

5. QUALITY INSPECTION

FABRICATION GUIDELINES

Solid Surface Material

1. Common Shipment Inspection

After off-loading, it is **recommended to inspect all goods** as follows:

- **Confirm quantities and colours** of all HIMACS products match the order.
- **Verify sheet number sequences** for multi-sheet projects. Please refer to the document **"3- Sheet Number | Fabrication Guidelines"**
- **Check for potential damage** to factory-applied peel coats or packaging boxes, which may indicate underlying damage to HIMACS products. For sheets, inspect for:
 - Irregular edges or corners
 - Bending, twisting, or warping
 - Noticeable thickness variation

(Inspect more carefully before fabrication.)

- If a **defective product** is found:
 - Identify the material and **record the issue**
 - **Take photographs** to illustrate the defect
 - Make a **detailed statement** including all relevant product information (reference, traceability, format, etc.)
 - **Register the information** on the **HIMACS Distributors Service Portal** to submit the claim

2. HIMACS Sheet Inspection

2.1 Colour & Pattern Evaluation

Checking **colour consistency between sheets** and **within individual sheets** is an essential step when inspecting HIMACS products.

Due to the composition and manufacturing process of HIMACS sheets:

- Slight colour variations may occur **between different production cycles**.
- Each colour group has **its own unique aesthetic**, with inherent variations caused by chips, veins, and glitter elements within the same sheet.

Important: LX Hausys does **not guarantee colour matching** between sheets from different lot numbers, nor a perfect match within colour groups that have their own distinctive aesthetic variations.

Ensuring the **best and acceptable colour match** is the responsibility of the fabricator and installer.

To achieve optimal results, LX Hausys **strongly recommends** following strict guidelines and referring to the **Sheet Information** to enhance colour consistency **between and within HIMACS sheets**.

2.2 Colour Match

- Check the sheet number printed on side edge of each sheet and use same lot number sheets. Easy way is using the sheets on same pallet.
- Proceed to gluing test on 2 small pieces together and visually check the color matching result.
- The colour difference between solid color sheets in same lot number should be less than $\Delta E 0.8$

2.3 Colour irregularities within a sheet

- **Solid Colour Sheets:**
 - If you notice blotches within a sheet during inspection, contact your supplier for further inspection and replacement if necessary.
- **Veined Colour Groups (Concrete, Aurora, Marmo):**
 - These colours **have intentionally irregular, randomly distributed veins**.
 - The natural aesthetic created by these veins is unique, and patterns **on the face and/or edges will not be identical within a sheet or between sheets**.
 - Sheets from veined colour groups should be fabricated carefully following exclusive guidelines.
- **Chip Colour Groups (Granite, Lucia, Volcanics, Aster):**
 - These sheets are designed with **irregularly distributed small or large chips**, which are a key part of the design.
 - **Irregular chip distribution is not a defect.**
 - If any **abnormal chip distribution** is observed within a sheet or between sheets of the same lot number, contact your supplier for inspection and possible replacement.
- **Glitter / Sparkling Effect:**
 - Some sheets contain **glitter chips** for a sparkling effect.
 - Due to the shape of the glitter chips, the sparkling effect is **visible only on the face side**, not on edges or sections.
 - Missing sparkling effect on edges or sections **is not considered a defect**.

Notes for Inspection and Colour Matching:

1. **Record the sheet number** printed on the edge and back side; this helps with colour matching during fabrication.
2. **Trial colour matching** can be quickly checked by gluing two small pieces with **cyanoacrylate adhesive (super glue)**.
3. **Avoid inspecting under bright lights** such as direct sunlight.
4. **Do not join sheets of different dimensions or different sheet numbers**; this will compromise colour match.
5. **Only the face, edges, and section (thickness direction)** are valid surfaces for colour and pattern inspection; the back side is **not suitable** for quality checks.

2.4 Dimensions

For standard dimension details, refer to the document “**Sheet Information.**”

HIMACS sheets may include an **additional size allowance of up to 10 mm** in both length and width. This buffer zone helps protect the primary usable area from direct damage, such as edge cracks or scratches, that may occur during transportation and handling.

The finish on the sheet’s edge section is **not suitable for joining**; therefore, the original edge should be trimmed before making any joins. Refer to the document “**HM2080 - HIMACS Cutting and Cutout**” for detailed instructions.

2.5 Flatness

Any warping should be less than **2 mm per meter** for 12 mm thick sheets, and **2.5 mm per meter** for 20 mm thick sheets upon delivery.

2.6 Face side effects

Minor defects (e.g., small stains, scratches, ripples, etc.) can be removed by sanding. However, if more serious defects are found, please contact your supplier for inspection and, if necessary, replacement.

2.7 Face side effects

HIMACS sheets are **one-sided materials**. Therefore, minor defects on the back side (e.g., small stains, scratches, ripples, etc.) do not affect the quality of the final finished product and can be removed by sanding. However, if more serious defects are found, please contact your supplier for inspection and, if necessary, replacement.

3. HIMACS adhesive inspection

- **Check the label** for the date of manufacture and colour.
- Inspect for any **visible damage** to the cartridge, tube, or accessories.
- Check whether **any contents have leaked**.

4. HIMACS sheet specifications

INSPECTION ITEMS	COLOURS	SPECIFICATIONS
COLOUR , PATTERN IRREGULARITIES	SOLID	Less than $\Delta E < 0.8$
	OTHER	Irregular distribution
DIMENSIONS	THICKNESS	12 mm $\pm$ 0.4 mm 20 mm $\pm$ 0.8 mm
	WIDTH	Less than + 10 mm to nominal value
	LENGHT	Less than + 10 mm to nominal value
FLATNESS	CONVEX WRAPPING	12 mm Less than 2 mm / m 20 mm Less than 2.5 mm / m
	CONCAVE WRAPPING	12 mm Less than 2 mm / m 20 mm Less than 2.5 mm / m
FACE SIDE	DARK SPOTS	Less than 2 impurities (diameter less 0.7 mm ²) Per Meter
	LIGHT SPOT	
	PINE HOLES	None
BACK SIDE	PINE HOLES	Less than 50 impurities (diameter less 2 mm ²) Per Meter

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