

HI·MACS

The shape of your ideas

HIMACS AURORA & MARMO COLLECTION

TDS - TECHNICAL DATA SHEET

Solid Surface Material

Colours belonging to Aurora & Marmo 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 Aurora & Marmo 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

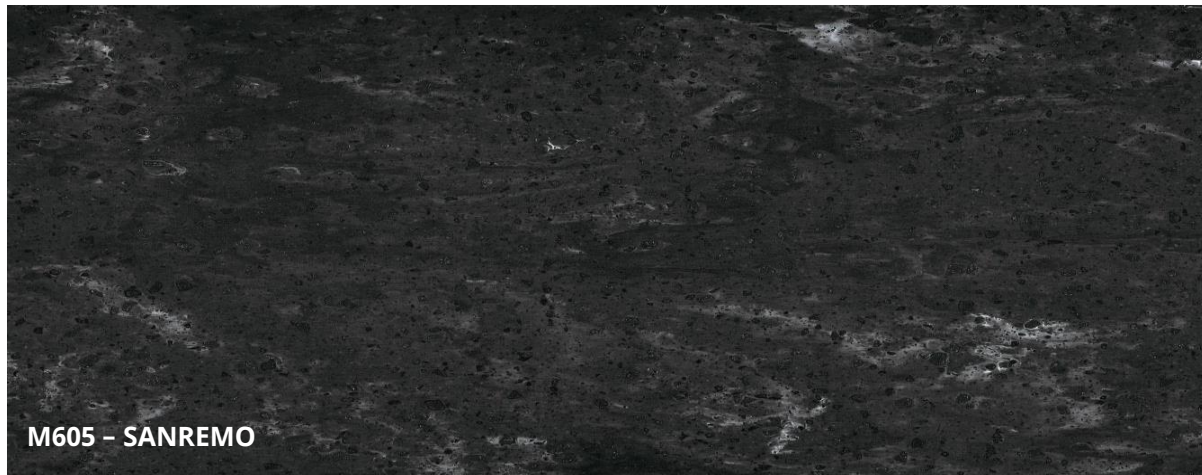
1.1. Available colours



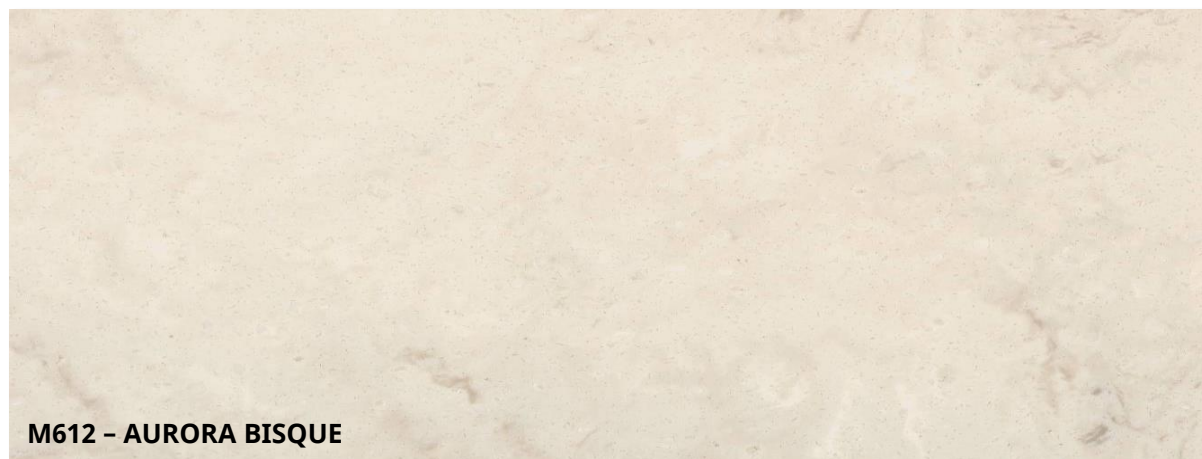
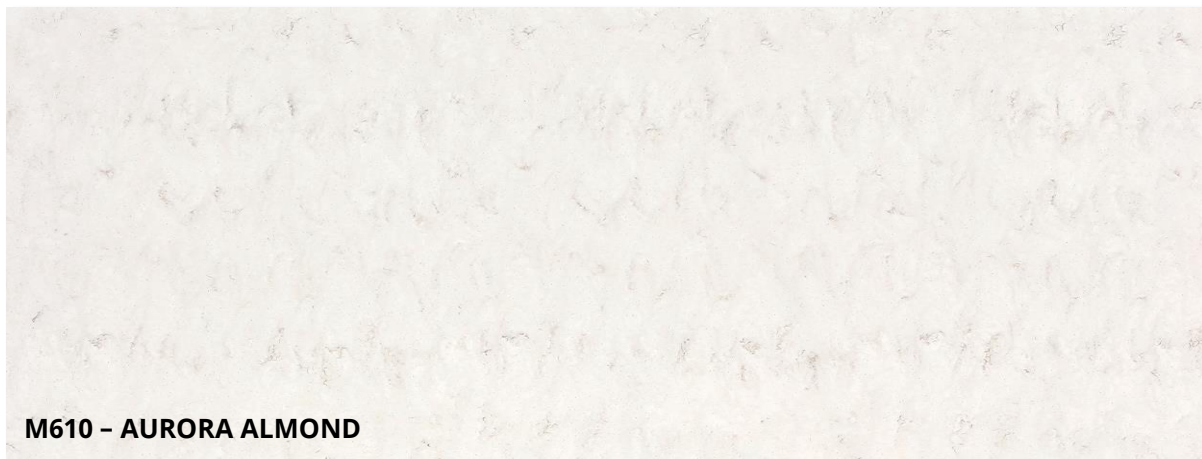
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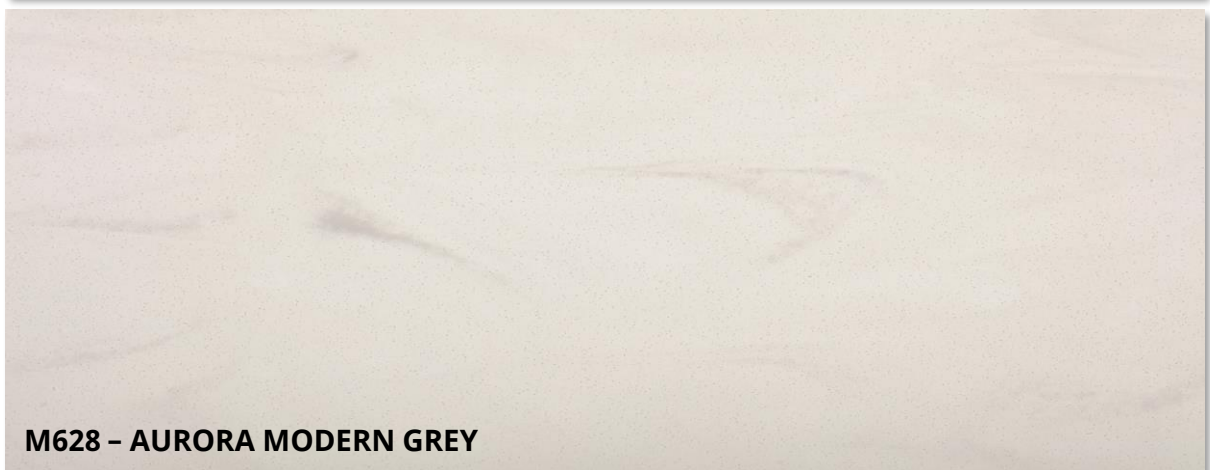
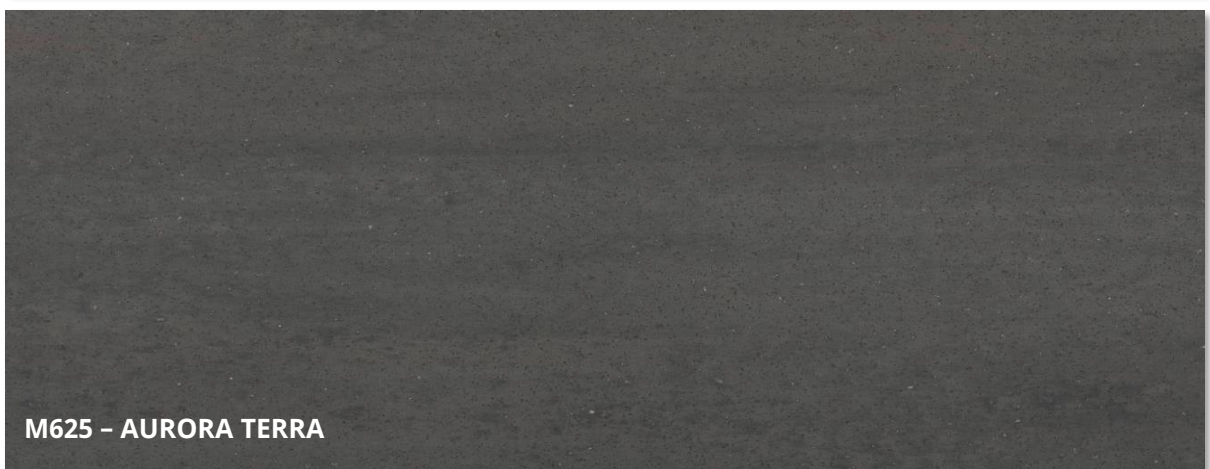
1.1. Available colours



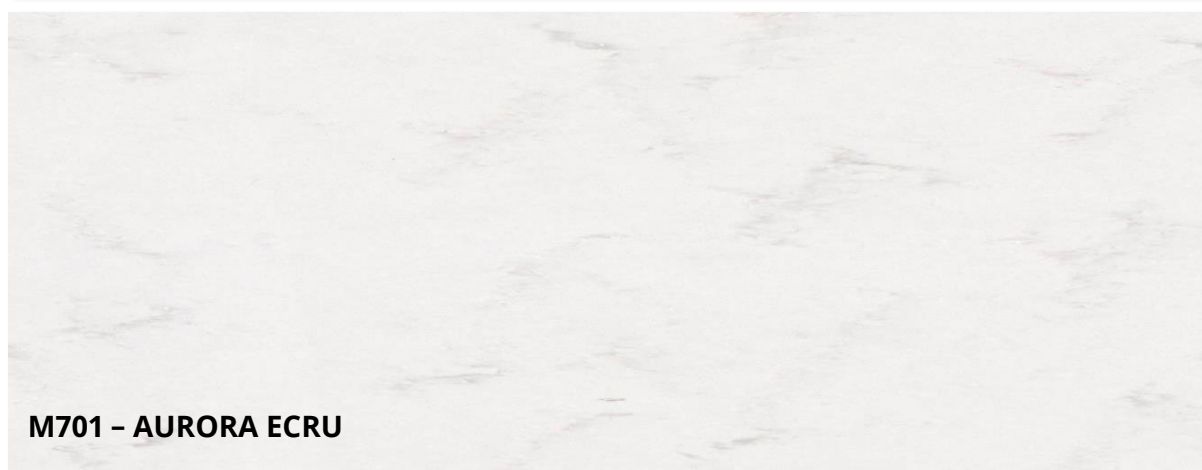
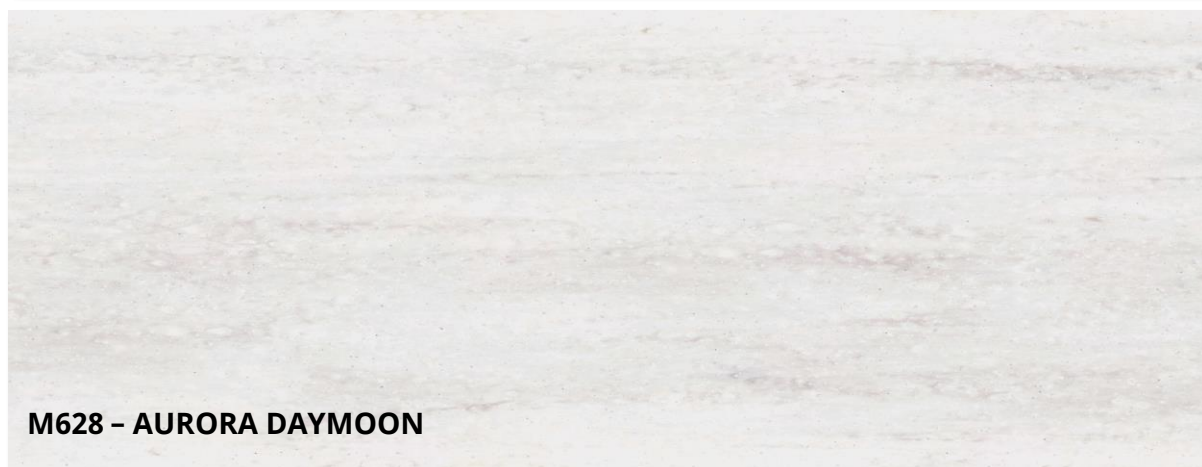
1.1. Available colours



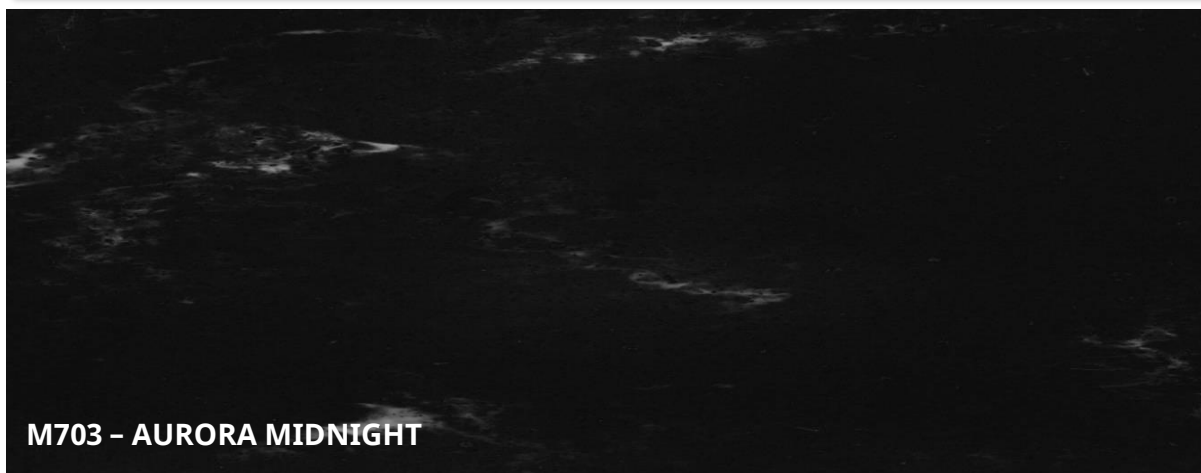
1.1. Available colours



1.1. Available colours



1.1. Available colours



1.1. Available colours



M705 - AURORA CANYON



M706 - AURORA ANGORA



M707 - AURORA MAGNOLIA

1.1. Available colours



1.1. Available colours



M803 - AURORA CALACATTA RAMO



M904 - NAPLES

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
Aurora & Marmo	M427	BELLIZZI	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M601	AURORA TORANO	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M603	PAVIA	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M605	SANREMO	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M606	AURORA BIANCO	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M608*	AURORA GREY*	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M610	AURORA ALMOND	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M612	AURORA BISQUE	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M614	AURORA UMBER	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M615	AURORA COTTON	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M617	AURORA BLANC	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M623	AURORA LINEN CREAM	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M624	AURORA COCOA	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M625	AURORA TERRA	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M626	AURORA MODERN GREY	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M627	AURORA BUTTER CREAM	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M628	AURORA DAYMOON	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M701	AURORA ECRU	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M702	AURORA FROST	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M703	AURORA MIDNIGHT	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M704	AURORA STONE GREY	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M705	AURORA CANYON	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M706	AURORA ANGORA	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M707	AURORA MAGNOLIA	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M708	AURORA SABLE	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
	M801	AURORA CALACATTA LUNA	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15
M802	AURORA CALACATTA FIORE	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15	
M803	AURORA CALACATTA RAMO	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15	
M904	NAPLES	12 mm	760mm x 3680mm	2,7968	55,38 kg	19,80 kg	15	

* M608- contains minimum 6% of pre consumer recycled plastic resin (certificate# SCS – RC - 09999)

3. Sheet & Matching adhesives

SHEET			ADHESIVE		
GROUP	COLOUR CODE	COLOUR NAME	COLOUR CODE	COLOUR NAME	PACKAGING UNIT
Aurora & Marmo	M427	BELLIZZI	H36	SILVER	45ml / 250ml
	M601	AURORA TORANO	H02	ARTIC WHITE	45ml / 250ml
	M603	PAVIA	H21	PAVIA WHITE	45ml / 250ml
	M605	SANREMO	H35	DARK	45ml / 250ml
	M606	AURORA BIANCO	H02	ARTIC WHITE	45ml / 250ml
	M608	AURORA GREY	H139	AURORA GRAY	45ml / 250ml
	M610	AURORA ALMOND	H139	AURORA GRAY	45ml / 250ml
	M612	AURORA BISQUE	H141	AURORA BISQUE	45ml / 250ml
	M614	AURORA UMBER	H143	AURORA UMBER	45ml / 250ml
	M615	AURORA COTTON	H144	AURORA COTTON	45ml / 250ml
	M617	AURORA BLANC	H146	AURORA BLANC	45ml / 250ml
	M623	AURORA LINEN CREAM	H140	AURORA ASH	45ml / 250ml
	M624	AURORA COCOA	H126	BEIGE	45ml / 250ml
	M625	AURORA TERRA	H039	LATTE	45ml / 250ml
	M626	AURORA MODERN GREY	H132	CLOUD	45ml / 250ml
	M627	AURORA BUTTER CREAM	H52	BABYLON BEIGE	45ml / 250ml
	M628	AURORA DAYMOON	H001	SATIN WHITE	45ml / 250ml
	M701	AURORA ECRU	H139	AURORA GREY	45ml / 250ml
	M702	AURORA FROST	H144	AURORA COTTON	45ml / 250ml
	M703	AURORA MIDNIGHT	H07	BLACK	45ml / 250ml
	M704	AURORA STONE GREY	H058	PEBBLE PEARL	45ml / 250ml
	M705	AURORA CANYON	H44	MIKENO	45ml / 250ml
	M706	AURORA ANGORA	H44	MIKENO	45ml / 250ml
	M707	AURORA MAGNOLIA	H001	SATIN WHITE	45ml / 250ml
	M708	AURORA SABLE	H20	SABLE	45ml / 250ml
	M801	AURORA CALACATTA LUNA	H02	ARTIC WHITE	45ml / 250ml
M802	AURORA CALACATTA FIORE	H140	AURORA ASH	45ml / 250ml	
M803	AURORA CALACATTA RAMO	H002	ALPIN WHITE	45ml / 250ml	
M904	NAPLES	H107	MARTA GREY	45ml / 250ml	

4. LRV Light Reflectance Values & colour codes (Pantone – RAL Classic – NCS)

GROUP	COLOUR CODE	COLOUR NAME	LRV	PANTONE	RAL Classic	NCS
Aurora & Marmo	M427	BELLIZZI	8,37	11-1001 TPG	RAL 9001 RAL 9016 △	S 1002-Y50R S 0500-N S 1505-Y20R
	M601	AURORA TORANO	71,82	11-4800 TPG 16-0000 TPG	RAL 9003 RAL 7044 ○ RAL 8019	S 0500-N S 3502-R ○
	M603	PAVIA	77,22	11-0601 TPX 11-4800 TPX	RAL 9003 ○	
	M605	SANREMO	8,49	19-4006 TPX 19-0000 TPX	RAL 8019 RAL 9005 RAL 9010 ○ RAL 8017	
	M606	AURORA BIANCO	78,35	11-0601 TPX 13-4403 TPX	RAL 9003 RAL 7045 ○ RAL 9002	
	M608	AURORA GREY	58,52	13-4403 TPX 12-0404 TPX	RAL 7047 △	
	M610	AURORA ALMONT	71,58	11-4201 TPG ○	RAL 9016 △	S 0500-N ○
	M612	AURORA BISQUE	53,48	12-5202 TPG 12-4301 TPG ○ 16-1210 TPG	RAL 085 85 10 △ RAL 080 80 10 ○ RAL 070 70 10	S 1005-Y30R S 1505-Y30R ○ S 3010-Y60R
	M614	AURORA UMBER	13,03	19-0808 TPG 13-0000 TPG ○ 19-3901 TPG	RAL 7039 △ RAL 7044 ○ RAL 8019 △	S 7005-Y50B S 1502-Y50R ○ S 7005-R50B
	M615	AURORA COTTON	73,51	11-4202 TPG ○ 11-4001 TPG 11-4301 TPG	RAL 9003 △	S 0500-N ○ S 0300-N △ S 1002-Y
	M617	AURORA BLANC	77,12	11-4800 TPG 11-0601 TPG ○ 16-4703 TPG	RAL 9003 RAL 7047 ○ RAL 7042	S 0500-N ○ S 0300-N △ S 4000-N ○
	M623	AURORA LINEN CREAM	62,39	12-0304 TPG ○ 13-0905 TPG ○ 11-0608 TPG ○ 14-1208 TPG ○	RAL 9001 ○ RAL 1013 △ RAL 1011 △	S 1005-Y20R ○ S 2005-Y40R △ S 3020-Y30R △ S 0500-N △
	M624	AURORA COCOA	40,71	15-1309 TPG ○ 16-1320 TPG ○ 16-1310 TPG ○ 11-4001 TPG ○	RAL 8025 ▲ RAL 8025 △ RAL 9003 ○	S 3010-Y30R S
	M625	AURORA TERRA	8,74	19-0812 TPG ○ 19-0810 TPG ○ 19-0508 TPG ○	RAL 8019 ○ RAL 9004 ○ RAL 8028 △	S 8000 ○ S 8000-Y50R ○ S 8500-N ○
	M626	AURORA MODERN GREY	51,80	14-4300 TPG △ 14-4107 TPG △ 14-4202 TPG △	RAL 7035 △ RAL 7042 △	S 1502-Y ○ S 2500-N ○ 8500-N ○
	M627	AURORA BUTTER CREAM	38,06	15-1308 TPG ○ 13-5304 TPG ○ 17-1210 TPG ○ 11-1001 TPG ○	RAL 1019 △ RAL 9001 ○ RAL 8025 ▲	S 3005-Y20R △ S 2005-Y20R ○ S 5010-Y30R △ S 1002-Y ○
M628	AURORA DAYMOON	60,45	11-4301 TPG ○ 15-0000 TPG ○ 16-5803 TPG ○	RAL 7047 ○ RAL 7004 △ RAL 7030 △	S 1000-N ○ S 3000-N △ S 3500-N △	

4. LRV Light Reflectance Values & colour codes (Pantone – RAL Classic – NCS)

GROUP	COLOUR CODE	COLOUR NAME	LRV	PANTONE	RAL Classic	NCS
Aurora & Marmo	M701	AURORA ECRU	68,16	12-4302 TPG ○ 17-1210 TPG ○ 15-0000 TPG △	RAL 9002 △ RAL 7044 △ RAL 7006 △	S 1000-N △ S 2502-Y ○ S 2502-Y ○
	M702	AURORA FROST	75,21	12-4302 TPG ○ 11-4001 TPG ○ 15-0000 TPG △	RAL 9002 ▲ RAL 9003 ○ RAL 7044 ▲	S 1000-N △ S 1502-Y ○
	M703	AURORA MIDNIGHT	6,78	19-4004 TPG ○	RAL 9001 ○	S 9000-N ○
	M704	AURORA STONE GREY	60,45	11-4301 TPG ○ 15-0000 TPG ○ 16-5803 TPG ○	RAL 7047 ○ RAL 7004 △ RAL 7030 △	S 1000-N ○ S 3000-N △ S 3500-N △
	M705	AURORA CANYON	58,47	12-5202 TPG ○ 15-1218 TPG ○ 16-1212 TPG △ 11-4001 TPG ○	RAL 9001 ○ RAL 1015 △ RAL 1011 △ RAL 9003 ○	S 1005-Y20R ○ S 2005-Y20R △ S 3020-Y20R ○ S 0500-N ○
	M706	AURORA ANGORA	57,08	12-5202 TPG ○ 15-1218 TPG ○ 16-1212 TPG △ 11-4001 TPG ○	RAL 9001 ○ RAL 1015 △ RAL 1011 △ RAL 9003 ○	S 1005-Y20R ○ S 2005-Y20R △ S 3020-Y20R ○ S 0500-N ○
	M707	AURORA MAGNOLIA	65,92	12-4302 TPG ○ 14-1208 TPG ○ 13-0907 TPG △ 14-0002 TPG ○	RAL 9003 ▲ RAL 1019 △ RAL 1011 △ RAL 7047 △	S 1002-Y △ S 3010-Y30R ○ S 2502- △
	M708	AURORA SABLE	56,43	13-0905 TPG ○ 17-1105 TPG ○ 13-0607 TPG △	RAL 1013 △ RAL 1019 △ RAL 7006 △	S 1005-Y20R △ S 1002-Y △ S 2005- ○ S 5005- Y20R ○
	M801	AURORA CALACATTA LUNA	81,89	11-0601 TPG ○ 12-4302 TPG △	RAL 9003 ○ RAL 9002 ○ RAL 7044 △	S 0502-G ○ S 1002-Y ○ S 1502-Y △
	M802	AURORA CALACATTA FIORE	77,34	11-4202 TPG ○ 14-4107 TPG ○	RAL 9003 △ RAL 7047 △	S 0502-B △ S 2500-N △
	M803	AURORA CALACATTA RAMO	81,49	11-4201 TPG ○ 13-0905 TPG ○ 12-4301 TPG ○	RAL 9003 △	S 0500-N ○
	M904	NAPLES	20,22	17-1500 TPG		S 5502-Y

Note:

LRV and colour code, such as Pantone, RAL or NCS are only meaningful values for solid colours. The values provided by other colours are for references only.

5. Fabrication

5.1. Sheet Characteristics :

Customer expectations are best managed by fully educating the customer about product characteristics. For instance, the "motion" or "veining" that appears on the surface doesn't continue directly through the sheet thickness. The top of an Aurora & Marmo sheet looks nothing like the bottom of that sheet and the cross-section looks nothing like either surface. Some of these differences are shown below:



The color and pattern distribution on the top surface changes to random layers of colors and stripes distributed through the material's thickness.

Conventional "stacked" or "built-up" edges generally can not be used due to the dramatic color and pattern differences as seen in this Section



Recommendation :

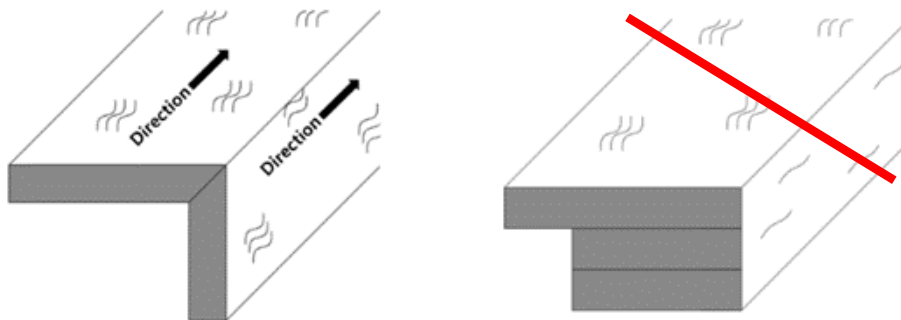
Aurora & Marmo are equivalent material as any other HIMACS product, but it requires special consideration in order to fabricate an aesthetically pleasing finished product. We strongly advise the fabricator to confirm that the purchaser and the end user understand these considerations before proceeding.

5.1.1 Special Sheet Characteristics - Aurora Calacatta Designs :

Customer expectations are best managed by fully educating the customer about product characteristics. For instance, the "motion" or "veining" that appears on the surface doesn't continue directly through the sheet thickness. The top surface of Aurora Calacatta designed sheet looks nothing like the bottom of that sheet, due to the specific product process, Calacatta veins **are only 3mm depth** into the product. This particularity must be taken in account during fabrication process :

For Edges Fabrication, HIMACS recommend to use the following way of assembly

- A 45° angle assembly will give the proper visual aspect



The veins position into the product do not allow strong and long sanding process on the product can reduce the visual effect of Calacatta Design and in some cases make the veins disappear.

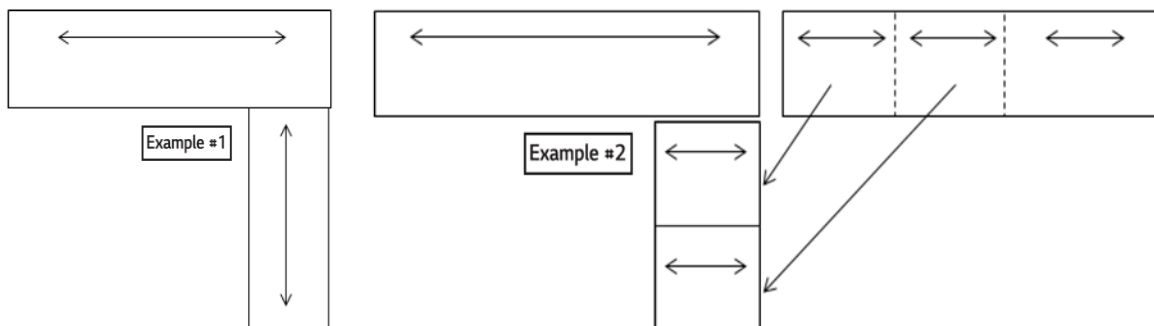
- **Veins depth : 3 mm from the Top surface**

Recommendation :

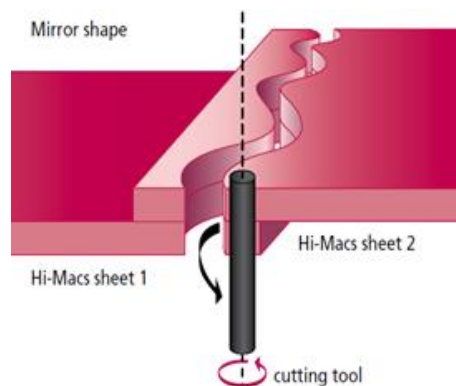
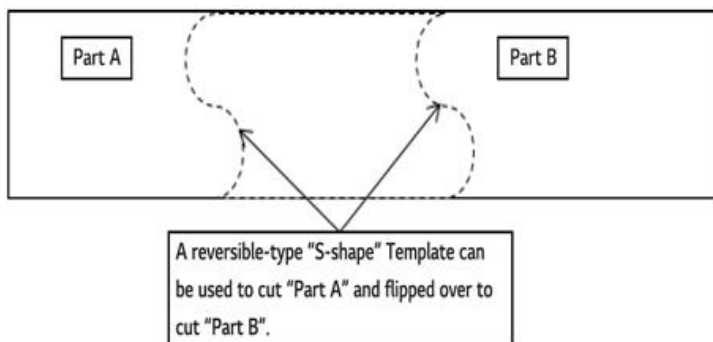
Aurora Calacatta designs are equivalent material as any other HIMACS product, but them requires special consideration in order to fabricate an aesthetically pleasing finished product. We strongly advise the fabricator to confirm that the purchaser and the end user understand these considerations before proceeding.

5.2. Sheet to Sheet bonding flow:

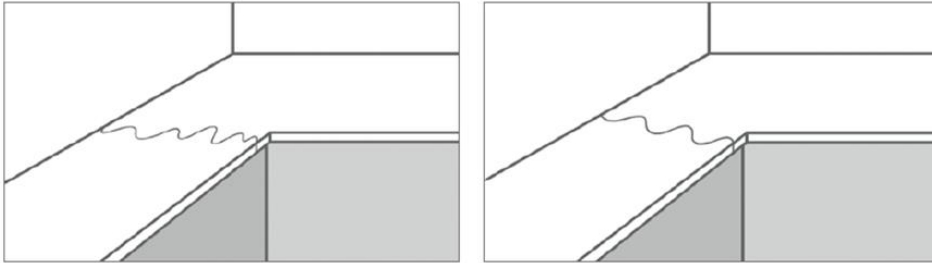
Fabricating an "L-shape" or "U-shape" countertop presents other challenges. Depending on the character of the HIMACS material, in some cases you may wish to have the "extension(s)" placed perpendicular to the primary surface (Example «1). In other cases, you may find that placing the "extension(s)" on 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.



Fabricating field seams using an "S" seam can help make those seams less visible. "Inconspicuous" seams are extremely difficult to create but creating the seam in an "S" shape will help to reduce the visual impact when two pieces of material with random patterns and color distribution are joined.



To achieve the best result of the visible pattern direction, particularly with the Aurora & Marmo colours : an irregular seam flow may be more effective and shows less pattern chip/structure cut between one to the other sheet



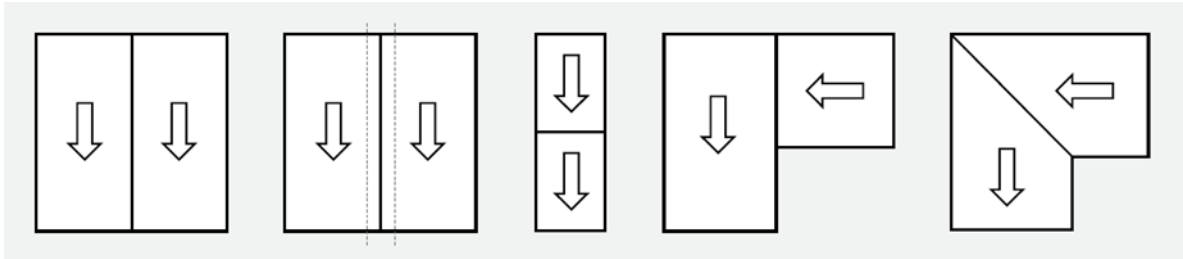
An even more irregularly directed cut must be prepared straight and parallel. Then re-sand with sandpaper of approx. 180grit (or 60 micron).

- Always clean the cut edges with a white cloth and use denatured alcohol or acetone.
- Ensure the edge is straight when making a “butt”-seam.
- Better still, make a profile, such as a tongue and groove.
- Ensure always to fabricate a re-enforcement strip (for kitchen worktops a 45° angled edge and smooth the adhesive line) from underneath.
- Always tighten pressure – but do not over tighten the pressure to the seam.

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).

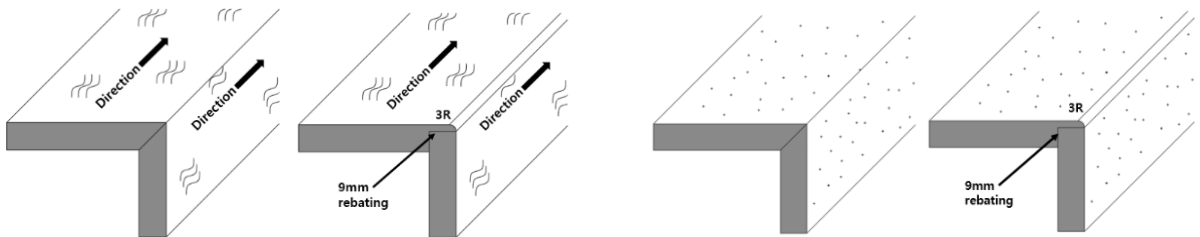
Before and during the gluing process between the sheets, check the best possibility of veining according to the fluidity of the design. Whatever design is chosen visual assessment is the only way to determine the best color combination. We strongly advise the fabricator to confirm that the purchaser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



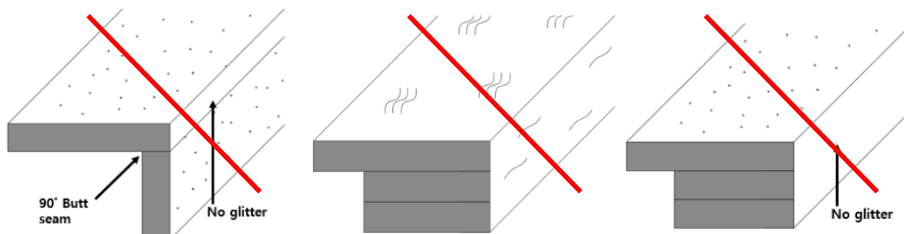
Note:

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

Recommended edge design



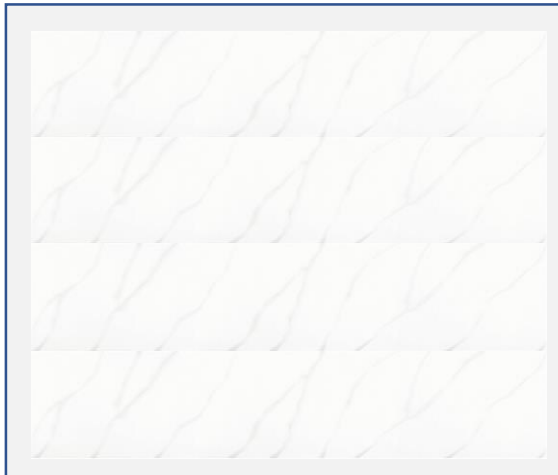
Non-Recommended edge design



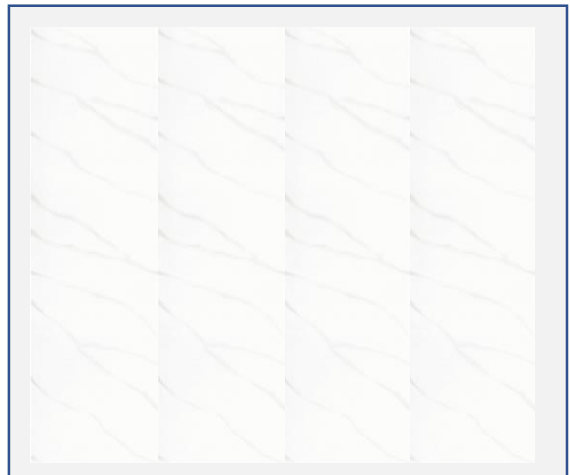
Important information : Aurora Calacatta Designs

Due to the veins design on M801 Calacatta Luna & M802 Calacatta Fiore a continuous creation of veining will be not possible to arrange, the view will be like below sample:

Veins in M801 Aurora Calacatta Luna & M802 Aurora Calacatta Fiore, are only 3 mm depth in the product. Strong and long sanding processes could change the final design as veins can disappeared



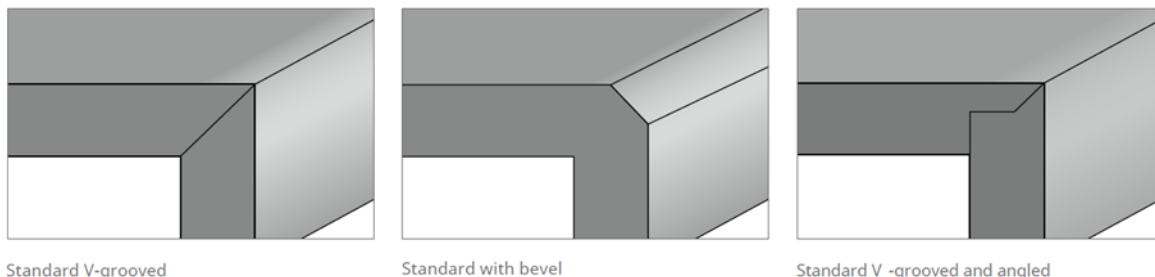
Horizontal view of full sheets of M801,
same effect on M802



Vertical view of full sheets of M801,
same effect on M802

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.



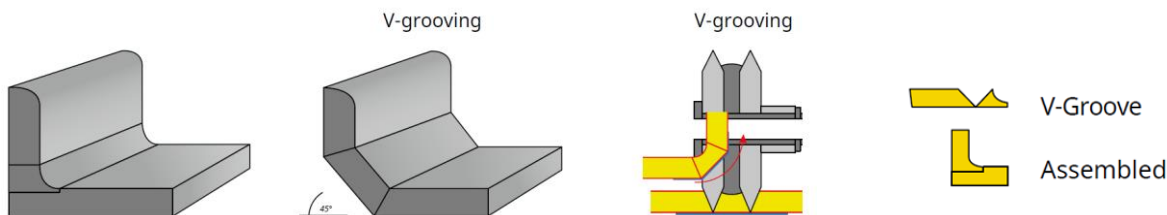
For the bonding process of the edges please follow the instructions of edge treatments.

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.

Please refer to §5.1.1 for Calacatta designs

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 colors 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 (V-grooving -p14).

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 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 AURORA is $\geq 100\text{mm}$.
- The classification of a minimum radius for MARMO is $\geq 200\text{mm}$.

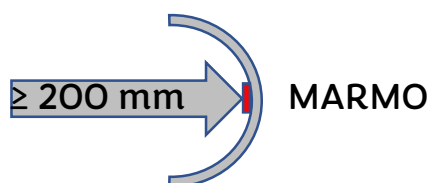
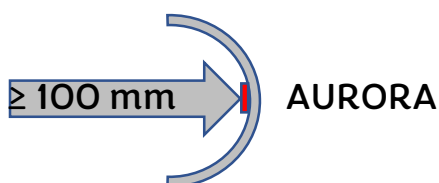
Be aware that any undertaking of recommended radii can cause some colour change or create some cracks.

For any technical inquiry contact your local technical support.

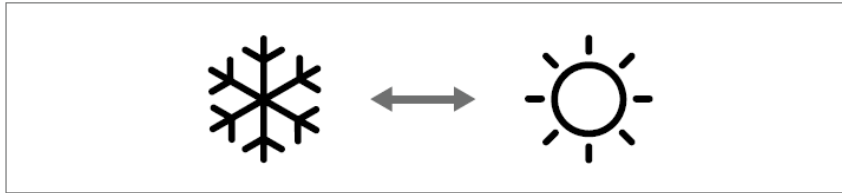
For more detailed thermoforming equipment or any thermoforming accessories please contact global@nabuurs.com or visit the web-site: www.globalvacuumpresses.com

Note:

Be aware that the veining may change in size when turning into a curve. As smaller the radius becomes as wider the veins gets but more cautions to be looked for when using dark colours to avoid unexpected whitening.

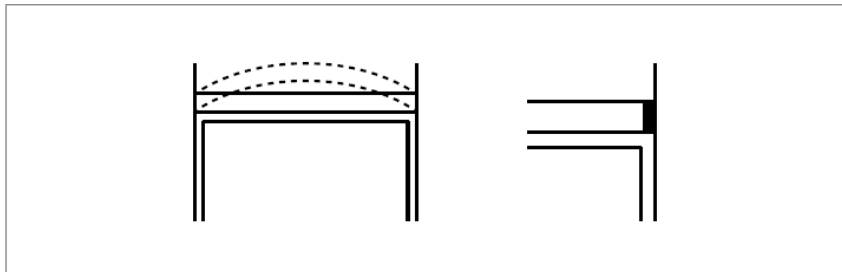


8. Thermal Expansion



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.

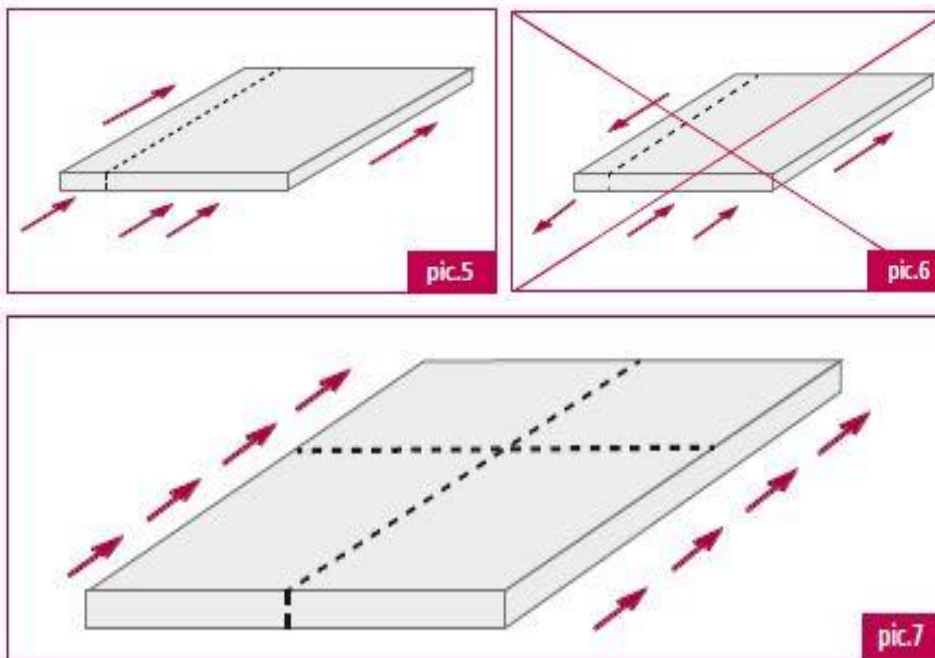
Important information:

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°).



- Fabricating field seams using an "S" seam can help make those seams less visible. "Inconspicuous" seams are extremely difficult to create but creating the seam in an "S" shape will help to reduce the visual impact when two pieces of material with random patterns and color distribution are joined.
- Aurora & Marmo are 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 veining layout as samples show above.

- Veining may 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.

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