

Interior Solid Surface Material

HI·MACS

TECHNICAL DATA SHEET PRODUCT QUALITY SPECIFICATION SHEET, SHAPE, ADHESIVE



HIMACS - Photographed by Dominik Obertreis

1. Sheet

Quality Specification 2021 (Sheet)

PRODUCT	PROPERTY	AIM VALUE	TOLERANCE	
Sheet	Incorrect labeling	None	-	
	Breakage - Cracks	No Cracks	Edge chips, but usable length \geq nominal - 10mm and/or usable width \geq nominal - 3.0mm	
	Length	Standard: 2490; 3000 and 3680 mm flex: 2200 - 3680mm custom request	-6.5 +12.5mm	
	Width	760 or over 910 mm (930; 1220; 1350 and 1520mm)	± 1.5 mm	
	Thickness	4,5; 6; 9; 12 and 20mm	1) 760mm width product: -0,15mm and + 0.45mm 2) Over 910mm width product: ± 0.7 mm 3) 930mm width product: ± 0.2 mm	
	Flatness Warping convex/concave	4,5; 6; 9; 12 and 20mm		
	width 760mm			
width 910 / 930mm	$\pm 2,5$ mm			
width 1220mm	$\pm 3,5$ mm			
width 1350mm	$\pm 4,5$ mm			
width 1550mm	$\pm 5,5$ mm			

Quality Specification 2021 (SHEET)

PRODUCT	PROPERTY	AIM VALUE	TOLERANCE
Face side	Gloss level	5	Variations from 3 to 6
	Chatter marks		
	Colour / pattern consistency within one sheet	No difference	-
	Colour / pattern consistency within 50 production sequential number of same lot	Any pieces seamed together should not show a difference	The seam may be inconspicuous $\Delta E \leq 0.5$
	Dark spots	None or $\leq 0.13 \text{ mm}^2$ size	Less than 5 spots ($\leq 0.13 \text{ mm}^2$ size) Observation Radius 1.000mm Observation Distance 600mm
	Light spots	None or $\leq 0.2 \text{ mm}^2$ size	Less than 5 spots ($\leq 0.13 \text{ mm}^2$ size) Observation Radius 1.000mm Observation Distance 600mm
	Pin holes, voids	None	Less than 5 voids ($\leq 0.1 \text{ mm}^2$ / sheet)
Back side	Gloss level	None	-
	Sanding level	Grit 100	± 20 grit
	Pin holes, voids	None	$\leq 3 \text{ mm}$ deep Less than 6mm in diameter and less than 10 holes within a circle of 100mm diameter

2. Shape

Quality Specification 2021 (Shape)

PRODUCT	PROPERTY	AIM VALUE	TOLERANCE
Shape	Cracks	No cracks	None
	Exposed surface	Free of ripples, craters, air holes, frost and white spots	None
		Free of foreign matter and dirt particles	None
	Interior length and width	Refer to shapes' brochure	(+) 0.5% / (-) 0.5%
	Shrinkage mark outside Shape	No shrinkage mark	None
	Flange	Thickness 11mm	(+) 1.0 mm / (-) 1.0 mm
		Interior edge should be sharp	Radius \leq 0.2 mm
		Flange width	Uniform within 2.5 mm
		Upper surface of flange should be flat	(+) 0.5 mm / (-) 0.5 mm
	Color	Color match according to master piece	max. $\Delta E \leq 0.7$
	Overflow hole	"Slot" according to each shape drawing	None chips broken
		Maximum length: L= x mm Maximum width: L= y mm	\pm 0.5mm \pm 0.5mm
		Horizontal & central positioning	None
		Edges both sides (R \geq 1.0 ./ 1.5mm)	\pm 0.5mm
	Air bubbles outside shape	Max. size of hole: \varnothing 1.0 mm Depth of hole: max. 1.0mm	None None
	Overflow piece (hardware PVC) plus instructions	Placed into shape during packing	Only for shapes with overflow hole
	Drain hole	Broken edges both sides (R \geq 2.0 mm)	\pm 0.5mm
	Kitchen sink	Kitchen sinks / baby bath / bathtub: Edges both sides (R \geq 3.0 mm)	\pm 0.5mm
		Circle 360° cut through \varnothing 90,0mm rebate \varnothing 116mm	+1.0mm / -0.0mm +1.0mm / -0.0mm
	Vanity	Circle 360° cut through \varnothing 46,0mm rebate/angel \varnothing 72mm	+1.0mm / -0.0mm +1.0mm / -0.0mm
	Shape production label (Stamp)	Placing position: bottom of the shape - near drainhole	None
	Shape product label	2-sites of box (outside) front-side ./ Right hand side	None

3. Adhesive

Quality Specification 2021 (Adhesive)

PRODUCT	PROPERTY	AIM VALUE	TOLERANCE
Adhesive	Shelf Life for adhesive cartridges	60 months after production date when stored at condition of 12-15°C, dark and dry	None
	Tightness of cartridges	No Leaking	None
	Curing time of joint adhesive	Complete 45 minutes After mixing at +17°C	± 10 minutes

* Method: Check whether the curing time is within specification and visual

► For further details see TDS Adhesive and MSDS Adhesive component A & B

HAZARDOUS INGREDIENTS

	Hazardous mixtures of other liquids, solids or gases	CAS	%
Adhesive	Part A		
	Methyl methacrylate	80-62-6	30 to 60
	Part B		
	Benzoyl peroxide	94-36-0	Up to 3
	Dipropylene Glycol, Dibenzoate	27138-31-4	Up to 60

PHYSICAL DATA

	Article	Data
Adhesive	Boiling point (°F)	350 ~ 450
	Vapour pressure (mm Hg) at 25°C	5mm at 22.2°C
	Vapour density	Heavier than air
	Evaporation rate	Slower than ether
	Water volume	0%

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