	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S026	Banana	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S027	Orange	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S028	Alpine White	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S029	Ivory White	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S034	Diamond White	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S100	Coffee Brown	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S102	Babylon Beige	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S103	Concrete Grey	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S109	Steel Grey	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S111	Dark Night	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S117	Midnight Grey	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S028E*	Alpine White*	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15

* S028E contains minimum 8% of pre consumer recycled plastic resin (certificate# SCS – RC - 09990)

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
Solids	S119	Evergreen	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S121	Suede	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S201	Nougat Cream	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S203	Sky Blue	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S212	Light Green	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	S233	Pink Leia	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
Solids	S001	Satin White	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
	S005	Grey	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
	S006	Arctic White	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
	S009	Cream	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
	S028	Alpine White	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
	S029	Ivory White	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
	S201	Nougat Cream	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

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
Solids	S005	Grey	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
	S028	Alpine White	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
	S034	Diamond White	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 ² PER SHEET	WEIGHT PER SHEET	WEIGHT PER m ²	SHEETS PER PALLET
Solids	S028	Alpine White	20 mm	760mm x 3680mm	2,7968	93 kg	33,25 kg	10

3. Sheet & Matching adhesives

SHEET			ADHESIVE		
GROUP	COLOUR CODE	COLOUR NAME	COLOUR CODE	COLOUR NAME	PACKAGING UNIT
SOLIDS	S001	Satin White	H001	SATIN WHITE	45ml / 250ml
	S002	Almond	H004	PEANUT	45ml / 250ml
	S005	Grey	H003	GRAY	45ml / 250ml
	S006	Arctic White	H002	ARTIC WHITE	45ml / 250ml
	S009	Cream	H121	CREAMY	45ml / 250ml
	S025	Fiery Red	H018	RED	45ml / 250ml
	S026	Banana	H017	BANANA	45ml / 250ml
	S027	Orange	H019	ORANGE	45ml / 250ml
	S028 / S028E	Alpine White	H016	ALPINE WHITE	45ml / 250ml
	S029	Ivory White	H032	IVORY	45ml / 250ml

3. Sheet & Matching adhesives

SHEET			ADHESIVE		
GROUP	COLOUR CODE	COLOUR NAME	COLOUR CODE	COLOUR NAME	PACKAGING UNIT
SOLIDS	S034	Diamond White	H113	DIAMOND WHITE	45ml / 250ml
	S100	Coffee Brown	H037	MOCHA	45ml / 250ml
	S102	Babylon Beige	H052	BABYLON BEIGE	45ml / 250ml
	S103	Concrete Grey	H053	CONCRETE GRAY	45ml / 250ml
	S109	Steel Grey	H101	STEEL GRAY	45ml / 250ml
	S111	Dark Night	T009	DARK NIGHT	45ml / 250ml
	S117	Midnight Grey	H150	NIGHT GREY	45ml / 250ml
	S119	Evergreen	H125	GREEN	45ml / 250ml
	S121	Suede	H126	BEIGE	45ml / 250ml
	S201	Nougat Cream	H020	CREAM	45ml / 250ml
	S203	Sky Blue	H030	DAWN MISTY	45ml / 250ml
	S212	Light Green	H056	LIGHT GREEN	45ml / 250ml
	S233	Pink Leia	H071	PINK LEIA	45ml / 250ml

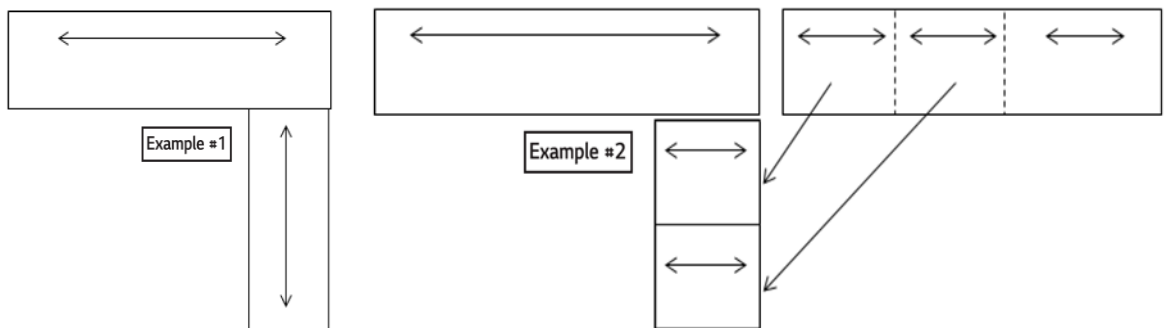
4. LRV – Light Reflectance Values – Colour codes (Pantone – RAL classic – NCS)

GROUP	COLOUR CODE	COLOUR NAME	LRV	PANTONE	RAL Classic	NCS
SOLIDS	S001	Satin White	72,06	11-4800 TPX	-	-
	S002	Almond	53,58	13-0607 TPX	-	S 2005-Y30R
	S005	Grey	45,22	14-4201 TPX	-	S 2500-N
	S006	Arctic White	87,27	11-0601 TPX	9016	S 0300-N
	S009	Cream	77,29	11-0105 TPX	-	S 0502-Y
	S025	Fiery Red	13,97	19-1763 TPX	-	S 2070-R
	S026	Banana	53,83	14-0848 TPX	-	S 1060-Y10R
	S027	Orange	25,13	1665 M	-	S 1080-Y60R
	S028 / S028E	Alpine White	85,12	11-4201 TPX	9003	-
	S029	Ivory White	79,24	11-0602 TPX	-	S 0500-N
	S034	Diamond White	97,09	11-4201 TPX	9003	-
	S100	Coffee Brown	17,28	19-0712 TPX	-	S 8505-Y80R
	S102	Babylon Beige	38,14	14-0210 TPX	-	S 3010-Y20R
	S103	Concrete Grey	14,31	18-4005 TPX	-	S 6502-B
	S109	Steel Grey	22,23	160-1-2 C	-	S 5000-N
	S111	Dark Night	12,88	433 M	-	S 8005-R80B
	S117	Midnight Grey	9,09	19-3906 TPX	-	S 7502-B
	S119	Evergreen	30,79	19-5413 TPG ○	RAL 6004 ○	S 6020-B50G
	S121	Suede	60,32	14-0002 TPG	-	S 2005-Y50R
	S201	Nougat Cream	64,33	12-0000 TPX	-	S 1005-Y40R
	S203	Sky Blue	27,46	644 M	-	S 3020-R90B
	S212	Light Green	58,19	373 M	-	S 0550-G50Y
S233	Pink Leia	52,76	13-1904 TPG ○	RAL 3015 ○	S 0520-R20B	

5. Fabrication guidelines

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 colour other than to visually evaluate the configurations.



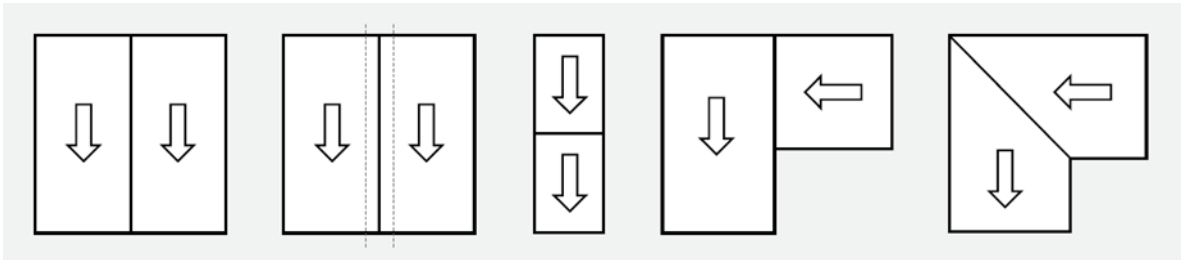
Note:

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.

Recommendation :

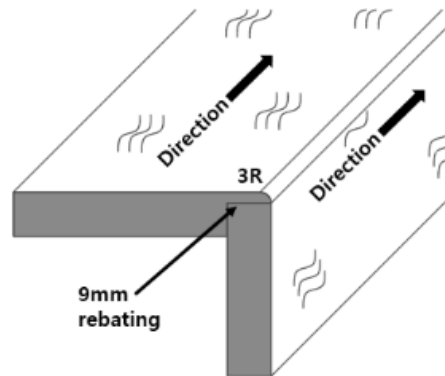
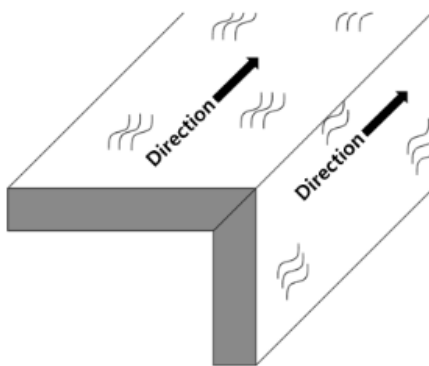
HIMACS SOLIDS is equivalent material as any other HI-MACS" product, but it requires special consideration in order to fabricate an aesthetically pleasing finished product. We strongly advise the fabricator to confirm that the purchaser and the end user understand these considerations before proceeding.



Note:

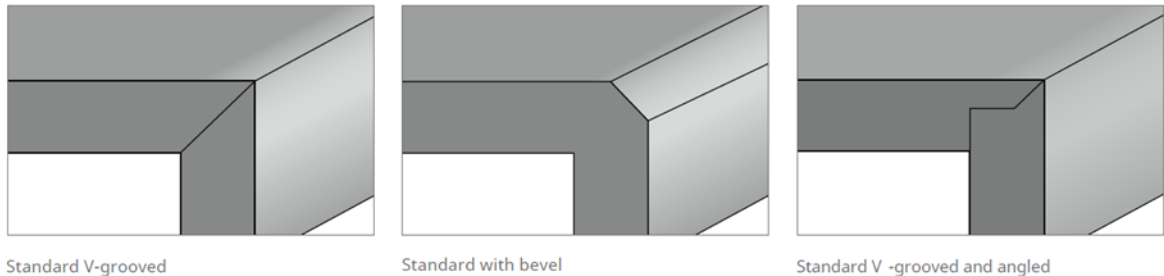
It is Fabricator's responsibility to find the best assembling arrangement of the layout as samples show above.

Recommended edge design



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.

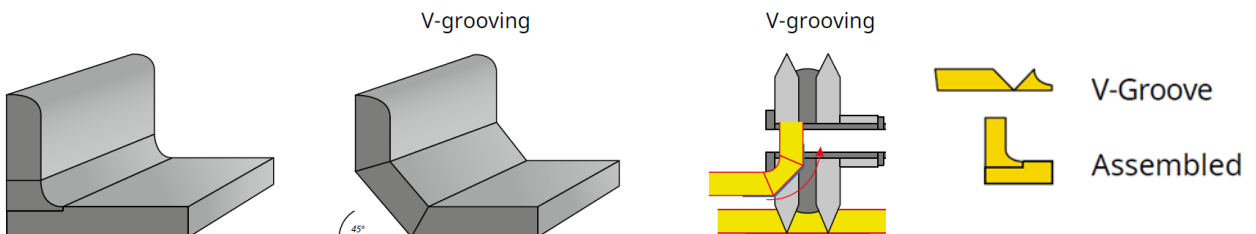


For the bonding process of the edges please follow the instructions of edge treatments.

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.

5.3. 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.

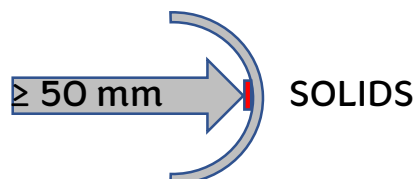
- The classification of a minimum radius for SOLIDS is $\geq 50\text{mm}$.

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 or visit the web-site: www.globalvacuumpresses.com

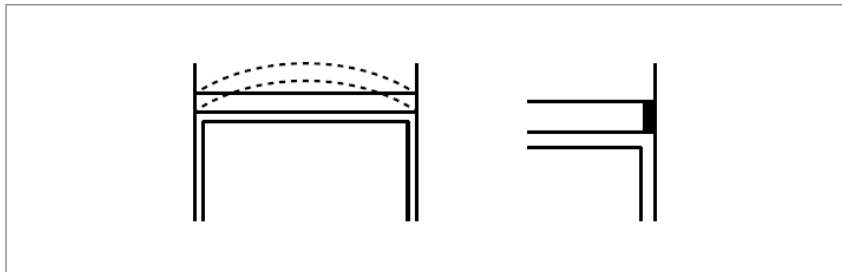


8. Thermal Expansion



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:

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

10. Quality Check

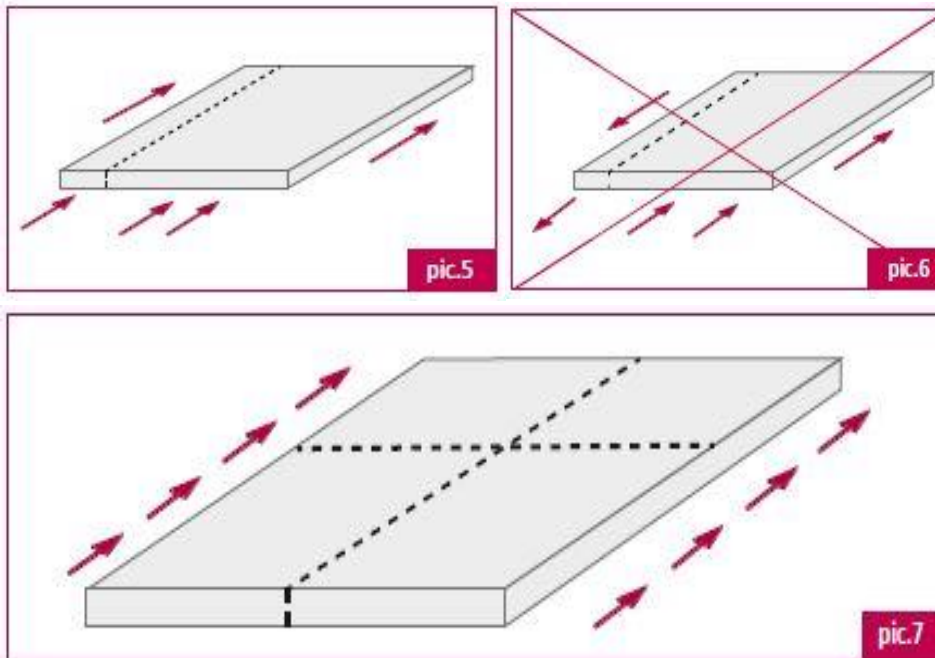
- Check any fabricated item on quality aspects before leaving the workshop.
- In case of any mistakes, it easily can be repaired in the workshop and keeps the time of re-work very low.
- Any damage or any mistake which will be recognized later will make the fixing much more expensive.

Important information:

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

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°).



- HIMACS SOLIDS 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. Unexpected whitening can appear in case of using smaller radius.

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