

18. REPAIRS

FABRICATION GUIDELINES

Solid Surface Material

HIMACS is a homogeneous material where its molecular structure is through and through the whole sheet panel thickness, length and width. Therefore it can become repaired efficiently and easily. The proper method to get the repair with stable quality will be addressed in this section.

1. Information

One of the main advantages of HIMACS is that the surfaces can be repaired in the event of an accident. Depending on the type of damage, a number of solutions can be used.

However, as due to small production variations or other circumstances it may happen that there will be some color differentiations by time. To avoid any risk of difference it is recommended keeping an original piece, like cut-out or similar lefts of the origin at a place to find it back later. To avoid any color match issue between the installation and its repair plug it is best to use a piece of the original material.

Therefore, a piece of a cutout supposed to be stored beside the kitchen or vanity or furniture. If no spare piece is available, check color match before starting repair.

2. Repair Recommendations

Shallow and slight scratches

For scratches, it may well be possible to sand them out with Scotch Brite pads, abrasive creams or even abrasive sandpapers.

Ensure to protect and cover other areas which should be not affected by your work. Always use dust collection systems as well as vacuum cleaner.

Deep scratches and cut marks

With deep scratches and cut marks it can be repaired by using standard sanding and polishing method.

Deep indentations and chip break out

With deep indentations and chip break out it is possible to drill out the affected area and fill the hole with HIMACS color matched adhesive. This may be the best method by pattern color.

Drill out the affected area, and, clean the part with white cloth and denatured alcohol. Fill the hole with HIMACS color matched adhesive. Be sure to over fill the hole and try to eliminate any air pockets prior to curing.

Once cured the adhesive it can be sanded down in the normal standard way, however, the repaired area will need to be blended in with the existing work surface.

Small areas of damage (crack and hole)

For small areas of damage like crack and hole, particularly with the Granites and Sands, a plug repair is a possible solution .

- Using trimmer, cut the cracked part or hole. And, clean the part with white cloth and denatured alcohol.
- Prepare proper plug using same color piece of HIMACS sheet.
- Plug the prepare piece, and apply HIMACS color matched adhesive.
- Be sure to over fill the part and try to eliminate any air pockets prior to curing.
- Once cured the adhesive it can be sanded down in the normal standard way, however, the repaired area will need to be blended in with the existing work surface.

Major damage

For major damage, regarding cracks or burn marks, a 12 mm triangular or round piece of HIMACS (same thickness as installed) will need to be fitted.

Process:

- Make a template and clamp it to the surface around the damaged area.
- Machine out the section using a portable hand router.
- Using the same template cut another section from an offcut of color matched HIMACS piece or better if the piece is from the same sheet to minimize any color difference.
- Bond the triangular spare piece with HIMACS adhesive and reinforce the underside.
- Regarding the intensity of damage it also may recommend best to replace sectional partly – if necessary.
- Repairs through a heating section, like a hob cutout or another similar heating device will not be successful for a positive long term result and is not recommended.

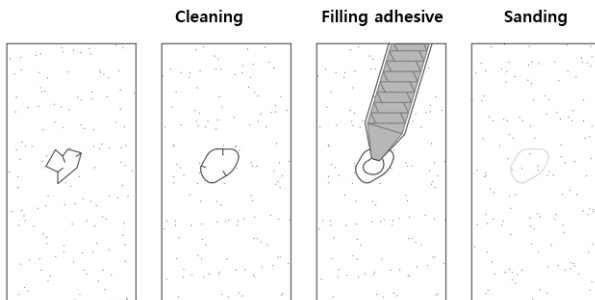
Broken seams

To repair a broken seam, first machine a 'V' groove down the entire length of the crack.

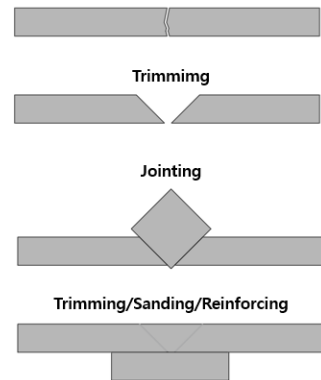
Recommendations:

- Make a square strip of matching LX Hausys HIMACS sheet so that when turned through 90°, it fits the groove.
- Ensure no production air bubbles may appear after finishing off.
- Apply LX Hausys HIMACS adhesive into groove and push the square section home until sufficient adhesive is forced upwards.
- Once fully cured sand down the new section as normal.
- Ensure that the seam has reinforcement beneath prior to completion.

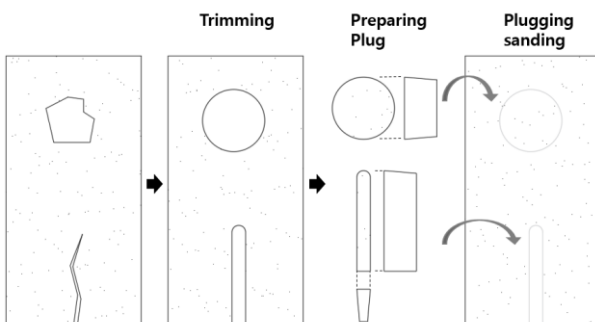
Deep indentation or chips irregularity repair



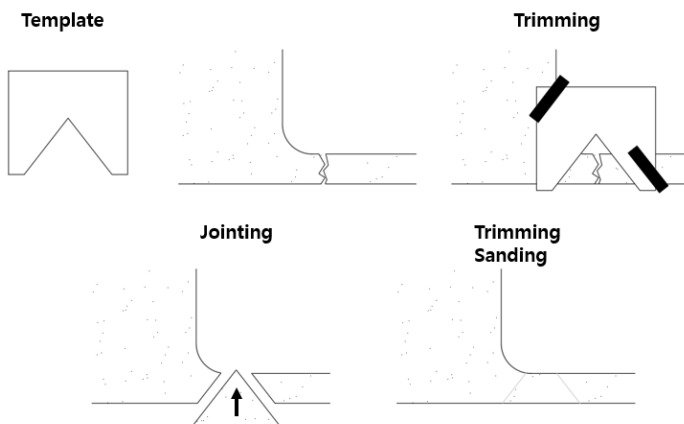
Seams break repair



Minor damages repair



Major damages repair



This guideline has been created to provide technical information for successful fabrication and installation of HIMACS, and it is intended to be used in a safe environment considering their own discretion and risk by who has technical skill for fabrication and installation of HIMACS.

This guideline is continually revised to provide reliable and up-to-date information, replacing all previous versions of the guideline and technical information, however the usage and conditions of use are beyond LX Hausys control, LX Hausys cannot guarantee the suitability of material, fabrication and installation for all usage and conditions of use. Users should not regard or rely on this guideline as a complete, sole, up-to-date or absolute information. HIMACS users, fabricator and installer should review whether the design for HIMACS, fabrication method, installation method and required performance are suitable for the intended use and conditions of use. LX Hausys shall not be liable for any direct or indirect, commercial damages or losses caused by the fabrication and installation results of HIMACS using any or all these guidelines. In addition, the results of joining with other materials, and the fabrication and installation guidelines for other materials shall not be covered by LX Hausys.

This guideline does not encourage to violate any laws, patents and licenses, and cannot be used as a basis for legal liability. All works on / from HIMACS must be performed in accordance with related laws and regulations.

LX Hausys reserves the right to change the technical information and disclaimers in this guideline for technical development and further information, and the use of HIMACS or this guideline is considered to accommodate the information and changes provided in this guideline. Therefore, please check the changed details of this guideline from time to time.

LX Hausys reserves all information in this material, and no reproduction or alteration is permitted in any way for all or any part of the information without the official written permission of LX Hausys.

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