

## CULTURED STONE NEWS

### Pigmented Back Fills, Continued from Page 2

The following are a few of our recommendations for a few of the more popular colors and is meant as a guide. Some fabricators like to experiment and can make some very unique color combinations spraying Poly Stone and backing it with a radically different back coat color. However, to get your colors to look like our samples, try adding some of these pigments to your back fill by BroCom (other pigments can be used) at a 0.5% loading for light colors, 1% for darks, and 1.5–2% for bold colors.

BroCom A-408, Almond goes with ACS:

- PS060, Dune
- PS070, Pebble
- PSC402, Aurora
- PSS312, Tan
- PSLC486, Sahara
- PSLC513, Silkstone
- PSLC510, Outback

BroCom A-2094, Designer White goes with ACS:

- PS100
- PS130, Snow

- PS220
- PSLC462, Everest
- PSLC466, Pepper Ivory
- PSLC501, Shimmer
- PS602, Edelweiss
- PSLC505, Kodiak
- PSS326, Vanilla
- PSLC 605, White Smoke
- PSLC 606, Jubilee

Adding color to the back fill—even white—can create added depth to any spray granite; as well as added safety in case small areas are sprayed to lightly during fabrication.

For more back fill color suggestions, visit our web site at [www.acstone.com/techinfo.html](http://www.acstone.com/techinfo.html). Once there, see chapter six of the Poly Stone Spray manual for more details.

Don Hay  
Western Sales Representative

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## GraniteFX™ Textured Silicone

ACS International, Inc. releases GraniteFX™, a new line of textured caulk-sealant utilizing our patented Poly Chips® granules and an industrial strength, neutral cure silicone.

ACS developed GraniteFX using a neutral cure silicone with a tack-free time of 20 minutes and a full cure time of 24 hours. Comprised of 100% neutral cure silicone and ACS's Poly Chips granules,

GraniteFX emits fewer odors and provides effective moisture and mildew blockage. Designed to seal-out water between surfaces such as shower/tub surrounds and back splashes, GraniteFX offers 350% elongation and no product shrinkage.

"We're offering customers a high-quality silicone in a variety of colors as part of our initial product line with many more colors in the forecast", says Greg Novak president of ACS International. "Our release of the GraniteFX silicone caters to cultured granite and solid surface users looking for a quality product at an affordable price."

In addition, the standard line of silicone colors match a variety of leading manufacturer's solid surface colors. For the current list of our GraniteFX color matching charts, visit our web site at [www.acstone.com](http://www.acstone.com) and click on the home page link for textured silicone. **If you haven't received a sample yet, give us a call at 1.800.669.9214!**

Please note: ACS will be closed the week of December 25<sup>th</sup> for the holiday season and returning on January 2, 2007.

Happy Holidays!



## Q & A

**Q:** What is the expiration date of Poly Stone?

**A:** One of the excellent features about the Poly Stone product line—Poly Stone has an indefinite shelf life as long as it's stored in a dry environment.

**Q:** What are the hours of operation for ACS? Did something change?

**A:** ACS has new office hours.

Monday–Thursday  
7:00 am to 4:30 pm

Friday  
7:00 am to 11:00 am

Saturday–Sunday  
Closed

**Q:** What's the largest chip I can spray?

**A:** With most spray guns, fabricators can usually only spray around a 12/18 mesh chip, yet the demand for larger chip still remains. This is where RimCraft can help fabricators. They've created a spray system that allows for the more desirable large chip sizes to be sprayed.

For more information visit [www.rimcraft.com](http://www.rimcraft.com) or call 704-933-8017.

## BIG Changes in Poly Stone!

Our Poly Stone line of products and support materials is getting updated! Some of the changes you might already have noticed and others will occur after the first of the year. What's changing?

- Ten **NEW** Poly Stone colors (figure 1) are available now! As seen in the images below, the new color line adds more warm earthy color tones to our standard color line as well as a few *pops* of color as seen in Jubilee.
- **NEW** Poly Stone brochures with over 70 standard colors represented—also available now. We decided to display our diverse line of colors in our brochure, where it's more easily done than on the display boards. We hope you like the changes!

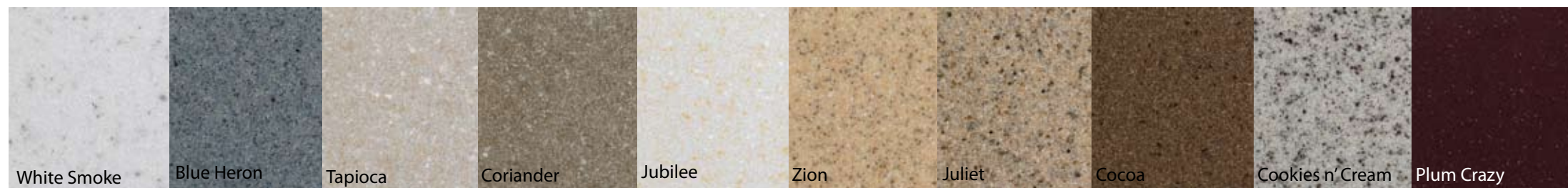


Figure 1: New Poly Stone Colors

- ACS is also reworking our sample board with the addition of the new colors and removing some other colors that aren't reflecting the current trends in color design. There will still be 50 colors represented on the Poly Stone sample board.
- Want a special *mini board*? We have a unique board that can display 10 key colors. This comes in handy for special in-store displays, or for customers that have specific colors in mind and need the added mobility of a smaller board. Currently, the mini boards are available with the ten new colors. Call your customer service representative for more information.
- Soon to follow is the spray manual with updated color charts and more. Don't forget to check if your Poly Stone color is available with a matching GraniteFX color.

Angela Kliever  
Dir. of Marketing

## Not All Colors Are Created Equal...Huh?

What fabricators enjoy the most about spray granite, can also be one of its greatest difficulties to accept. Spray granite is most often a thin layer of chip mixed with gel coat that can be sprayed onto a wide variety of mold surfaces. Backing the color up is a variety of products including lightweight fillers, such as Featherlite, ATH or calcium carbonate. This is where not all back fill colors are created equal.

When spraying granite products, such as Poly Stone, it is difficult to be exact in the coat thickness; even with a mil gauge. For this reason, pigmented back fills are often recommended for colors that could shift if the back coat is influencing the surface appearance.

*Continued on page four...*

## Thermal Shock; Gel Coat vs. No Gel Coat\*

When using spray granites, each component of the process has its own pros and cons. Most spray applications recommend using a gel coat layer first and then spraying a mixture of granules (such as Poly Stone) and gel coat. Each manufacturer has a recommended chip-to-gelcoat ratio, however most recommend spraying behind a gel coat for bowl applications. The reasoning behind this recommendation is simple—added thermal shock strength.

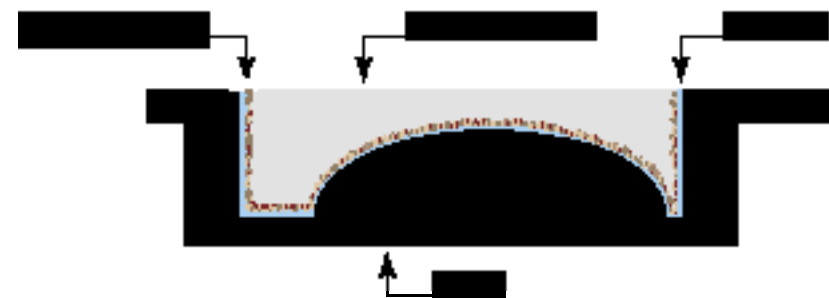


Figure 2: Standard Spray Granite Layers

As seen in figure two, three components make up a typical fabrication process while spraying cultured granite products; the gelcoat, the granule mixture, and the backfill matrix. In this study, the protective gelcoat provided a significant improvement in the thermal shocking of the test parts. The parts tested with a

gelcoat eventually showed appearance defects of small spider web type gelcoat cracks. The non-gelcoated spray granite produced larger surface cracks. In the case of the non-gelcoated parts, it is impossible to tell if a matrix crack preceded the surface crack. See figure three for test results and measurement criteria.

Thermal Shock Cycles of Gel-coated vs. Ungelcoated parts with Calcium Carbonate (CaCO <sub>3</sub> ) and Modified Backfills						
	Thermal Shock Cycles 45° at 175°F		Thermal Shock Cycles 50° at 150°F		% Increase with a Modified Backfill	
	CaCO <sub>3</sub>	MOD.	CaCO <sub>3</sub>	MOD.	175°F	150°F
Gelcoated	623	754	1501	1420	21	-5
Un-gelcoated	371	459	338	548	24	62
% Improvement by Using Gelcoat	68%	64%	344%	159%		

Figure 3: Thermal Shock Data

Previous studies have shown that the matrix backfill has a significant effect on the gelcoated hand basins. The data developed in this study shows that improvements in backfill do not improve the thermal shock ability of a part universally (figure three). Improvement was seen in specific systems, but there was not an attempt to optimize the individual systems with backfill combinations. Additional details from this study regarding the impact of the backfill matrix on thermal shock results are available.

Jack Simmons  
VP of Sales

*\*This thermal shock excerpt is from an extended study of the benefits of using a gelcoat in spray applications. To get a copy of the report, please contact Jack Simmons at [jack@acstone.com](mailto:jack@acstone.com) or call 520.889.1933*

### What's New?

As a result of increased production costs, effective December 15, 2006 ACS will implement a price increase on the majority of our product lines. For some products, such as GraniteFX, there is no price increase; however the majority of the products will receive an increase. We will be contacting our customers prior to the increase date and providing further details.

Many customers that are aware of competitive pricing know that ACS holds off longer than the competition in regards to price increases. We strive to make quality products and at reasonable prices.

Most of our readers are aware that ACS International no longer produces solid surface or stone adhesives; Acrybond and Stoneweld adhesives are now available from ITW Plexus. A change that developed from this business decision has resulted in improved excellence in service for our filler customers.

Russell Davis, previously the adhesive manager, was promoted to the laboratory director. The results of this decision were seen quickly with improved quality and service for ACS's extensive color matching capabilities. We urge you to call Russell directly for any of our laboratory services. Or, feel free to e-mail Russell at [russell@acstone.com](mailto:russell@acstone.com).