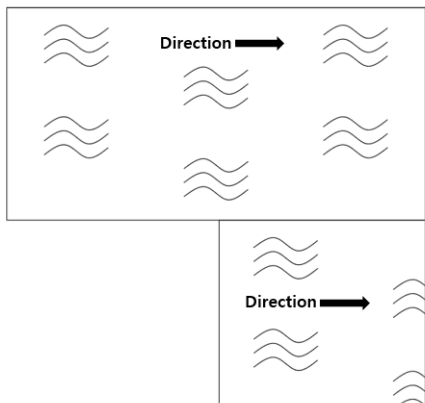


If the length of one side to be joined is less than 760mm (the width of the standard sheet), parallel join can be better solution. The side part of Aurora “M6XX” series is slightly darker than the middle part. Therefore. If you want to reduce the color difference, cut away 50 to 100mm of the side part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

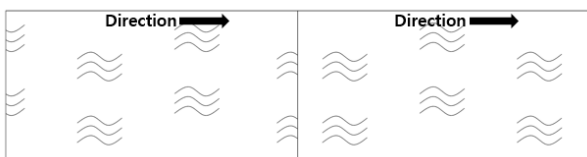
Fig. 1-5. “L” shape by parallel join



“End to End” Join

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

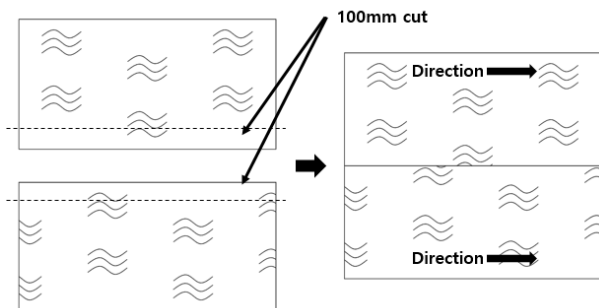
Fig. 1-6. “End to End” join



“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

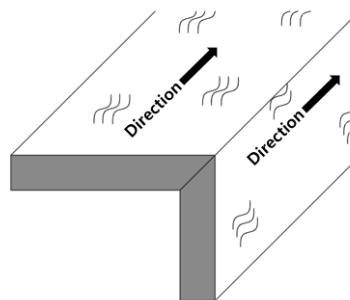


Fig. 1-9. “Rebating” edge

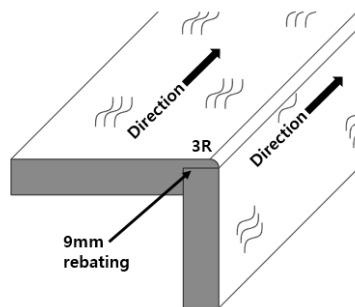
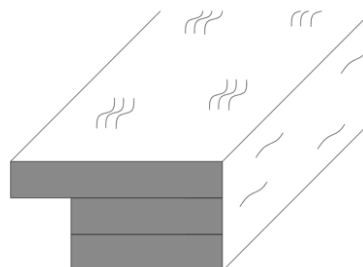


Fig. 1-10. “Stacking” edge



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 joint line through sanding, but effort to minimize the level gap of joint 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 ‘HM2021 HIMACS Sheet Information’ 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

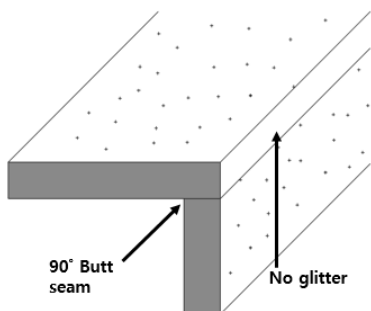


Fig. 2-2. "V-Grooving" edge

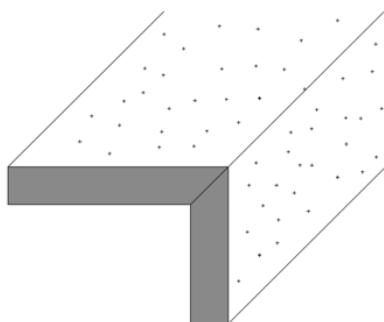


Fig. 2-3. "Rebating" edge

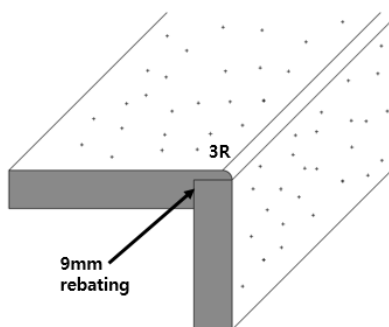
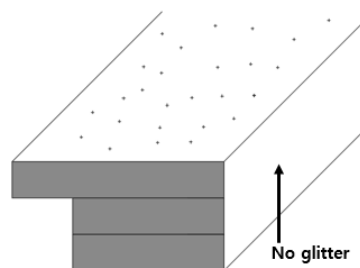


Fig. 2-4. "Stacking" edge



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 'HM2021 HIMACS Sheet Information' 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 -