

HIMACS Fabrication for Specific Colors

HM2140

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Introduction

This section guides the fabrication method for HIMACS specific colors.

Overview

The characteristics that give these HIMACS sheet materials their distinct appearance are the result of the manner in which the materials are manufactured. Conventional seaming methods for field seams, edge treatments, and backsplashes are not suitable for these products. Conventional methods that work well with solid colors and small particulate do not result in acceptable visual aesthetics when used with these products. Therefore, the suitable fabrication method for specific colors be addressed in this section.

Note !

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1. Irregular Patterns (Marmo/Aurora)

1-1. Color characteristics

Marmo and Aurora are products with natural marble as a motif, and is characterized by irregularly strong/soft, large/small and long/short marble(vein) patterns distributed on the surface and edge. These irregular and complex marble(vein) patterns are unique features of manufacturing with these colors, and this is not defect. For this reason, even a sheet of the same pattern, within the same sheet or between different sheets, there can be pattern difference and color difference. Long vein may not be matched. This causes unnaturalness in the edge and surface of the seam when joining, so fabricator must try to make a better seam with recommended method or their own improved technology.

Refer to sample book for the color list.

The fabricator and installer can reduce the color and pattern difference of the seam by checking the distribution of the marble(vein) pattern on the sheet of the surface and edge, and by making a plan for cutting and placing the sheet. But seam line cannot be perfect like Solid color or Granite color due to the unique characteristics of the marble(vein) pattern. Customer complaints about the result of visible seam caused by the marble(vein) pattern are not covered by LX Hausys product quality warranty.

Fabricator and installer must inform the customer that visible seam may occur in the finished product fabricated with Marmo/Aurora before fabricating the Marmo/Aurora sheets, and sufficiently explain the increase in processing loss, and discuss the required amount considering this.

The Marmo/Aurora group of HIMACS materials all exhibit a greater variation in color, shading, and pattern than is apparent in samples. If possible, allow the customer to view the actual material together with seaming layout examples and have the customer sign a "document of understanding" to help assure that the finished countertop is consistent with customer expectations.

LX Hausys recommend following fabricating method for better aesthetic result of your fabrication and installation.

Fig. 1-1. Pattern difference between edge and surface

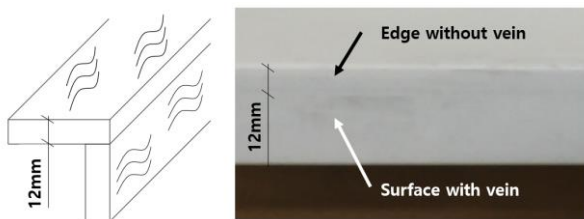
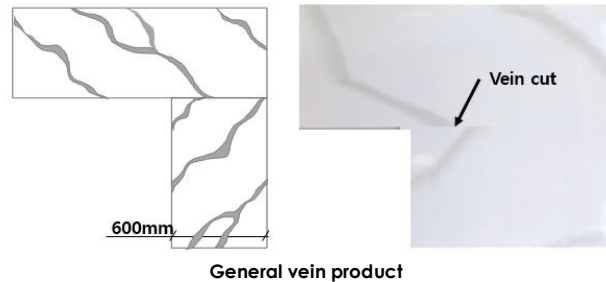
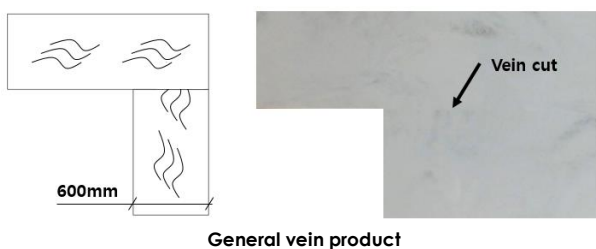


Fig. 1-2. Different direction and cut of vein of surface

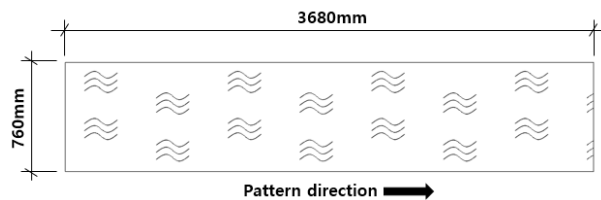


General vein product

1-2. Fabrication details.

Marmo/Aurora have the directionality of the marble(vein) pattern in the length direction due to its manufacturing characteristics. Therefore, in order to improve the design of the seam, Marmo/Aurora must be joined in accordance with same direction of the pattern, and the directionality can be checked through the distribution of the marble(vein) pattern and the arrows indicated on the back side of the HIMACS sheet.

Fig. 1-3. Pattern direction example of standard size sheet



"L" shape

"L" shape makes marble(vein) pattern cut and visible seam. However, Matching the marble(vein) pattern direction is recommended to get better/improved seam design.

Fig. 1-4. "L" shape by 90° join

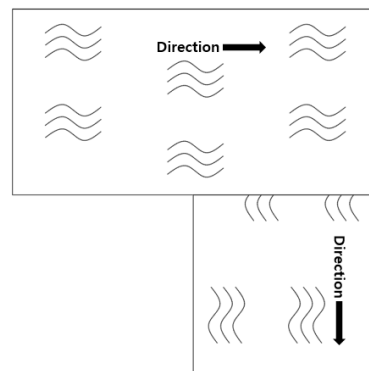
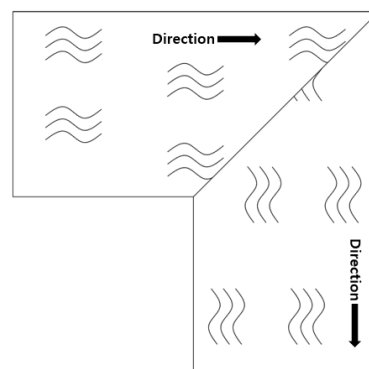
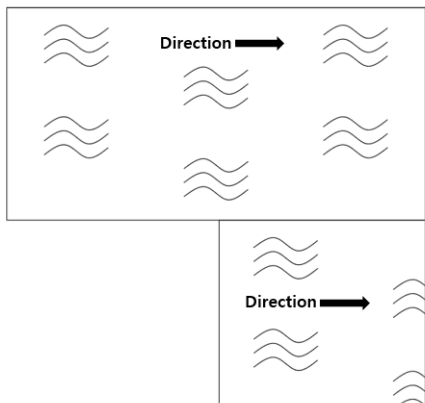


Fig. 1-5. "L" shape by 45° join



If the length of one side to be joined is less than 760mm (the width of the standard sheet), parallel join can be better solution. The side part of Aurora “M6XX” series is slightly darker than the middle part. Therefore. If you want to reduce the color difference, cut away 50 to 100mm of the side part from the edge of standard sheet, and then join. See “Side to Side” join’ in this section.

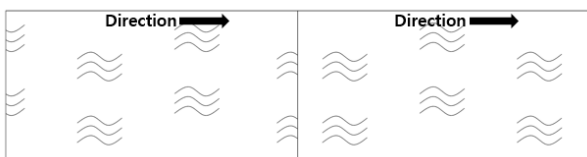
Fig. 1-5. “L” shape by parallel join



“End to End” Join

Matching the marble(vein) pattern direction is recommended to get better/improved seam design.

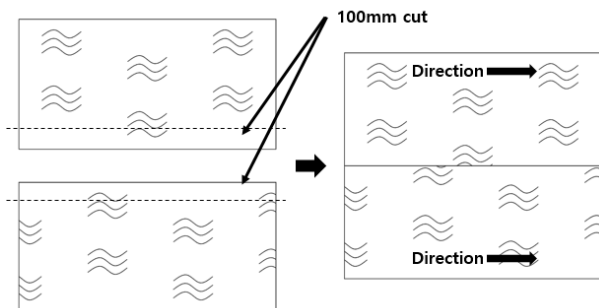
Fig. 1-6. “End to End” join



“Side to Side” Join

Parallel align of the marble(vein) pattern direction is recommended to get better seam design. The side part of Aurora “M6XX” series is slightly darker than the middle part. Therefore. If you want to reduce the color difference, cut away 50 to 100mm of the side part from the edge of standard sheet, and then join.

Fig. 1-7. “Side to Side” join



Edge details

The marble(vein) pattern and color of Marmo/Aurora sheet edge have slightly different appearance compare to the surface(plane). Therefore, when you join edge and plane, the best way to get better

edge design is hiding the edge of sheet. For example, V-Grooving(45° cut and join) is the best way to hide the edge of sheet. And, 9mm rebating method also useful. Stack edge makes a bit different appearance compare to plane surface. However, the stack edge with Marmo/Aurora looks natural, and this edge has wide applicability for various edge design.

Fig. 1-8. “V-Grooving” edge

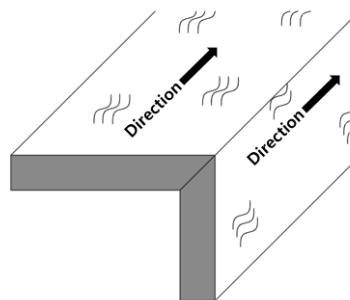


Fig. 1-9. “Rebating” edge

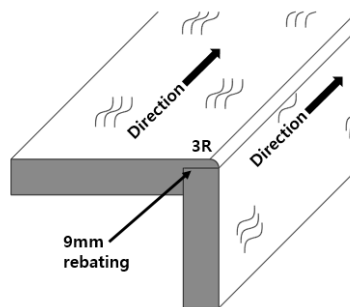
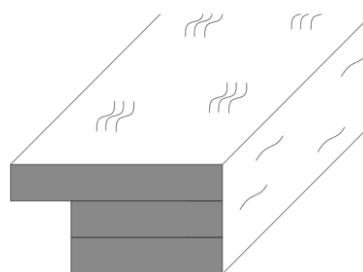


Fig. 1-10. “Stacking” edge



Sanding for “Long Vein” products

Long vein pattern is figured on the surface of HIMACS with a little bit shallow depth compare to general marble pattern. Do not sand too deep because it may remove long vein. Therefore, do not try to match the level of join line through sanding, but effort to minimize the level gap of join line before sanding.

2. Glitter, Pearl (Perna & Some colors)

2-1. Color characteristics

★ Perna and some colors have glittering effect. These colors have glitter or pearl. Glittering effect is visible only plane surface, and the effect is not shown on the edge of HIMACS sheet. The absence of glittering effect on the edge is unique features of manufacturing with these colors, and this is not defect.

Refer to sample book for the color list.

Edge details

For this reason, Perna and some colors having glittering effect should be fabricated with proper method for edge. The simple 90° butt seam edge will not show the glittering effect on 12mm edge of HIMACS sheet. Therefore, when you join edge and plane, the best way to get better edge design is hiding the edge of sheet. For example, V-Grooving(45° cut and join) is the best way to hide the edge of sheet. And, 9mm rebating method also useful. Stack edge makes a bit different appearance compare to plane surface. There are no glittering effect on stack edge. However, the stack edge has wide applicability for various edge design. 90° butt seam join is not recommended for glittering colors.

Fig. 2-1. "Butt seam" join

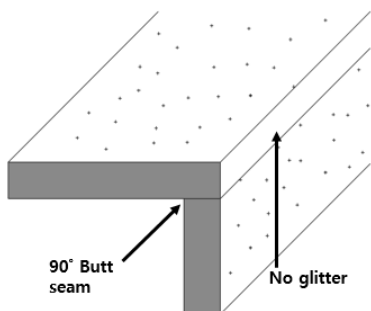


Fig. 2-2. "V-Grooving" edge

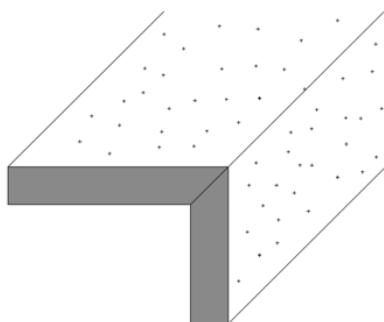


Fig. 2-3. "Rebating" edge

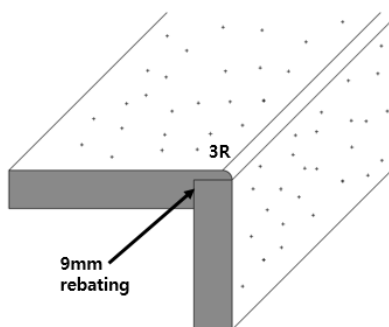
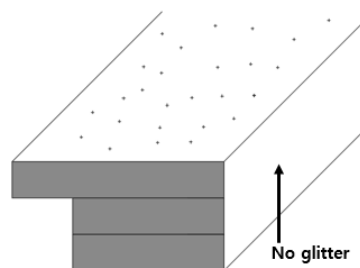


Fig. 2-4. "Stacking" edge



3. Lucent and Semi-Lucent

2-1. Color characteristics



These colors have translucent effect using LED backlight. But, the seam line and corners are shaded due to the refraction of light. The shadow of Lucent and Semi-Lucent colors on the seam line and corner is unique features of refraction of light, and this is not defect.

Refer to sample book for the color list.

Seam details

For this reason, the simple 90° butt seam edge and corner is not recommended. Therefore, when you join edge and plane, the best way to get better translucent effect is hiding the edge of sheet. V-Grooving(45° cut and join) is the best way to minimize the shadow.

And, explain to your customer about the shadow of light and structure, so that they consider the position of seam line that makes shadow.

Referenced documents

- 'HM2021 HIMACS Sheet Information'
- 'HM2090 HIMACS Seaming(Bonding)'
- 'HM2120 HIMACS Drop Edges and Downturns'

- End of Document -