

# STONE FILL



## *Castable Granite Effect Filler*

*SFHD 3200 Caraway*

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.



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SFL 2030 Blizzard



SFL 2100 Pewter



SFL 2234 Mineral **NEW!**



SFL 3000 Sandy Beach

**STONE  
FILL**

**STONE  
FILL HD**



SFL 3040 Coral Sand



SFL 3110 Tidal Sand



SFL 3175 Baja **NEW!**



SFL 3300 Walnut Toffee



SFL 3350 Coffee



SFL 3600 Light Fawn



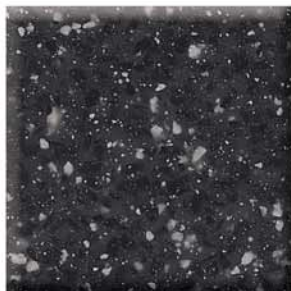
SFL 3620 Sycamore



SFL 3750 Tortilla Chip



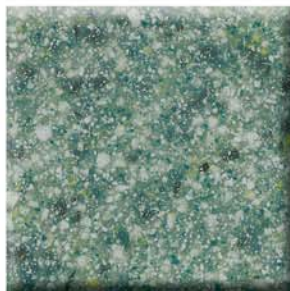
SFL 3900 Crushed Almond



SFL 4200 Obsidian



SFL 4300 Graphite



SFL 6300 Winter Pines



SFL 7230 Chambray



SFL 7300 Denim



SFX 2013 Sand Dollar



SFX 2015 Almond Buff



SFX 3500 Champagne\*

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

• • •

One bag, preblended mix

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Good filler suspension in a casting resin

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Color consistency from batch to batch

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Easy to cut with standard marble tools

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Minimal abrasion during mixing

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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.**





SFHD 2085 Polar



SFHD 2105 Savannah



SFHD 2340 Oyster



SFHD 2836 Azul\* **NEW!**



SFHD 2400 Silver Birch



SFHD 2720 Flagstaff



SFHD 2048 Colosseum



SFHD 3010 Riviera



SFHD 3150 Sahara



SFHD 3200 Caraway



SFHD 3365 Mesa



SFHD 3675 Hickory



SFHD 3815 Granola



SFHD 3825 Nutmeg



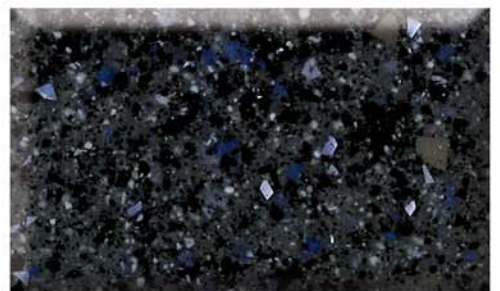
SFHD 3860 Rio Grande\*



SFHD 3945 Maui



SFHD 4115 Meteor Grey



SFHD 4350 Harbor\*



## 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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