

HI·MACS MyWorktop®

The Top-Solution. For Kitchen, Bath, Living & Office Space.

☐ Solid Surface Material

INSTRUCTION MANUAL - Edition 3.1

Dimension	Worktop	colour	Diamond White
	20mm(T) x 620mm(W) x 2,200mm(L)		Chamomile
	Upstand		Aurora Blanc
	20mm(T) x 40mm(W) x 2,200mm(L)		

BEFORE YOU START

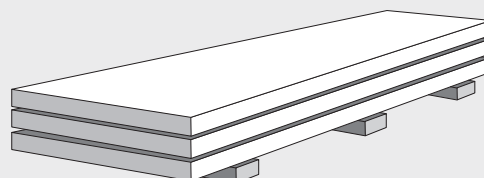
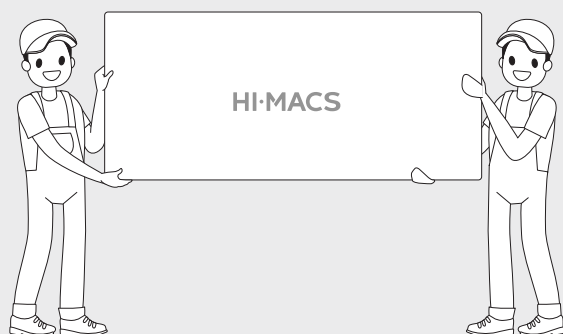
1. Important Information

- Ensure that you read, understand and follow this instruction manual carefully.
- Retain this instruction manual and box label barcode without any damage for future reference and A/S.
- Refer to the detailed fabrication manual, fabrication movie clip and MSDS (Material Safety Data Sheet) from our website - www.myworktop.uk - to ensure your high quality fabrication and safety.

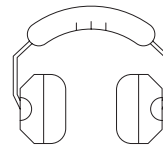
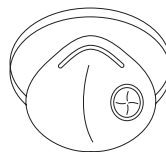
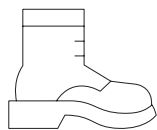
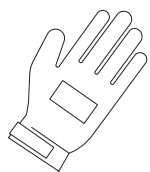
2. Handling, Storage and Preparing

- Always handle the material with care to avoid any additional uncontrolled scratching from the top or from the back of the sheet.
- Never attempt to carry HIMACS MyWorktop® on your own. HIMACS MyWorktop® should be lifted by two people, one at either end. Always lift in a vertical position.

- HIMACS MyWorktop® should always be carried/stored horizontal and flat on sturdy pallets, workbench or clean floor in a dry, well ventilated area, and do not put it outside.
- HIMACS MyWorktop® and additional materials must be stored for minimum 24hours at room temperature (min. +17°C) before starting fabrication.
- Check the quality of HIMACS MyWorktop® before use, and to see if there is any visible damage or defects.
- Always check colour consistency and design when using several sheets.
 - : Aurora products are characterized by irregular marble(vein) patterns distributed on the surface and edges.
 - : Due to the irregularity of marble(vein) patterns, even a sheet of the same pattern, within the same sheet or between different sheets, there might be pattern and color difference. Surface and section also has slight difference.
 - : It is natural features of Aurora products, and not a defect.
- Ensure that you consider the sub-construction and strength of the flooring as this needs to be suitable for the weight of long term use.
- When fabricating HIMACS MyWorktop® the smell during the fabrication process due to the acrylic based material is very unique. But, once installed HIMACS MyWorktop® is emission free.



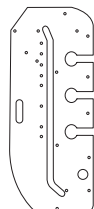
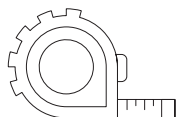
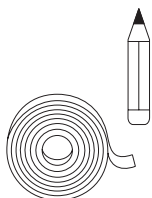
SAFETY INSTRUCTIONS



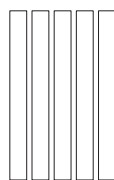
- * Always respect national and local safety instructions for tools and equipment you may be using and follow the legal requirements.
- Always ensure you have good ventilation when fabricating and installing.

- Always wear appropriate personal protective equipment
- : Protective dust masks, eye and ear protection, work and/or latex gloves and safety shoes are required.

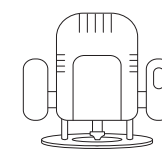
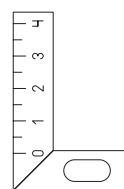
TOOLS AND HARDWARE REQUIRED



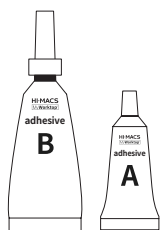
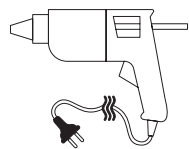
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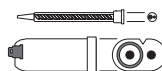
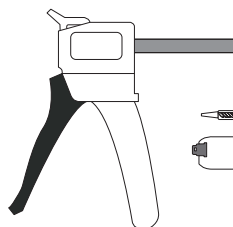
12mm(T) x 150mm(W) x 100cm(L) Wooden Strips



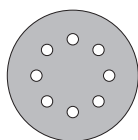
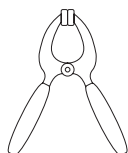
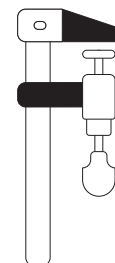
With 2,400mm guide rail for long cuts



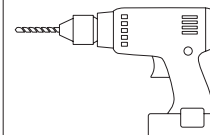
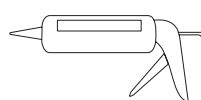
or



or



180 240 320 400
SG or Maroon
Scotch Brite 7447



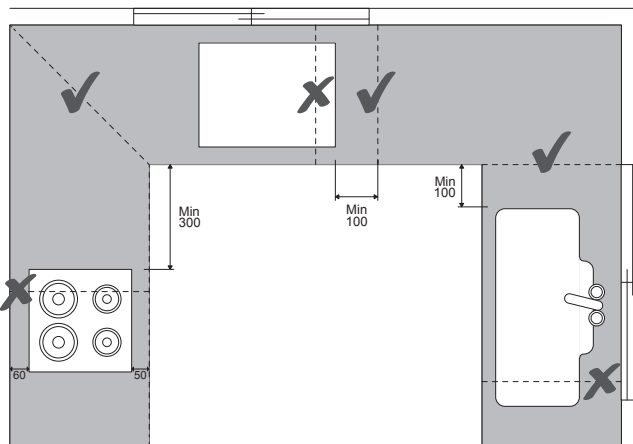
- * Ensure the electric hand tools and any other tools are adequate to fabricate HIMACS MyWorktop®
- Use a hand held router with a power rating of 1800-2000w, using a 1/2" or 12mm collector and a cutter with at least a 25mm cut length, and 30mm sleeve guide.

- You should have a wide selection of Tungsten Carbide tipped router bits for straight cuts, profile finishing and bowl installation.
- : Profiling cutters with bearings (preferably nylon).
- Random orbital sander and dust extraction equipment
- : Always select machines which use quick fix discs and pads up to Ø150mm

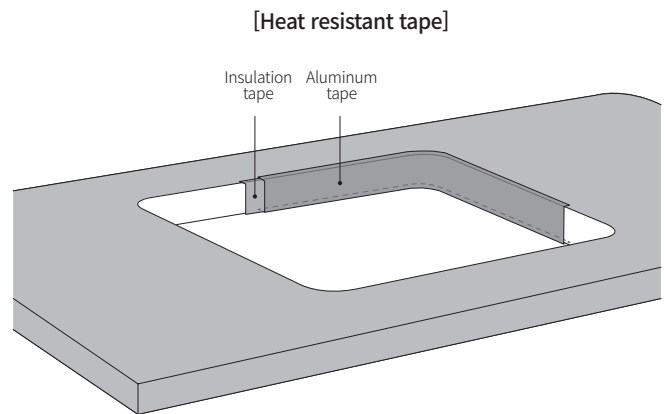
FABRICATION

1. Guide for Job Planning

- Successful installation relies on accurate job planning, especially around kitchen appliances
- Never place seams around cut-outs and heat or wet zone like heating device, dishwasher or washing machine.
- For corner seam, rectangle joint is a simple and quick way, but diagonal joint is recommended in case of Aurora products to minimize unnatural figure of vein cuts.
- Keep seams 100mm from any cut-out for stove, sink or other cut-out.
- When having to layout and fabricate a countertop, (except kitchen top) remember to maintain the seam 50mm from the inside corners.
- A distance from hob cut-out to splashback or upstand should be min. 50mm.
- The distance of cut-out for hob to the wall should not be below 60mm.



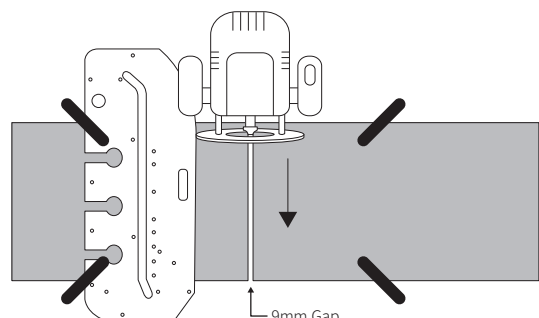
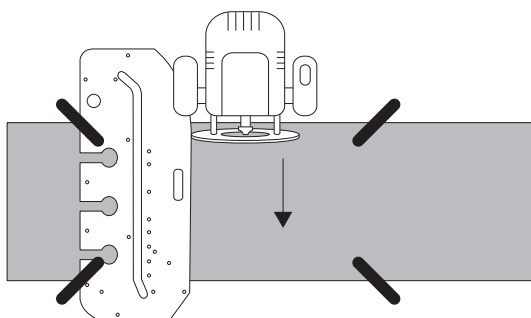
- Keep a distance of the cut-out for hobs to the next unit min. 100mm.
- Keep a minimum distance for a seam to a hob cut-out at least 300mm.
- For hob cut-out the internal edge should be covered with self-adhesive insulation tape and covered with self-adhesive aluminum reflective tape. This will prevent excessive heat buildup and the potential risk of stress cracking.
- Always leave a minimum of 3mm space between the underneath of the appliance and the edge of the HIMACS MyWorktop® if possible (depending on the type of hob you may have to include a filling piece)
- Ensure proper air ventilation and avoid any air to accumulate.
- Inspect the site and check for anything that could interfere with fabricated elements. Check for unevenness in the wall / flooring etc.



2. Cutting

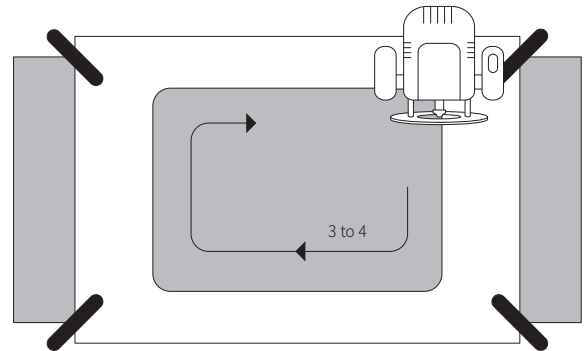
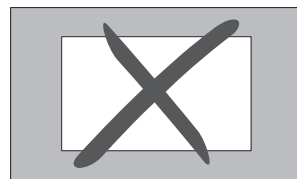
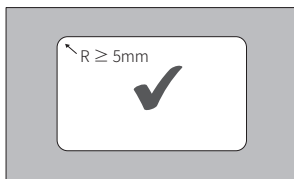
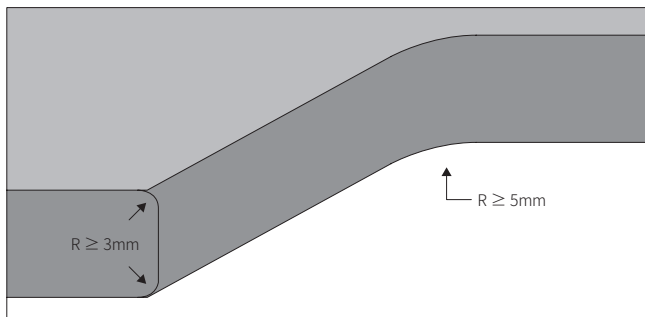
- You should allow an expansion gap of 1.5mm per linear metre of HIMACS MyWorktop® when fitting the product between two walls.
- Clamp the jig/template in correct position on the HIMACS MyWorktop®, and check the position carefully.
- For the economical fabrication, 4 or 5 linear straight wooden strips like MDF in 12mm(T) x 150mm(W) x 100cm(L) size can be used instead of jig/template.
- For long cuts to length direction, use 2,400mm guide rail for more stable and accurate cut.
- Cut HIMACS MyWorktop® with router. When routing the HIMACS MyWorktop®, to ensure a clean cut and avoid cutting marks, make 3 or 4 times routing along the cut increasing the depth of cut by 6 to 8mm with each routing until the complete thickness is cut through.

- The most reliable method for clear cutting and jointing is the “mirror cut” technique with a hand-held router, which works by cutting both adjoining edges in one cut.
- Place the two pieces of HIMACS MyWorktop® on a level surface leaving a gap of 9mm between them and secure with screw clamps. Clamp a metal or compact straight edge to one of the pieces and to a strong and stable table.
- With a 12mm double flute tungsten router bit fixed into your hand router, move the machine steadily in one direction away from your body and cut both sections at once.
- Taking care that there is nothing underneath its path, screws etc.
- Maintain a slow steady pace without stopping. After cutting check that the joint matches perfectly and mark the mating position with a pencil line.



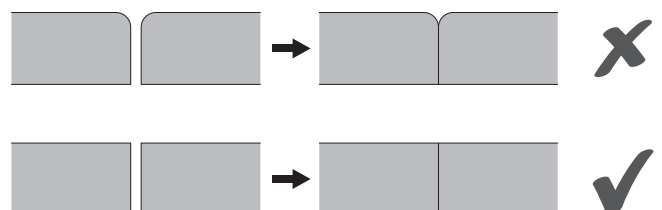
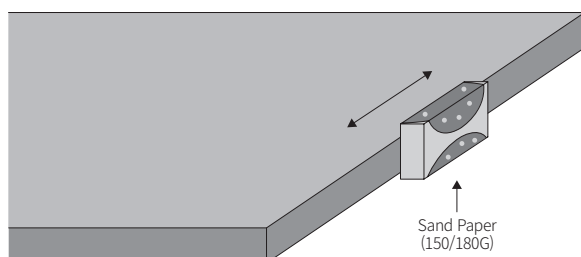
3. Cut-out

- Always ensure there is a radius to all internal corners of the cut-out, ($R \geq 5\text{mm}$). Never have square internal corners!
- Always ensure that there is a radius of $R 3\text{mm}$ on the top and bottom of the cut-out.
- Follow the instructions supplied with the Hob or Sink, use the template provided to make an MDF jig to use with router to make the cut in the HIMACS MyWorktop®. Make sure you allow for the distance between the bush guide and cutter. Check the hob or sink fits the jig prior to cutting the HIMACS MyWorktop® on the HIMACS MyWorktop®, and check the position carefully.
- All cut-outs must be machined using a router with at least a 10mm diameter cutter and a bush guide.
- Cut HIMACS MyWorktop® with router. When routing the HIMACS MyWorktop®, to ensure a clean cut and avoid cutting marks, make 3 or 4 times routing along the cut increasing the depth of cut by 6 to 8mm with each routing until the complete thickness is cut through.
- Before last cut ensure the cut-out piece will not fall freely, support fully.



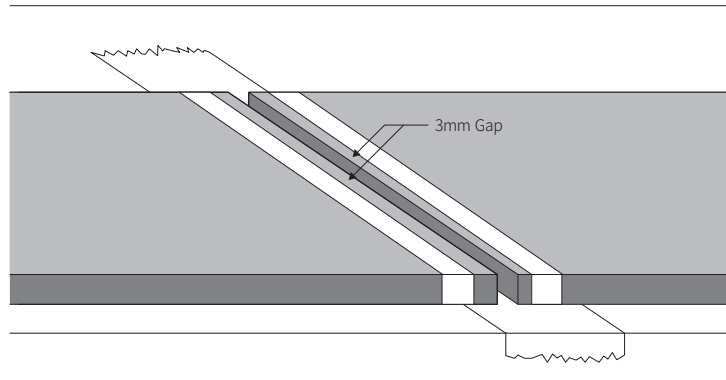
4. Preparing the Bonding

- The machining of two pieces of HIMACS MyWorktop® to create a seam joint can be carried out in different ways. What is important however, is the quality of the machined edge.
- The goal is always to create a perfect seam without any visible gaps at all. The better the seam is prepared, the better the joint will be.
- When edges have been cut, sanded and cleaned, they are ready for bonding. The original edge must be cut and sanded, if you want to use at joint part.
- To prepare the cut faces for bonding, each side of the joint needs to be square cut.
- The broken/profiled edge of the surface edge needs to be removed. The sheet edge has a small round due to sanding in manufacture, it is important that this is removed to prevent a visible glue line.
- After cutting, both cut edges will require sanding with 150/180 grit abrasive sandpaper and to be cleaned using denatured alcohol with a white clean cloth or white industrial paper, in preparation for bonding.
- Ensure the edges are dry and free of debris and dirt including the surrounding edges.

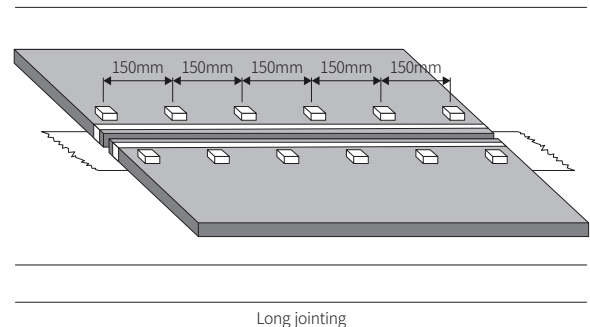
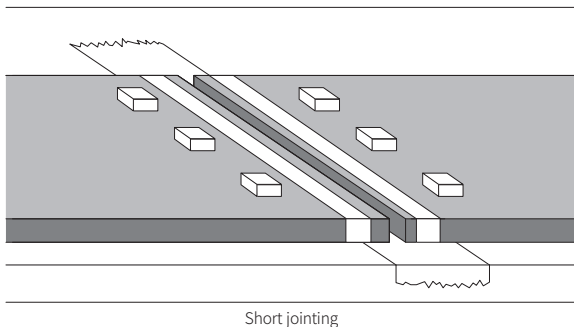


5. Jointing

- Before starting ensure the sheets to assemble are placed in the right position and have been produced according to its production flow.
- Cover the area beneath the joint with tape in order to catch any overspill of adhesive.
- Apply masking tape about 3mm from the edge of each joint line.



- The sheets are to be clamped together using for example screw clamps. It will be necessary to fix small timber blocks to the sheet using hot melt adhesive.
- Fix the 6 blocks (3 each side of the joint) just outside the masked area using hot melt and lined up so a clamp can be positioned at either side to pull the joint together.
- Long jointing (over 620mm length joint) : Fix several blocks at each side of the joint. The method is similar with case of short jointing. But, max 150mm distance between blocks is recommended for strong jointing.
- Alternatively, seaming clamps for solid surface can be used.



- Ensure all joint parts are prepared and positioned correctly before mixing the adhesive kit.
- The working time of the adhesive once mixed is around 5 minutes depending on ambient temperature.
- Finish bonding in 3~4 minutes from mixing.
- Wear gloves before using HIMACS MyWorktop® adhesive kit. HIMACS MyWorktop® adhesive gets very hot around 5 minutes after mixing.
- Prepare the HIMACS MyWorktop® adhesive kit.
- Tube type or cartridge type adhesive can be used

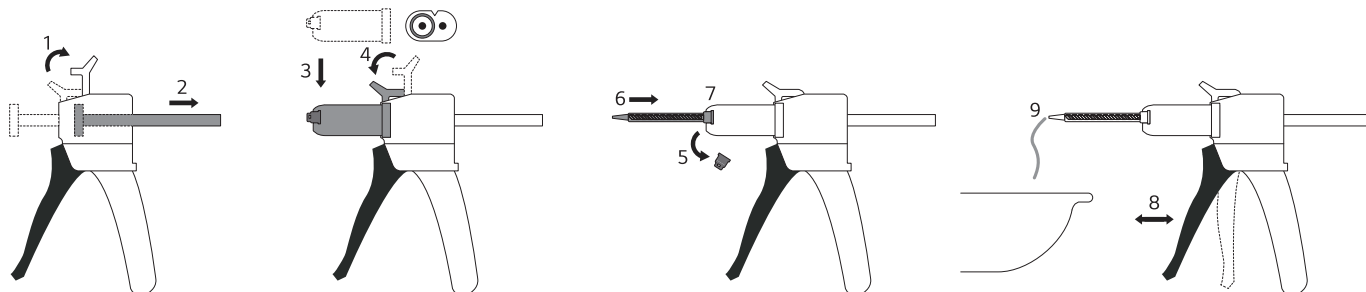
Tube type adhesive

- Smaller tube (A) is the main component and bigger tube (B) is the catalyst.
 1. Open the 2 tubes, and cut the head of bigger tube (B) 6mm.
 2. Squeeze all main component in smaller tube (A) into bigger tube (B).
 3. Put on the cap of bigger tube (B), and mix well by kneading for 1minute. If not mixed well, the adhesive will discolour and become weak.
 4. The cap of bigger tube (B) has an outer cap and a nozzle. Open only the outer cap.
 5. Throw away the first 3 to 5 drops of mixed adhesive.

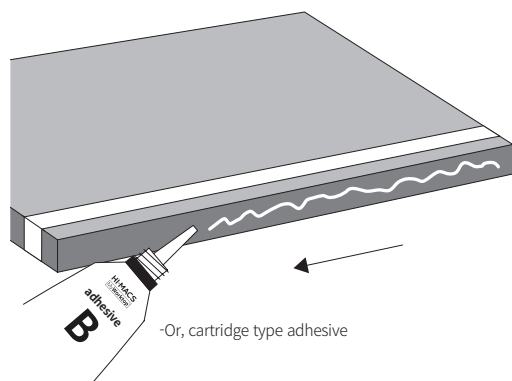


Cartridge type adhesive

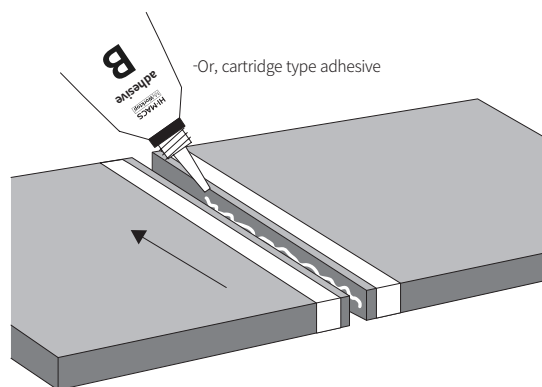
1. Open the cartridge mounting cover.
2. Pull back the pushing bar of the dispenser gun.
3. When mounting the cartridge, the shape of flange and gun guide must match together. (small to small / large to large)
4. Close the cartridge mounting cover.
5. Remove the cap of the cartridge.
6. Place the mixer tip with its nozzle to the cartridge.
7. Turn the cap part of mixing nozzle and lock.
8. Pull the trigger of the gun.
9. Throw away the first 2-3 cm of mixed adhesive.



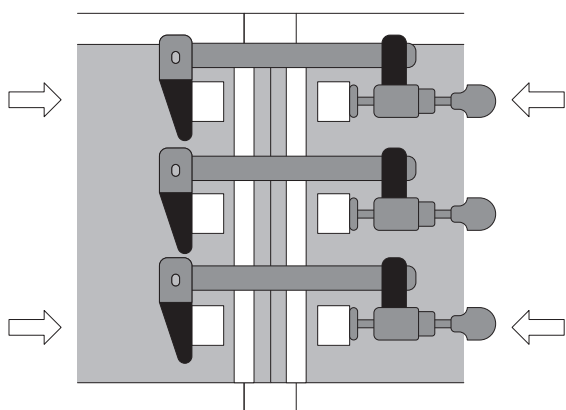
- Apply adhesive to the cut edge of the both sheets.



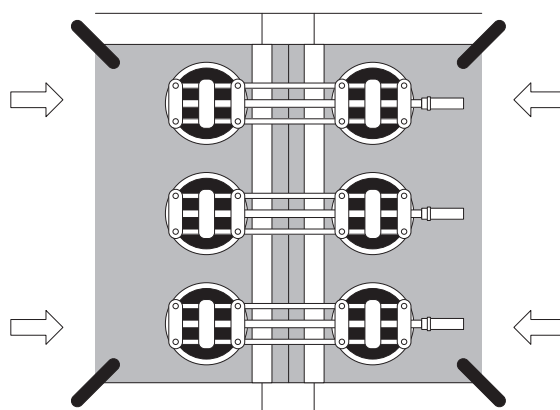
- Apply a continuous bead of adhesive along the entire part to be joined.



- Push the sheets together so that an even bead of adhesive is forced out from the joint.
- Clamp the assembly but do not over tighten it, as this will cause weak joints through starvation of adhesive.



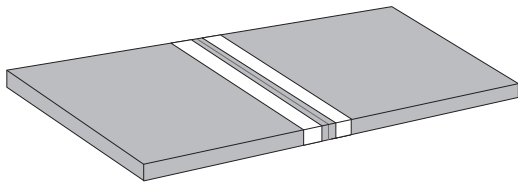
- The joint of HIMACS MyWorktop® should be no larger than a half thickness of a piece of paper.
- Ensure the surfaces are level and tighten together.
- Ensure that both sheets are flat without angle.
- If the two sheets make an angle at joint line, make them flat by clamping the edges of both the sheets (opposite the joint line) to a worktable.



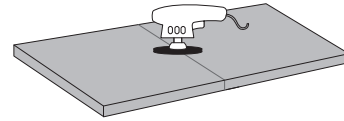
or



- The hardening time of the adhesive depends on the room temperature and the amount of adhesive applied.
- Let the adhesive cure for a minimum of 40 minutes or until hard to your fingernail touch.



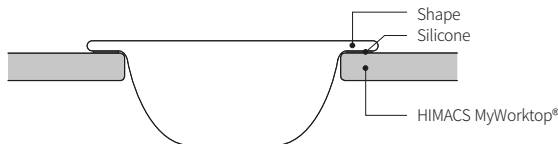
- Remove the tape and clamps once the adhesive is fully cured and hard to the touch.
- Finish the joint by sanding method described in section 10 - Sanding.



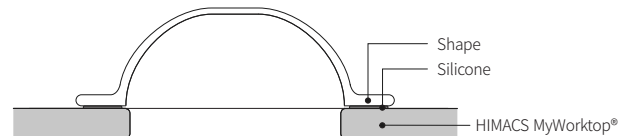
- There may be a slight colour difference and marble patterns cut between two sheets near the joint line, these are natural features of HIMACS MyWorktop.

6. Shape Installation

- Prepare cut-out as per section 3.
- Round and smoothen the edge of cut-out.
- Flip MyWorktop sheet upside down, if you install undermount shape.
- Place moisture resistant silicone around the edge of shape.
- Place shape in correct center position. Fix the flange of shape to HIMACS MyWorktop® with clamp, or put some heavy items (aprox.20kg) on the shape.



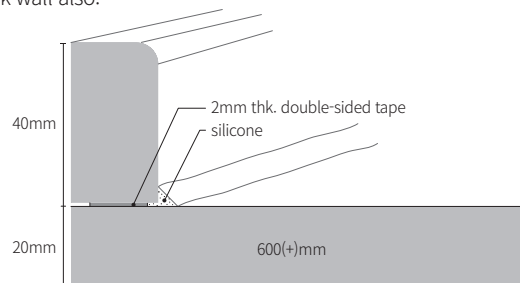
- Allow the silicone to dry at room temperature for 24 hours without touching in a dry well ventilated room.
- Stainless Steel, ceramic and HIMACS MyWorktop® shapes can be installed, either under mounted or top mounted.
- First, follow the guideline of shape supplier to install shape in HIMACS MyWorktop®



7. Fitting Upstand

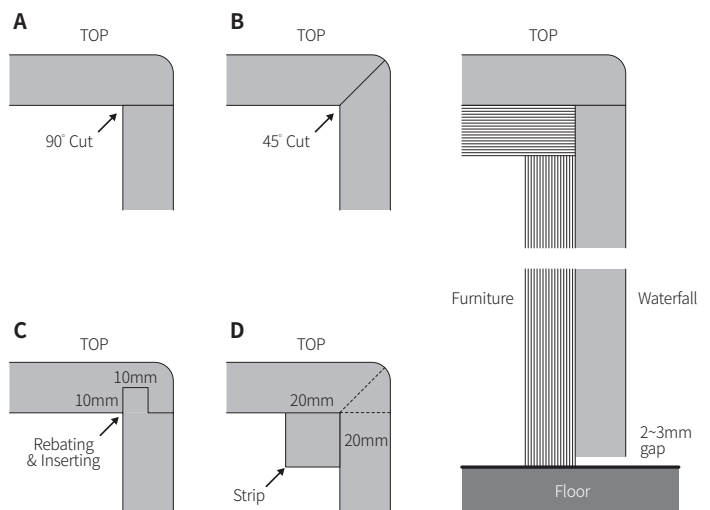
- Prepare a HIMACS MyWorktop® upstand according to the height of upstand.
- Smooth all cuts & trimming marks.
- Break all edges (R= min. 1,5mm)
- Coat the back of the upstand or splashback with a good quality flexible silicone adhesive.
- Apply thk.2mm*15mm width double sided foam tape along the top back edge of the HIMACS MyWorktop®, then position the upstand and apply hand pressure until a sufficient bond is achieved (refer to adhesive manufacturer's instructions).
- Use a damp cloth to remove excess silicone from joint between upstand and HIMACS MyWorktop®.

- Apply a bead of clear silicone at the top back corner between HIMACS MyWorktop® and upstand, between upstand and back wall also.



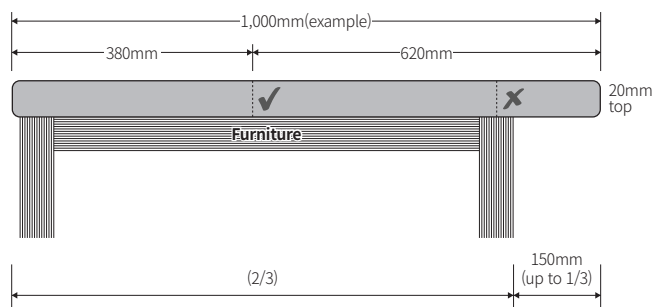
8. Fitting waterfall

- Waterfall can be made by jointing top panel and side panel in 90°.
- There are three ways to make the edge of waterfall
 - A.** Flat jointing by 90° cut is the most simple way. But, it is not strong enough for long term use.
 - B.** Angle jointing by 45° is useful to make better appearance of joint for Aurora product. But it is also not strong enough for long term use.
 - C.** Rebating and inserting is the most recommended strong jointing method.
 - D.** If you want a stronger edge joint for section A and B, attach HIMACS MyWorktop® strip (cut from original sheet) with adhesive along the whole length of inside corner of the joint.
- Adhesive should be applied fully at every joint.
- Make round all edges (R= min. 1.5mm)
- Waterfall should be attached at strong base structures like kitchen furniture. Never install independently without structures or supports.
- The length of Waterfall should be a bit shorter (2~3mm) than the furniture height, so that the bottom edge of waterfall does not reach the floor.

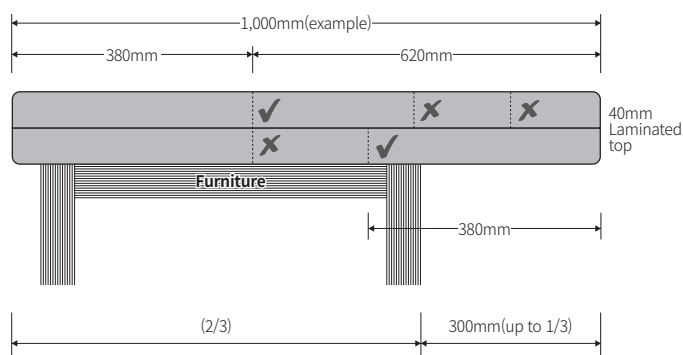


9. Fitting breakfast bar(Overhang)

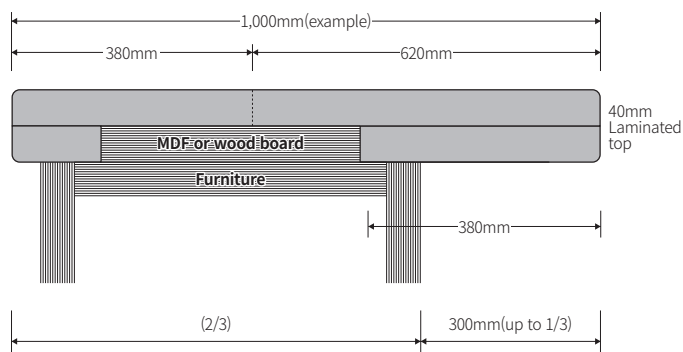
A. Overhang up to 150mm can be made with 20mm thickness top by single 20mm sheet.



B. Overhang up to 300mm can be made with 40mm thickness top made of laminating 20mm sheets.



C. Or, overhang needs strong under layer like 20mm thickness MDF board or composite wood board.

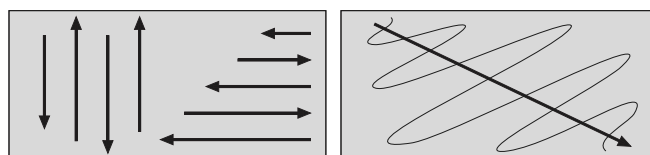


- Overhang over 300mm should be supported by corbels and/or supports at every 600mm.
- Never design the overhang over 1/3 width of whole width of top.
- Joint line of jointed wide width top should be designed to put on opposite side to overhang : Never put the joint line near and/or on the overhang.
- Joint line on the laminated top should be overlapped to staggered.
- When you make laminated wide top, join the top section together first and then laminated underneath.
- When you laminate sheets, adhesive should be fully applied between the two sheets. All edges of laminated sheet should be filled with enough adhesive, so that it can be squeezed out from all edges.
- Make round all edges (R= min. 1.5mm)

10. Sanding

- The recommended finish for HIMACS MyWorktop® standard fabrication is a semi-gloss finish.
- Some colours of HIMACS MyWorktop®, especially darker colours with higher colour pigmentation need to have more sanding and finishing care.
- Use an 180 Grit. Clean surface from dust, and ensure all the previous grit sanding marks have been removed.
- Switch to 240 Grit Wipe off the dust and ensure all the previous grit sanding marks have been removed.
- Switch to 320 Grit. Wipe off the dust and ensure all the previous grit sanding marks have been removed.
- Change to use 400 Grit. Clean the top from dust and ensure all the previous grit sanding marks have been removed.
- Sand the top with a SG or Maroon Scotch Brite 7447 pad Clean

- the top once again and examine the final finish.
- Clean off any dust or wipe off with wet soap-water and dry cloth/paper
- When starting with the sanding process using the manual method, following the direction < West - East > and then change to < South - North > direction.
- Repeat the directions, moving the random orbital sander in small circular motions, each time overlapping the previous made circle.



11. Fixing HIMACS MyWorktop® to the Furniture

- When the jointed and finished HIMACS MyWorktop® are in the final position, they should be fixed in place to the base units with

high modulus silicone. The silicone may be used as small spots in place for ease of removal at a later date.

Use and Care:

Please visit www.myworktop.uk before you use MyWorktop for the information ' Use and Care'