Stone Fill (SFL) & Stone Fill HD (SFHD) granite effect materials are designed for casting behind clear gel coat. 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.
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
- Same appearance is obtained when casting on vertical & horizontal surfaces

Final product determination must be based on casting in your resin and process.

Actual color and granule size will vary.

*Features a reflective additive.

SFX colors contain special effect granules.
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.

- SFHD
The recommended resin level for Stone Fill HD granite is 35-39% by weight. This resin percent will vary based on resin viscosity and temperature. 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.

- SFL
The recommended resin level for Stone Fill granite is 30-35% by weight. This resin percent will vary based on resin viscosity and temperature. SFX2013 and SFX2015 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.

NOTE: 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.

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