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Would you like to receive this newsletter electronically? Or, would you rather not be on our mailing list? Please call or send your request to sales@acstone.com.

Trade Show Spot

In just a few months, ACS will be exhibiting at two shows. We will be launching the Crystic® Crestomer® product line at IBEX in October, so check us out!

Composites 2004
October 6–8
Tampa, Florida
www.acmashow.org
Visit us at booth #1246

IBEX 2004
October 25–27
Miami, Florida
www.ibexshow.com
Visit us at booth #370, hall A or at our outdoor demonstration booth (#28) for a hands-on example of the Crystic Crestomer product line!

ACS Web Continued From Page 2

our contact information. Each of these main pages contains a great deal of information intended to service our customers.

We do however, have a couple of tips prior to your visiting our new site. First, if you do not currently have Adobe® Reader® 4.0 or higher visit www.adobe.com to download this free software. All of our documents on the new site that are available for download are in a pdf format.

Second, the site is best viewed with Internet Explorer® or Netscape®, but other web browser applications can still view it. What "best viewed" means, is that the site will look better in Explorer than in another browser. Visit us at www.acstone.com. If you have problems or suggestions, please e-mail angela@acstone.com.

CASTING NEWS NETWORK

Summer 2004

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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.

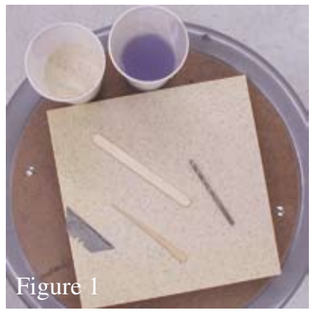


Figure 1

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 (Figure 1).

Using the drill or Dremil, clean the damaged area to remove any imperfections or foreign material. It is not usually necessary to drill deeply (Figure 2).

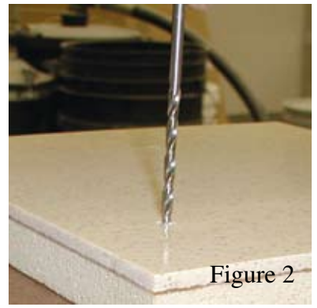


Figure 2

Next, use the blade to create slanted and irregular sides on the edge of the hole (Figure 3). 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 (Figure 4). 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 noticable. MEKP catalyst at a 1–2% should be stirred into the mixture for at least a minute to ensure

Figure 3

Cont. on page 2.

ACS International, Inc.

Q&A

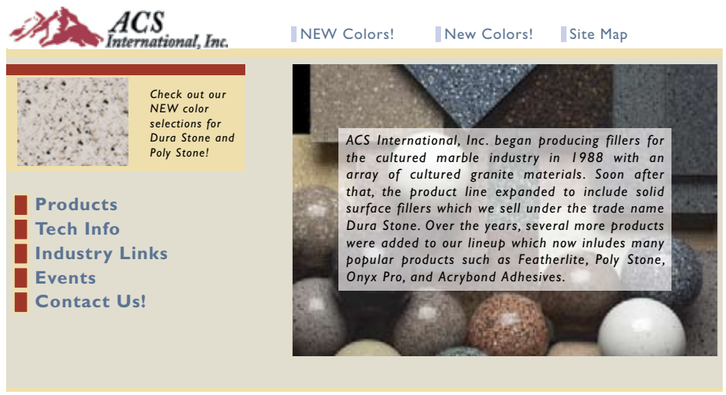
Q: How does heat affect the Acrybond™ solid surface adhesive?
A: Exposure to heat will cause the activator in Acrybond to deteriorate resulting in a reduction in curing times and incomplete cure. Prolonged exposure to high temperatures will completely neutralize the activator resulting in a product that will not cure at all. This is true for most BPO cured acrylic adhesives. Storage should be maintained at, or below, room temperature for best results.

Q: Why am I getting warpage on my flat stock without other problems with my sinks or tubs?
A: Warpage or distortion is caused by uneven shrinkage. The resin is the portion of the matrix that can have up to 7% volumetric shrinkage. When filler settles it leaves a resin rich surface. The resin shrinks and the part concaves upward—similar to a potato chip. Possible causes include:

- Over vibration causing filler settling
- Resin to filler ratio not optimized
- High exotherm
- Incorrect initiator or initiator percentage for the resin or season
- Part is pulled while it is still green and not placed on a flat surface
- Long gel time causing filler settling
- Part sticking in the mold

NEWWebsite!

Product manuals, tech bulletins, color selections, Acrybond™ cross reference charts! Does this sound like useful information? Well, visit the NEW ACS website (www.acstone.com) for lots of these helpful pieces of information. We've updated the content and the design to create—what we hope—is an easy-to-use and comprehensive site. From our home page, seen below, you can view products, technical information, distributors, industry links, events, and



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Patching Poly Stone® continued from page 1.

Figure 4

a thoroughly catalyzed mixture. Make sure the matrix is thoroughly mixed before applying to surface area.

Figure 6

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

Using the broken stick (for larger repairs a different device should be used) drip the mixed matrix into the hole as shown in figure 5. Be certain to overfill the area in order to allow any air bubbles to rise above the surface of the repaired

Figure 5

Figure 7

ACS Distributing Crystic® Crestomer®

ACS International, Inc. is pleased to announce the finalization of a distribution agreement with Scott Bader—U.K., becoming the exclusive U.S. distributor of their complete line of Crystic® Crestomer® structural adhesives for the glass reinforced plastic (GRP) industry.

Speedboat adhered together using only Crystic Crestomer's family of products.

"We at ACS are excited and confident in our partnership with Scott Bader", says Greg Novak, President of ACS, "the Crystic Crestomer line of adhesives has an excellent reputation and proven track record with over twenty years of use in the European market". ACS will specifically be distributing Crystic Crestomer 1152PA, 1181A, 1196PA, Advantage 10 and Advantage 30 in the United States. The entire line is scheduled to début October 25th at IBEX, International BoatBuilders' Exhibition and Conference, in Miami, Florida, at booth 370.

Scott Bader's headquarters are based in the UK where they have purpose-built, state-of-the-art facilities that provide complete evaluation, testing and application support. They have manufacturing facilities in the UK and in Amiens, France.

Scott Bader was established in 1921. Since 1951 it has had no external shareholders. Its shares are held in a charitable trust making the employees trustees-in-common of the company assets.

As a totally independent company, free from take-over, Scott Bader is an ideal company with which to enter long-term sustainable relationships. For further information regarding Scott Bader, please call +44 1933 663100 or visit www.scottbader.com.

Patching Poly Stone® continued from page 2.

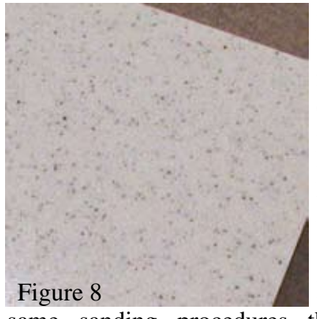
Figure 8

patch with a better color match.

Once the patch is completely cured, the area may be sanded (Figure 7). 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 possibly some polishing compound as a final step.

Finally, the patch is complete and should blend into the surrounding area (Figure 8).

Acrybond™

Continual improvement and product excellence is what our Acrybond solid surface adhesive team strives for. To meet these standards, our team of adhesive specialists have developed new procedures and techniques to create a superior solid surface adhesive.

ACS has enhanced and added to several key manufacturing procedures and equipment to improve the quality and reliability of our Acrybond adhesive line. Quality control standards have become more stringent than ever with each batch being tested for gel time, viscosity, color, adhesive strength and shelf life. In addition, we've updated our manufacturing equipment to meet the needs of large batch requests as well as to improve product quality and turn-around-time.

As always, ACS has unbeatable customer service and technical support to answer any of our customers' questions. Don't miss out on our summer shipping special. For a limited time, all Acrybond orders of $500 or more receive FREE SHIPPING anywhere in the continental United States!