

MEGANITE®

TECHNICAL
BULLETINS

BRIGHT, VIBRANT, AND DARK SOLID COLOR
FABRICATION RECOMMENDATIONS

DOCUMENT PURPOSE

This document offers recommended fabrication techniques for fabrication of bright solid colors, vibrant solid colors and dark solid colors of Meganite Acrylic Solid Surface.

MEGANITE COLORS INCLUDED IN THIS CATEGORY

Grey 056A	Parapet Grey 090A	Slate 040A	Pewter 093A/X	Jet Black 019A/X
Fire 088A	Tangerine 077A	Sunshine 079A	Lime 060A	Chocolate 091A/X

And any non-white & non-off-white solid colors from Pantone, NCS, paint matches or custom matches designs.

DUE TO THE INHERENT REFLECTIVE PROPERTIES OF THESE COLORS, THE FOLLOWING PAGES INCLUDE ILLUSTRATED FABRICATION TECHNIQUES FOR YOUR REVIEW.

MEGANITE®

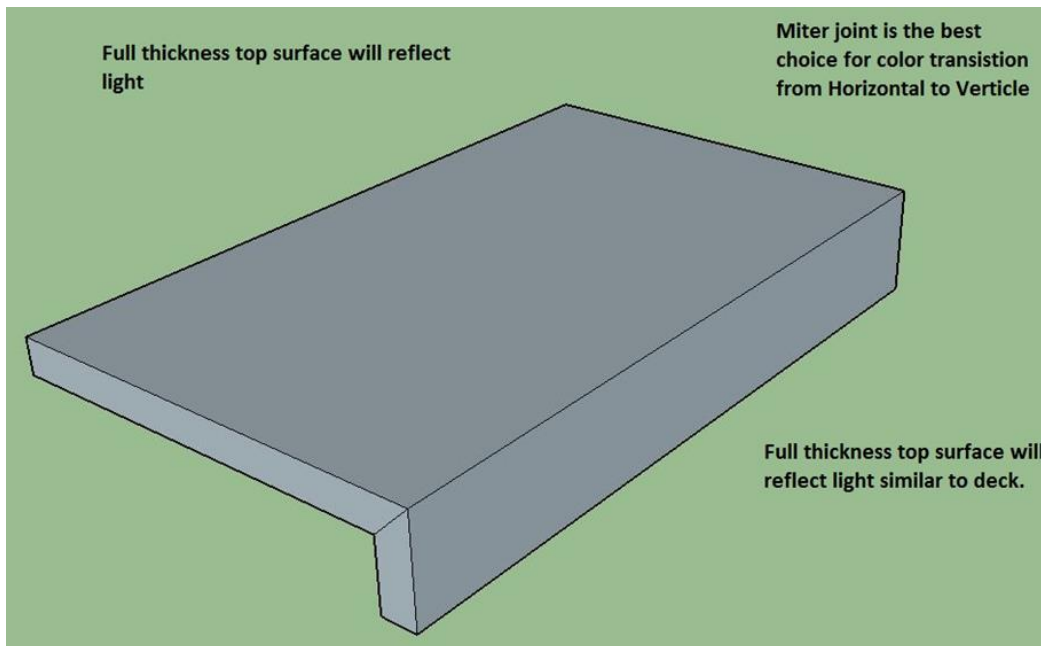
TECHNICAL
BULLETINS

BRIGHT, VIBRANT, AND DARK SOLID COLOR
FABRICATION RECOMMENDATIONS

BEST OPTION - MITER EDGE FOR BUILDING AN EDGE

Diagram 1 is a sample of the best fabrication technique, to give the edge and deck surface the most consistent color appearance. Always do a mockup test piece to make sure you and/or your customer is satisfied with the final product.

Diagram 1 Miter Edge (Best Option)



MEGANITE®

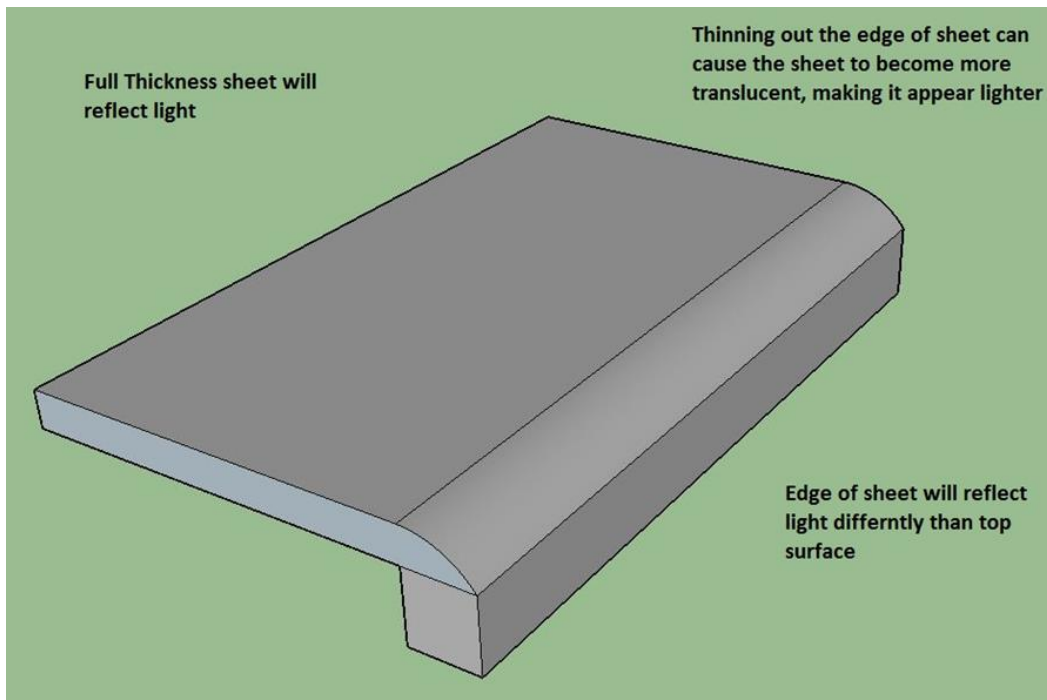
TECHNICAL
BULLETINS

BRIGHT, VIBRANT, AND DARK SOLID COLOR
FABRICATION RECOMMENDATIONS

STACKED LAMINATED EDGE

The top surface of these colors can reflect light differently than the edge of the sheet. As a result, the top surface might look differently in color compare to the edge. Diagram 2 is an over exaggerated diagram of how a laminated edge may appear. Always do a mock up test piece to make sure you and/or your customer is satisfied with the final product.

Diagram 2 Stacked Laminated Edge



MEGANITE®

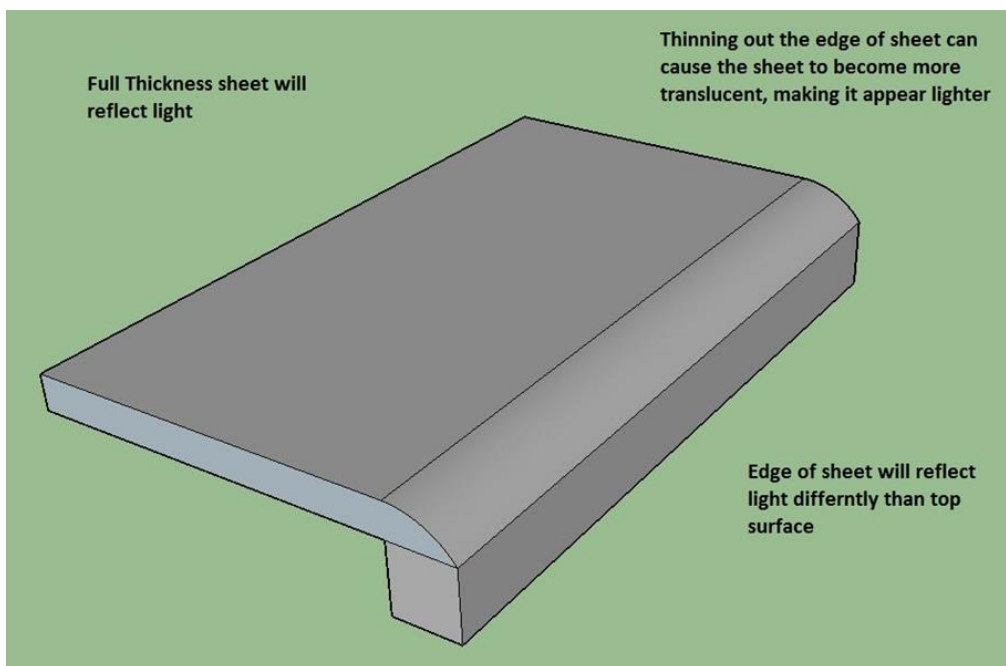
TECHNICAL BULLETINS

BRIGHT, VIBRANT, AND DARK SOLID COLOR FABRICATION RECOMMENDATIONS

DROP EDGE

The top surface of these colors can reflect light differently than the edge of the sheet. As a result, the top surface might look differently in color compared to the edge. Diagram 3 is an over exaggerated diagram of how a drop edge may appear. Always do a mockup test piece to make sure you and/or your customer is satisfied with the final product.

Diagram 3 Drop Edge



GENERAL THERMOFORMING GUIDE TO COLORS IN THIS CATEGORY

Please be aware when bright, vibrant and dark solid colors can have more visible white stretch marks after thermoforming. And discoloration is possible. This is not a material bending issue. It is generally because the material is bent too fast or not heated through enough.

When do thermoforming to above colors, the material shall be heated in oven at 150-160°C (302-320°F), 10-20 mins. The common radius shall be $\geq 150\text{mm}$ ($\geq 5\text{-}15/16''$). Heating temperature higher than 190°C (320°F) is not recommended. Heating time longer than 30 min is not recommended.

Every oven is different. Results can vary. PRACTICE ON PARTIAL OF SHEET IS RECOMMENDED BEFORE CARRYING OUT THERMOFORMING ON FULL SHEET.

IF YOU HAVE QUESTIONS, PLEASE CONTACT MEGANITE SOLID SURFACE REPRESENTATIVES, AUTHORIZED FABRICATORS, DISTRIBUTORS OR EMAIL US AT INFO@MEGANITE.COM.

ALL TECHNICAL BULLETINS CAN BE FOUND @ WWW.MEGANITE.COM