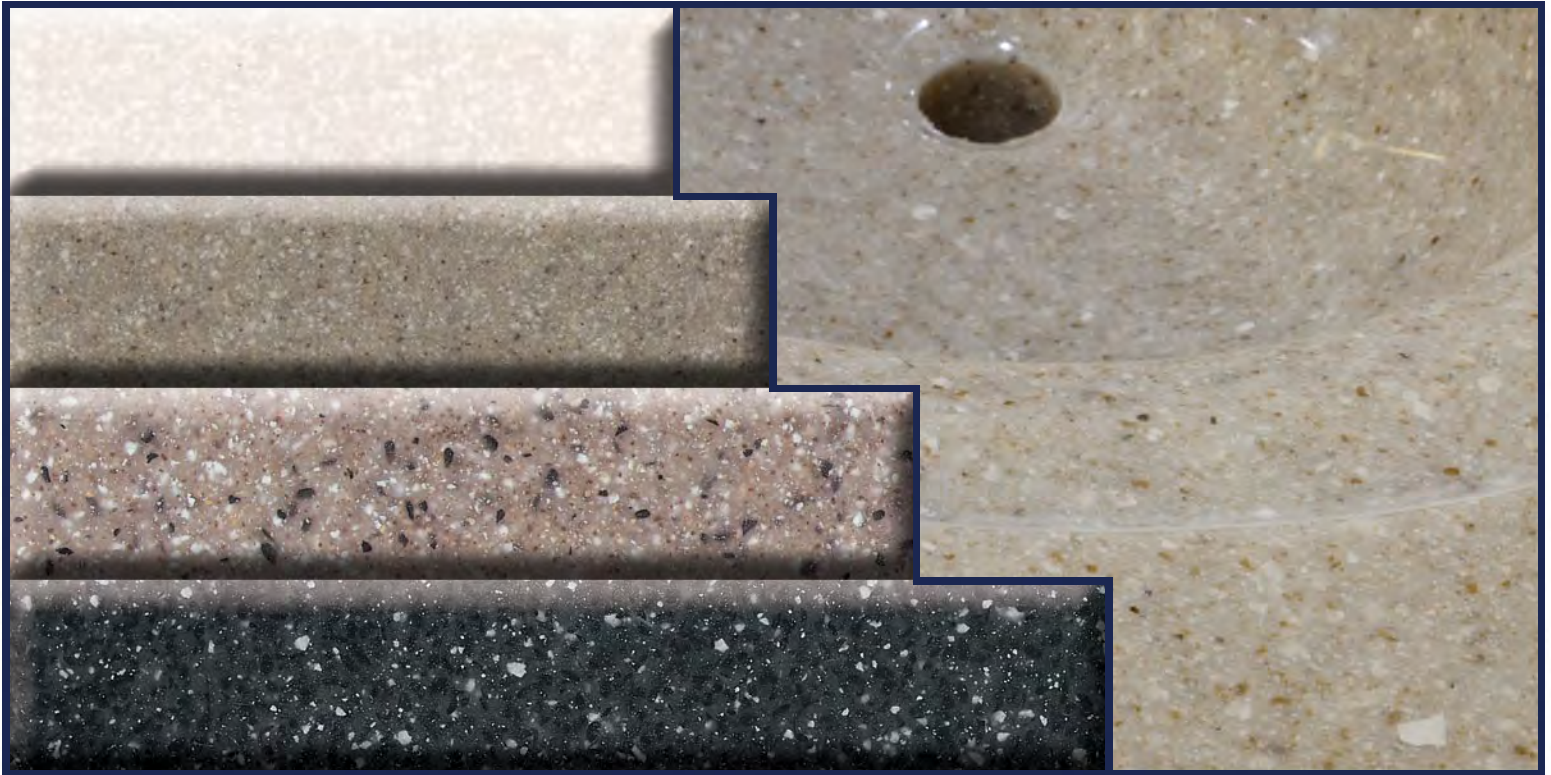




THE R. J.  
**MARSHALL**  
C O M P A N Y

*Castable  
Granite Effect Filler*

**STONE  
FILL**



Stone Fill (SFL) & The New Stone Fill HD (SFHD) granite effect materials are designed for casting behind clear gel coat. The New Stone Fill HD offers a high definition large aggregate appearance which adds another unique option for marble manufacturers that compliments the already popular Stone Fill line.

toll free: 800-338-7900 ▪ customer care: 888-514-8600 ▪ [salesinfo@rjmarshall.com](mailto:salesinfo@rjmarshall.com)

[www.Rjmarshall.com](http://www.Rjmarshall.com)



# STONE FILL



SFL2000 Flurries



SFL2013 Sand Dollar



SFL2015 Almond Buff



SFL2030 Blizzard



SFL2100 Pewter



SFL3000 Sandy Beach



SFL3002 Mojave Dune



SFL3040 Coral Sand



SFL3110 Tidal Sand



SFL3221 Caramel



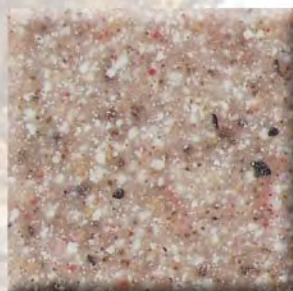
SFL3300 Walnut Toffee



SFL3310 Oxford



SFL3350 Coffee



SFL3400 Mahogany Mist



SFL3430 Mesquite



SFL3600 Light Fawn



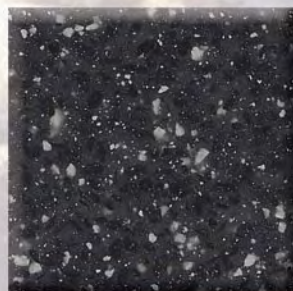
SFL3620 Sycamore



SFL3750 Tortilla Chip



SFL3900 Crushed Almond



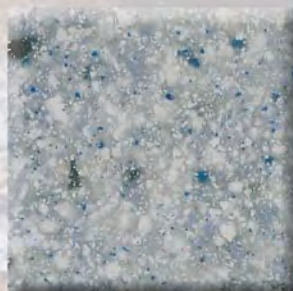
SFL4200 Obsidian



SFL4300 Graphite



SFL6300 Winter Pines



SFL7230 Chambray



SFL7300 Denim



SFL8000 Peach Freeze



SFX3500 Champagne



# STONE FILL HD



**NEW!** SFHD 2085 Polar



SFHD 2105 Savannah



SFHD 2340 Oyster



SFHD 2400 Silver Birch



**NEW!** SFHD 2720 Flagstaff



SFHD 3010 Riviera



SFHD 3150 Sahara



SFHD 3200 Caraway



SFHD 3365 Mesa



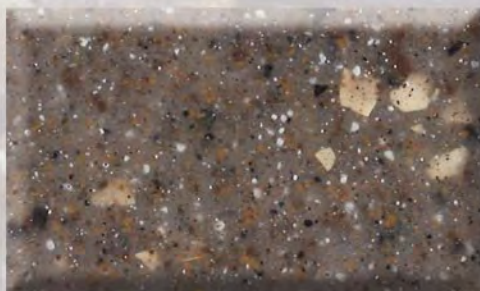
SFHD 3675 Hickory



**NEW!** SFHD 3815 Granola



SFHD 3825 Nutmeg



SFHD 3945 Maui



SFHD 4115 Meteor Grey

## **Stone Fill & Stone Fill HD offer the following features:**

- One bag, preblended mix - Good filler suspension in a casting resin
- Color consistency from batch to batch - Easy to cut with standard marble tools
- Minimal abrasion during mixing - Easily pigmented to achieve numerous hues
- Same appearance is obtained when casting on vertical & horizontal surfaces

*\*Actual color and granule size will vary. Final product determination must be based on casting in your resin and process.*





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COMPANY



## Suggestions For Use:

### Gelcoat

We recommend that a gelcoat be used on all gravity cast, Stone Fill & Stone Fill HD granite effect products. A gelcoat thickness of 22-25 mils (wet) is recommended. To obtain a satin finish use a 400 to 600 grit sand paper or a 3M "Scotch Brite" pad. Gelcoat protection is necessary with this material to ensure chemical, stain and blush resistance.

### Resin Suggestions / Mixing Instructions

An onyx or swing type resin is recommended due to the translucent nature of the material, however, you may use a general purpose marble casting resin. The appearance of the Stone Fill & Stone Fill HD final product may vary in color and translucency when different resins are used. The recommended resin level for Stone Fill granite is 30-35% by weight and Stone Fill HD granite is 33-38% by weight. *Due to the delicate nature of the thin chips in Stone Fill HD, please mix carefully. We suggest mixing the resin & catalyst first, then add the Stone Fill HD and mix until filler wet out. Also, increasing the resin percent will reduce the matrix viscosity which decreases shear stress.*

*SFL2013, SFL2015, SFL3002, SFL3221, SFL3430, SFL3610, SFL3630, SFL4220, SFL4400 and SFL6320 include granite effect highlight granules. These products can be poured at 25% resin by weight using a medium viscosity onyx or swing resin.*

### Catalyst Level

The catalyst level should be about the same as cultured marble. A 1% catalyst level is a good starting point. The gel time for the granite matrix should be between 20 and 30 minutes.

### Matrix Consistency

When the resin level is as recommended, the flow characteristics should be similar to cultured marble.

### Vibration

Use standard marble manufacturing practices regarding vibration.

### Thermal Cycling

When poured by standard marble manufacturing procedures Stone Fill & Stone Fill HD granite effect fillers will exceed all industry standards.

**STONE**  

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**FILL**



*Castable, Large Chip Granite Effect Filler*

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toll free: 800-338-7900 ▪ customer care: 888-514-8600  
www.Rjmarshall.com ▪ salesinfo@rjmarshall.com

If using less than a full bag, we suggest mixing material in the bag thoroughly before using. Material may segregate during shipping. Due to the translucent nature of these products, backfilling with any other material is not recommended. These suggestions are not meant to represent a guarantee. Each manufacturer must evaluate Stone Fill & Stone Fill HD materials and judge the suitability in their own system.

March 2014