



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

26776 W. Twelve Mile Rd.
Southfield, MI 48034-7807
248/353-4100
toll free USA 800/338-7900
Fax 248/948-6460
www.rjmarshall.com

Suggestions for Use

Densified Granite Effect – DGE & Luxury Series Granite Effect for Solid Surface or Gravity Cast Applications

Equipment – The basic equipment needed for solid surface manufacturing includes a vacuum mixer or continuous casting machine with a densifier, appropriate molds, table sander, and necessary saws and routers. For gravity cast manufacturing, a mixer and molds are needed. For additional information, please see our paper entitled “Solid Surface Manufacturing”.

Resin Suggestions – The appearance of the final product may vary in color consistency when different resins are used. While percentages may vary, the recommended resin level for most DGE applications is 30 – 35% by weight. In cultured granite applications, (behind a clear gel coat), the use of an onyx or swing type resin is recommended due to the translucent nature of the material.

Catalyst Level – A catalyst level of 1.5% by weight of resin, is a recommended starting point. Differing catalyst levels can change the overall color of the material. The gel time should be between 20 and 30 minutes. If excessive gel times are experienced a change in catalyst may be necessary.

Matrix Consistency – When the resin level is around 30-35% by weight, the matrix should have a workable consistency. The use of Hylite Granules or Luxury Line granites with Hylites included may require a higher viscosity mix and less or no vibration. This higher viscosity may be achieved by reducing your resin percentage by 1-3%.

Vibration – If vibration is necessary, it should be minimal. Vacuum mixing, creating a matrix with an appropriate viscosity, and using proper pouring techniques should eliminate air entrapment in the matrix.

Thermal Cycling – When poured by standard manufacturing procedures, our DGE Filler will exceed all ICPA certification standards.

Note: These suggestions are not meant to represent a guarantee. Each manufacturer must evaluate our materials and judge its suitability in their own system. Consistency in all manufacturing procedures including temperature, humidity, resin/catalyst types and levels must be kept constant from batch to batch to ensure continuous product quality. DGE and LXS series products are translucent, backfilling with any other material is not recommended. When air is entrapped in darker colors this will appear as a blushing. Textures using finer granule sizes have a higher risk of air entrapment. This problem is more significant when these materials are not vacuum mixed.



THE R. J.
MARSHALL
COMPANY

26776 W. Twelve Mile Rd.
Southfield, MI 48034-7807
248/353-4100
toll free USA 800/338-7900
Fax 248/948-6460
www.rjmarshall.com

Technical Information

Densified Granite Effect – DGE & Luxury Series Granite Effect for Solid Surface and Gravity Cast Applications

Physical Properties (Typical)

| | |
|------------------------------------------|--------------|
| Resin Demand* (ml/100g) | 20-30 |
| Gel Time (minutes) | 15-30 |

Testing done with Silmar 793C resin and Cadox M-50a catalyst
* Laboratory wet out test, actual shop resin percentage may vary.