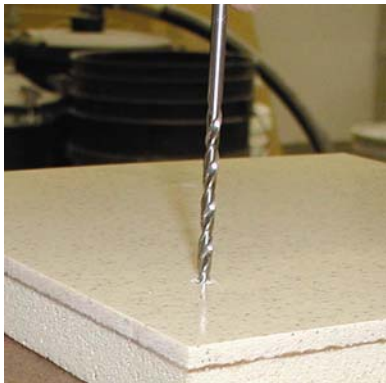


Technical Bulletin

Patching Poly Stone

Over time and hard use, chips and nicks can mar the surface of any countertop. However, repairs can be done quickly and easily with the right tools and procedures. In the following article, steps are given to repair a non-gel coat **Poly Stone**[®] solid surface piece.

As with any project, collecting the right tools for the job is the first step. Color matched Poly Stone granules, resin, blade, drill or **Dremil**[®], a Popsicle stick for stirring and a broken stick with a small point on one end (right).



Using the drill or Dremil, clean the damaged area to remove any imperfections or foreign material. It is not usually necessary to drill deeply (left).

Next, use the blade to create slanted and irregular sides on the edge of the hole (right). This is a very important step as it ensures the proper fill of the patch material, and will help the repair appear less conspicuous. Then, remove any residual particles that may have been generated from the drilling and scraping process.



Once the area preparation is complete, the Poly Stone granules and resin may be mixed (left).



The patch mixture should be made using a clear gel ISO NPG gel coat at a 60% loading to 40% Poly Stone. For improved suspension, it is often recommended that a small amount (10–20% by weight) of alumina tri-hydrate be added to the patch matrix. This also helps to ensure that the patch matches the rest of the area and is less noticeable. MEKP catalyst at a 1–2% should be stirred into the mixture for at least a minute to ensure a thoroughly catalyzed mixture. Make sure the matrix is thoroughly mixed before applying to surface area.

Using the broken stick (for larger repairs a different device should be used) drip the mixed matrix into the hole as shown in figure to the left. Be certain to overfill the area in order to allow any air bubbles to rise above the surface of the repaired area.



Curing time may vary. It is highly recommended that a heat gun (or hair dryer) be used in the curing process. This enables the patched area to obtain similar high exothermic temperatures that the original matrix did—creating a superior patch with a better color match.

Once the patch is completely cured, the area may be sanded (right). Follow the same sanding procedures that normally would be used in finishing a solid surface area. Adhering masking tape around the patch will assist in determining the sanding progress. Once the patch is close to even with the surface, switch to a fine grit sand paper that matches the surface finish of the repaired part. For matte finishes this is typically 220 to 320 grit. For high gloss surfaces a 600-1200 grit paper will be required and possible some polishing compound as a final step.



Finally, the patch is complete and should blend into the surrounding area (left).