

# HI·MACS

The shape of your ideas



HIMACS TERRAZZO COLLECTION

# TDS - TECHNICAL DATA SHEET

Solid Surface Material

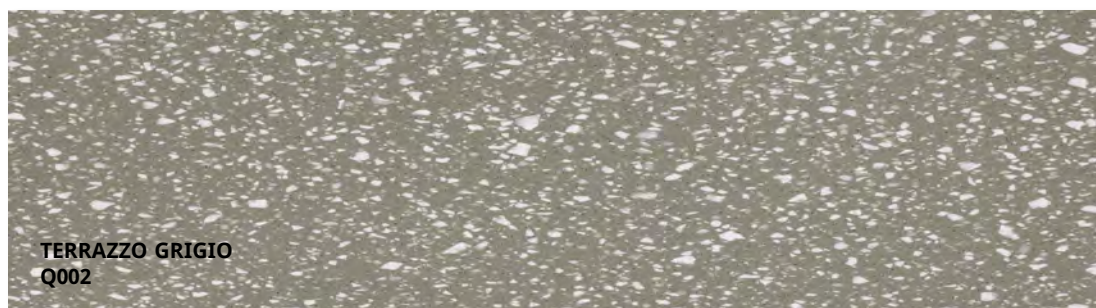
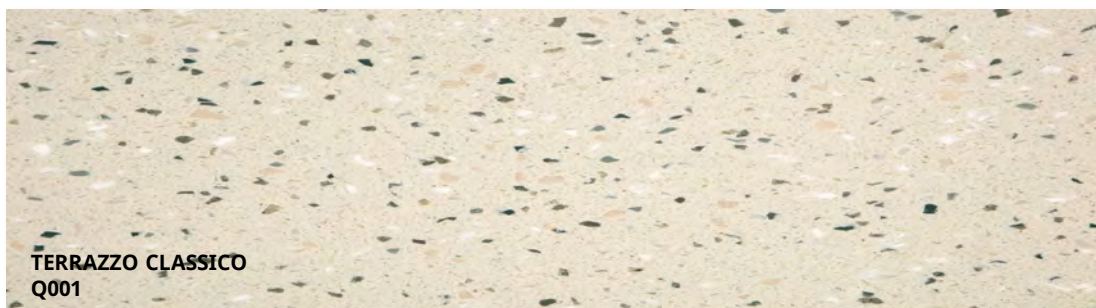
Terrazzo has a long tradition as a material aesthetic: the coarse-grained look has offered the perfect blend of longevity and elegance since antiquity. HIMACS has now adopted the trend with two colours, which both combine perfectly with their typically coarse-grained, 'splattered' look. The Terrazzo Collection is especially suitable for the hospitality and gastronomy sector, as well as for any other high-traffic public building.

## 1. Product Specifications

### Available colours



### Available colours – Full sheet view



## 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
TERRAZZO	Q001	Terrazzo Classico	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	Q002	Terrazzo Grigio	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15

## 3. Sheet & Matching adhesives

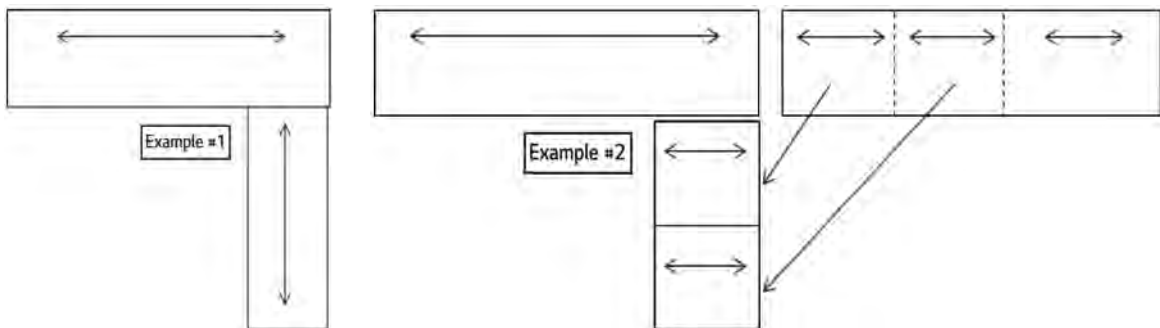
SHEET			ADHESIVE		
GROUP	COLOUR CODE	COLOUR NAME	COLOUR CODE	COLOUR NAME	PACKAGING UNIT
TERRAZZO	Q001	Terrazzo Classico	H032	IVORY	45ml / 250ml
	Q002	Terrazzo Grigio	H109	MUD GREY	45ml / 250ml

## 4. LRV , PANTONE, RAL Classic & NCS

GROUP	COLOUR CODE	COLOUR NAME	LRV	PANTONE	RAL Classic	NCS
TERRAZZO	Q001	Terrazzo Classico	58,29	-	-	-
	Q002	Terrazzo Grigio	26,24	-	-	-

## 5. Fabrication Guidelines

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).

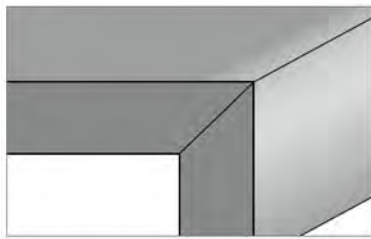
Before and during the gluing process between the sheets, check the best possibility of according to the fluidity of the design. Whatever design is chosen visual assessment is the only way to determine the best colour combination.

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

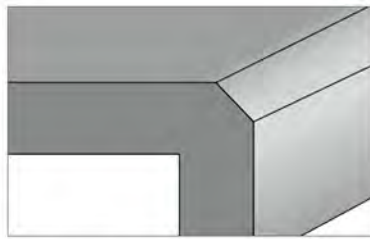
## 6. Edge & Backsplash

### 6.2 Edge bonding flow:

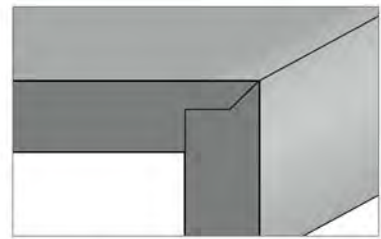
To let the pattern flow around the edges a 45° angled cut of the edge or an alternative rebate is one of the best solutions.



Standard V-grooved



Standard with bevel



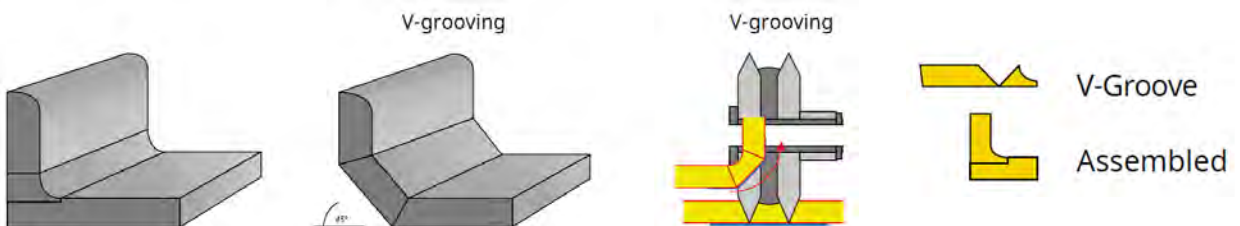
Standard V-grooved and angled

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.



HIMACS sheets are delivered with a sanded backside, it is recommended 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.**



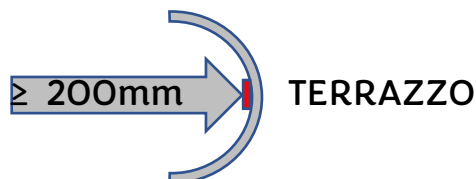
The heating time is equivalent to the general heating time of HIMACS products for the thermoforming process.

- The classification for 2D application, of a minimum radius for TERRAZZO (12mm)  $\geq$  200 mm.
- Be aware that any undertaking of recommended radii can cause some colour change or create some cracks.

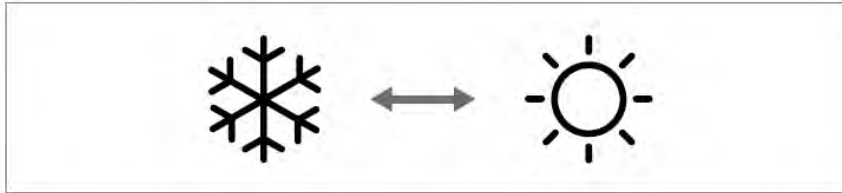
For further details of thermoforming process see also our FM22 EU, section 7.15 THERMOFORMING.

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)

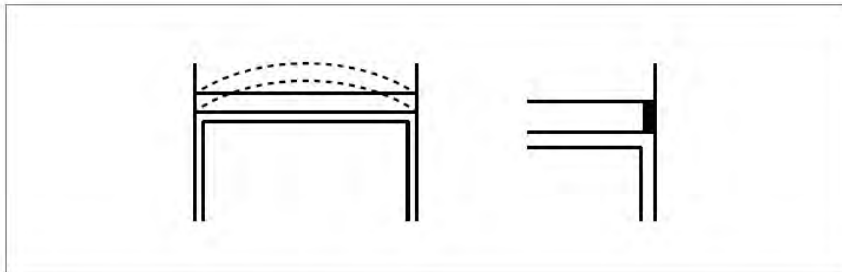


## 9. Thermal Expansion



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.

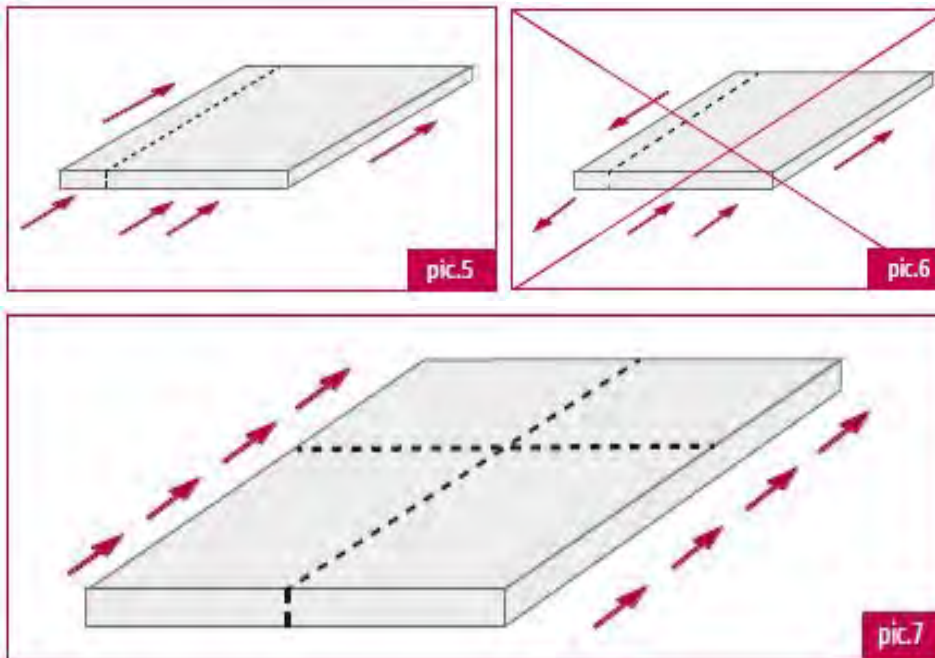
### **Important information:**

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°).



- TERRAZZO 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.
- 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.

LX HAUSYS Europe GmbH  
Lyoner Str. 15  
60528 Frankfurt am Main  
Germany