

Onyx Fill™

Alumina Trihydrate for Cultured Onyx Applications

The R.J. Marshall Company offers a full line of Onyx fillers for the casting industry. They are carefully controlled for consistency and are designed to give optimal performance and beauty. Their managed resin demand contributes to good physical properties and decreased shrinkage and warpage. Off-color contamination is tightly controlled along with color consistency, which allows for predictable results. As in all ATH materials, meeting Class I flame and smoke requirements is an added benefit.

Typical Physical Properties

Product	OF136	OF250	OF255A	OF500	OF600	OF300
Resin Demand ¹ (ml/100g)	25	25	21	25	23	25
Gel Time ² (min)	15	15	20	15	15	15
Black Specks (#/100g)	10 max	10 max	10 max	10 max	10 max	10 max
Translucency (foot-candles)	115	115	105	100	120	110
Color	Cool White					Champagne

1) Laboratory wet-out test, actual shop resin percentage may vary. 2) 65% filler loading, 2% catalyst based on resin weight.

Suggestions For Use:

Manufacturing Onyx products is not significantly different than manufacturing marble dust products, but here are a few suggestions to assist in making quality parts:

Filler/ Resin Ratio Filler to resin ratios vary from product to product. The technical Information above will help you determine the starting point for your resin and filler combination. Adjustments may be needed to achieve the stiffness you desire in your mix.

Catalyst Level Gel times and curing times may be longer than cultured marble parts. If faster gel times are needed, contact your resin manufacturer for recommendations. Do not add catalyst at levels outside of the resin manufacturer's recommendations.

Background Color Onyx Fill products are color controlled. The translucent nature of Onyx Fill products allows the resin color to show up in your part. Old resins or catalysts can have undesirable effects on the background color. Choose a good quality onyx resin and test it for cured color on a regular basis.

Color Additions Veining— To preserve the depth of the onyx system, do not use pigments and other color effects except in veining. Too much pigment and heavy veining will reduce the translucent effect of the onyx.

Thermal Cycling Onyx fill products when manufactured correctly will meet or exceed the ANSI Z124.3 test standard. Careful gel-coating and manufacturing techniques are necessary for a quality part.

Marketing Onyx products give an image of quality. They offer the manufacturer the opportunity to sell a product of beauty at a better margin than cultured marble. The products should be presented to the customer in a showroom display that enhances the quality image of the onyx product.

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