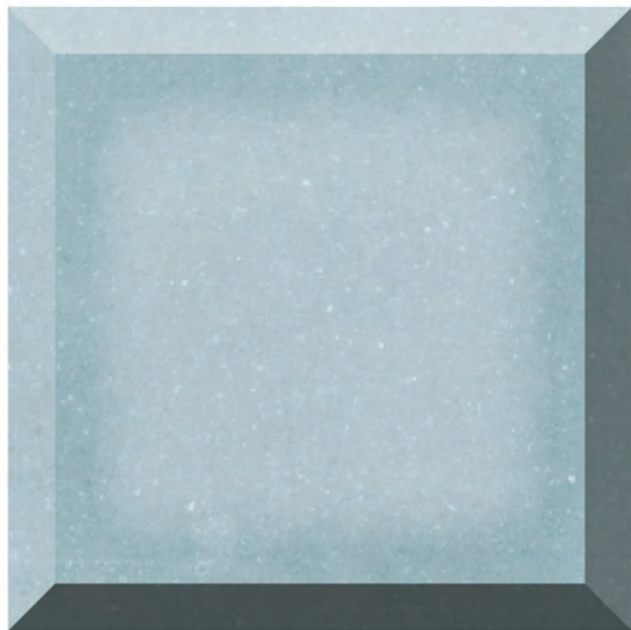


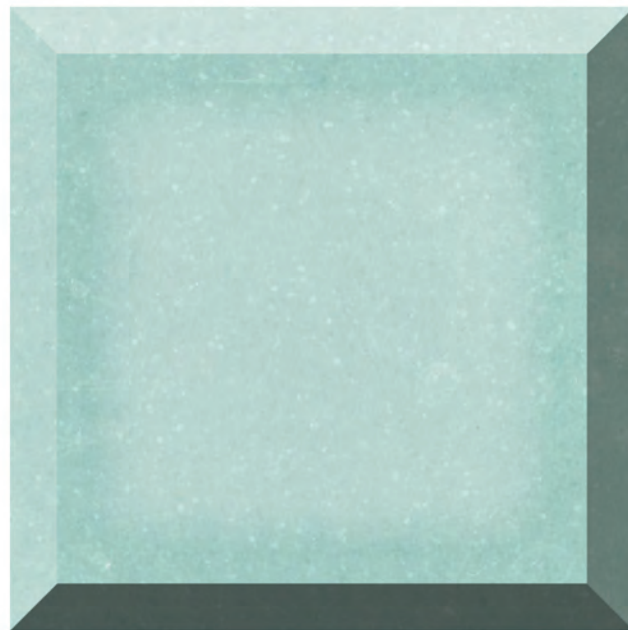
# Illuminated Color Effect

## *Standard Colors*

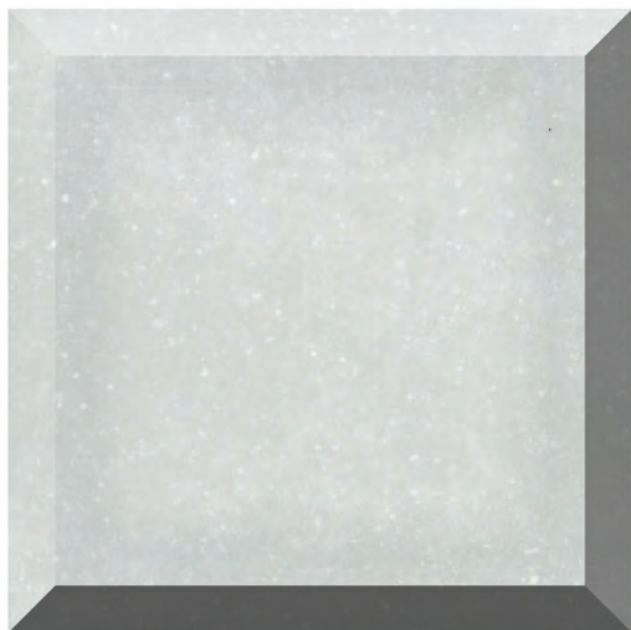
This translucent filler gives you the look of frosted glass with the properties of solid surface at an affordable price. When combined with backlight, they impart a dramatic, illuminated effect. ICE can be manufactured just like our other DGE or Stone Fill products and can be used with or without gelcoat.



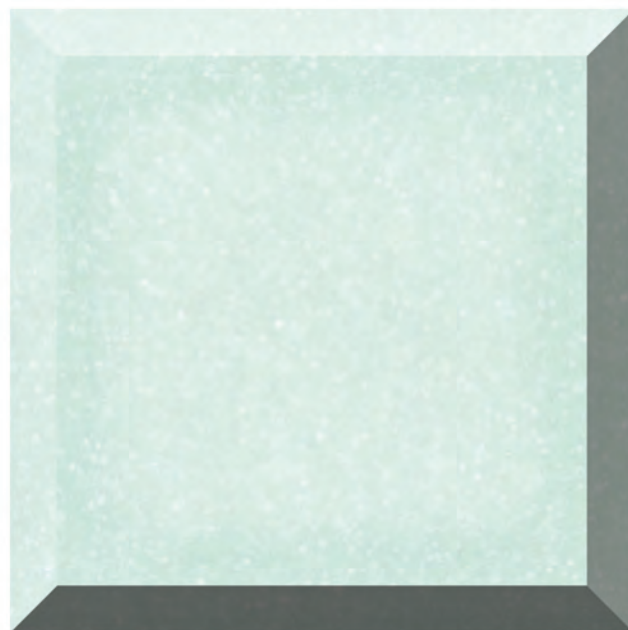
**Sky ICE 7540**



**Emerald ICE 7535**



**Winter ICE 7501**



**Jade ICE 7538**



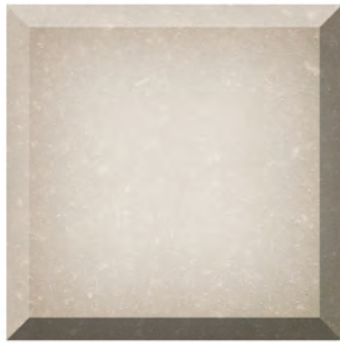
THE R. J.  
**MARSHALL**  
C O M P A N Y

26776 W. 12 Mile Road, Southfield, MI 48034  
toll free: 800-338-7900 ▪ customer care: 888-514-8600  
[www.Rjmarshall.com](http://www.Rjmarshall.com) ▪ [salesinfo@rjmarshall.com](mailto:salesinfo@rjmarshall.com)

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

# Illuminated Color Effect

## *Special Blends*



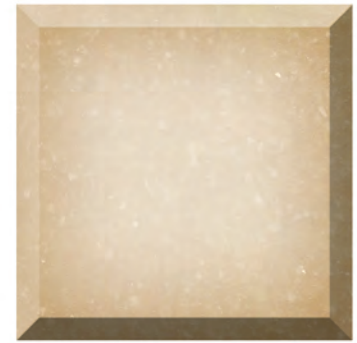
Vanilla ICE SB 7505



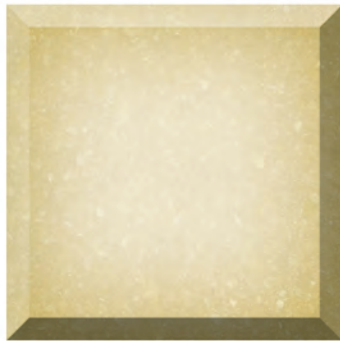
Amber ICE SB 7510



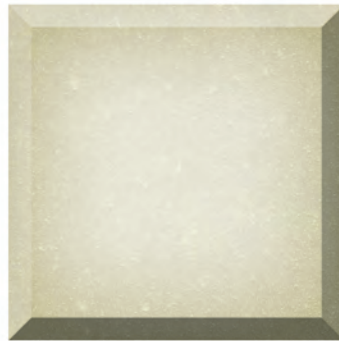
Strawberry ICE SB 7515



Melon ICE SB 7518



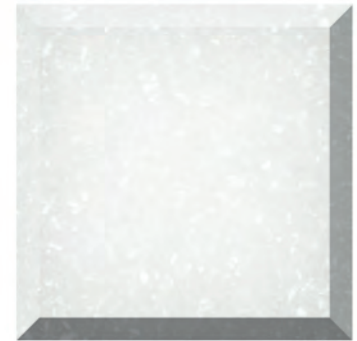
Lemon ICE SB 7520



Kiwi ICE SB 7530



Peach ICE SB 7517



White ICE SB 7500

**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** – We recommend a clear casting or solid surface resin in order to maintain a high translucency and cut down on color variations. While percentages may vary, the recommended resin level for most applications is 35% by weight.

**Catalyst** – MEKP at a level of 1.5% by resin weight is a good place to start. 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.

**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, ICE filler will exceed all ICPA certification standards.

**Fabricating** – Please be aware that, due to the translucent nature of ICE, supports, under-mount sink flanges, and dabs of silicone will show through your finished parts. When ICE is laminated together for a thicker appearance, such as in a drop-edge or seam block, the laminated areas will appear darker due to reduced light transmission. These natural effects, however, can be worked into your design schemes for a unique aesthetic appearance.

When ICE products are chosen for applications in which less translucency is desired, the backsides of the finished part can be painted to hide supports and produce a fairly uniform appearance. The color you choose will affect the final finish hue: dark and light colors will yield different looks. Painting can be done once the part is cured.

NOTE: Testing performed with Silmar 793C resin and Norox FS-100/9 catalyst

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. ICE series products are translucent, backfilling with any other material is not recommended.