

HI·MACS

The shape of your ideas

HIMACS VOLCANICS COLLECTION

TDS - TECHNICAL DATA SHEET

Solid Surface Material

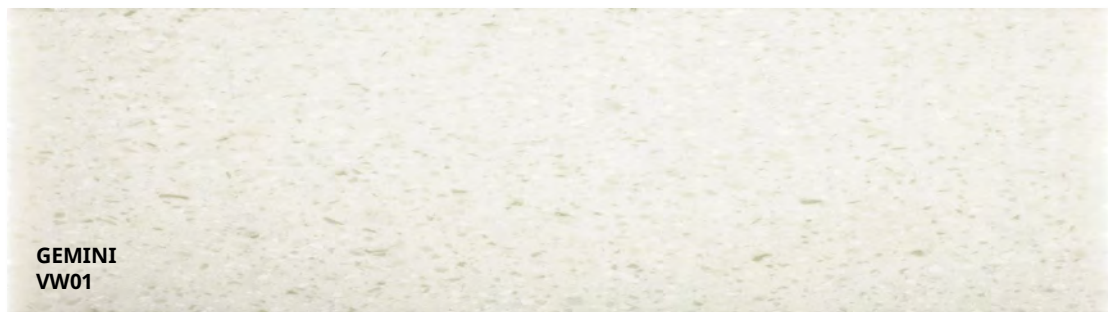
The large particles of the Volcanics shades add a sense of style to any design. When used on a large scale the result is a dramatic showpiece. Three colours from the Volcanics range contain recycled content for an environmentally friendly solution with a luxurious natural stone look.

1. Product Specifications

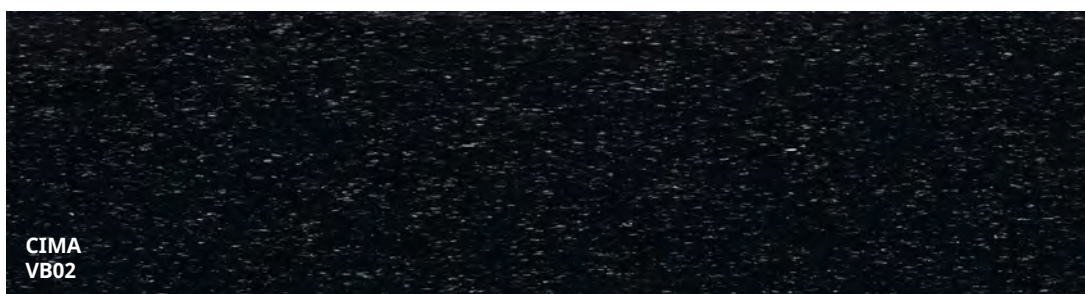
Available colours



Available colours - Full sheet view



Available colours - Full sheet view



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
VOLCALNICS	VW01	Gemini	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	VE01	Tambora	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	VA01	Santa Ana	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	VG21	Maui	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	VB02	Cima	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15

3. Sheet & Matching adhesives

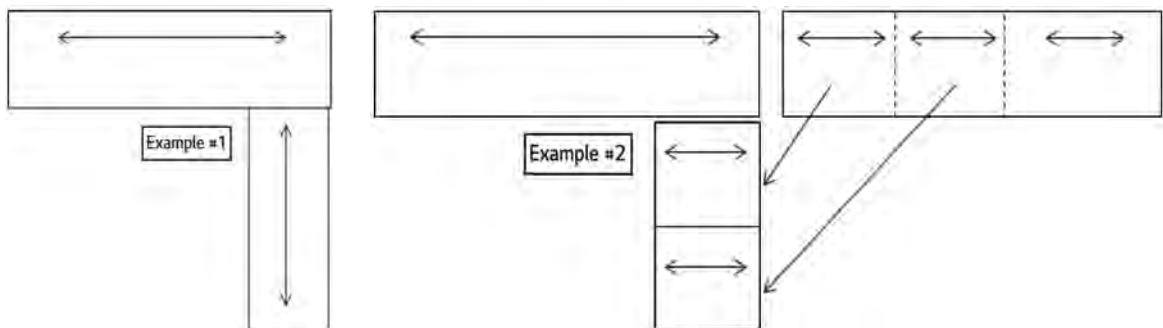
SHEET			ADHESIVE		
GROUP	COLOUR CODE	COLOUR NAME	COLOUR CODE	COLOUR NAME	PACKAGING UNIT
VOLCALNICS	VW01	Gemini	H036	SILVER	45ml / 250ml
	VE01	Tambora	H020	CREAM	45ml / 250ml
	VA01	Santa Ana	H003	GRAY	45ml / 250ml
	VG21	Maui	H049	MAUI	45ml / 250ml
	VB02	Cima	H045	VOLCANICS /BLACK	45ml / 250ml

4. LRV , PANTONE, RAL Classic & NCS

GROUP	COLOUR CODE	COLOUR NAME	LRV	PANTONE	RAL Classic	NCS
VOLCALNICS	VW01	Gemini	84,32	-	-	-
	VE01	Tambora	59,15	-	-	-
	VA01	Santa Ana	44,35	-	-	-
	VG21	Maui	18,38	-	-	-
	VB02	Cima	6,53	-	-	-

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).

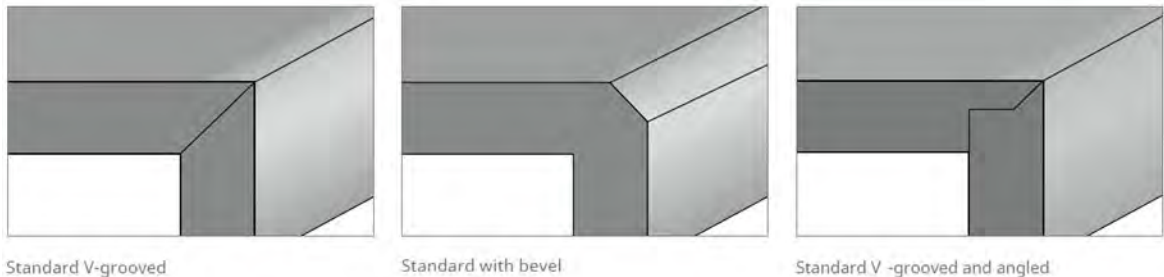
Before and during the gluing process between the sheets, check the best possibility of according to the fluidity of the design. Whatever design is chosen visual assessment is the only way to determine the best colour combination. We strongly advise the fabricator to confirm that the purchaser and the end user understand these considerations before proceeding.

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 exists. After Sawing, whitening effect can appear .

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.

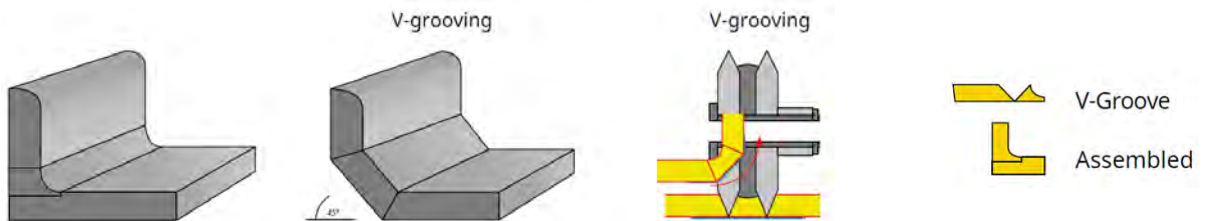


For the bonding process of the edges please follow the instructions of edge treatments.

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 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.



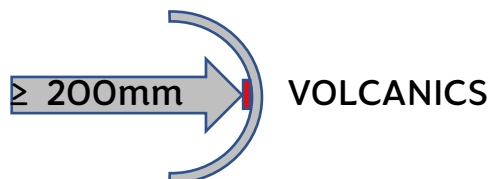
The heating time is equivalent to the general heating time of HIMACS products for the thermoforming process.

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

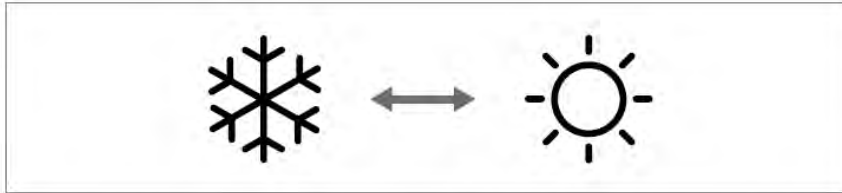
For further details of thermoforming process see also our FM22 EU, section 7.15 THERMOFORMING.

For any technical inquiry contact your local technical support.

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

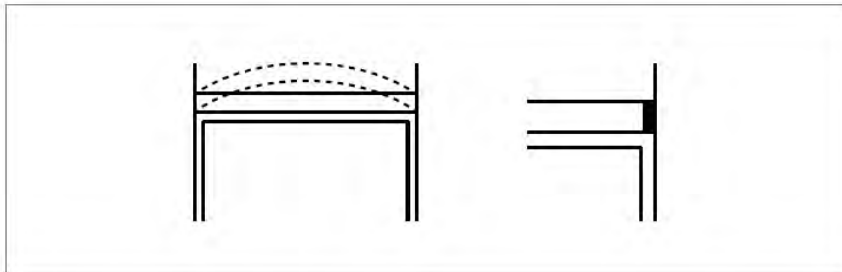


9. Thermal Expansion



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

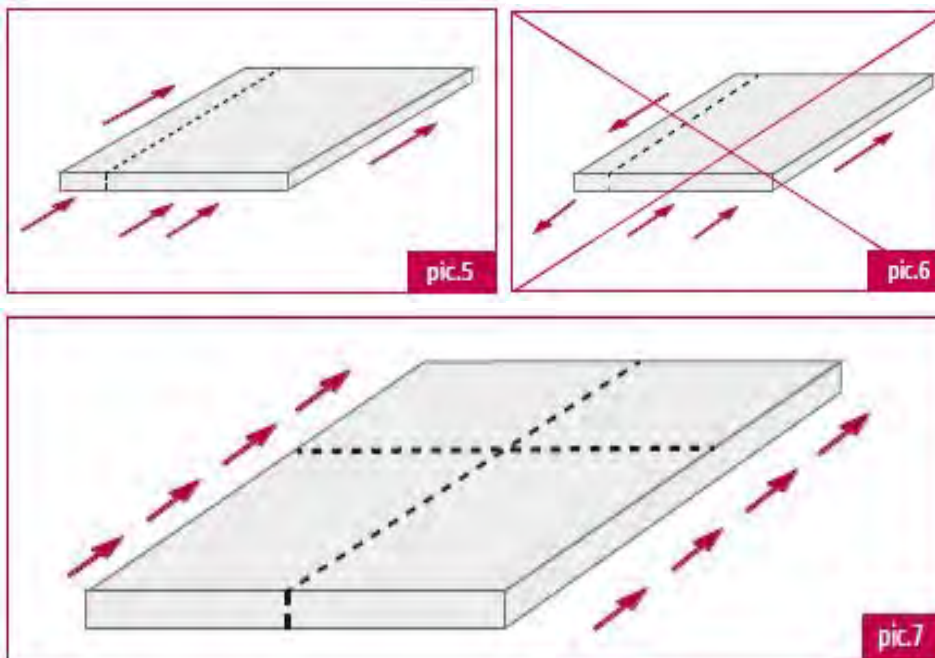
- Check any fabricated item on quality aspects before leaving the workshop.
- In case of any mistakes, it easily can be repaired in the workshop and keeps the time of re-work very low.
- Any damage or any mistake which will be recognized later will make the fixing much more expensive.

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 VOLCANICS 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.

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