

Technical Data Sheet

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Properties:

AKEMI® Machine Filler is a 2-component filler based on unsaturated polyester resins dissolved in styrene. The product is distinguished by the following qualities:

- good drawing properties due to creamy consistency
- high filling and non-sag properties
- long working time (18 - 20 minutes)
- facile grindability and high abrasive properties
- very good adhesion on metal (iron, steel, aluminum), wood, stone and various plastics (e.g. rigid PVC, polyester) also in case of higher temperatures (up to 100°C)
- resistant to water, petrol, mineral oils, diluted lye and acids

Application Area:

AKEMI® Machine Filler is mainly used in commercial vehicle construction or in the engineering industry for levelling of dents or coarse unevenness on large areas. Hardening can be accelerated by heat (infrared radiation).

Instructions for Use:

1. The surface to be treated must be free of rust and dust, dry and slightly roughened. All prior coats not hardened and thermoplastic acrylic lacquers must be removed.
2. Add 2 to 4 g of red hardener paste to 100 g of filler (4 to 5 cm of paste pressed out of the screw tube correspond to 1 g).
3. Both components are mixed until a homogeneous shade of colour is achieved. The mixture can be worked for about 12 to 20 minutes.
4. After 60 to 90 minutes the hardened filler can be worked (ground, drilled, milled).
5. The hardening process is accelerated by heat and delayed by cold.
6. The filled surface can be worked over with all fillers and lacquers which are commercially available.
7. Tools can be cleaned with AKEMI® Nitro-Dilution.

Special Notes:

- Use AKEMI® »Liquid Glove« to protect your hands.
- Apply filler in a short interval after grinding of metal surface to guarantee good adhesion.
- Hardener portions higher than 4 % reduce adhesion and deteriorate surface drying.
- Hardener portions less than 1 % delay hardening or low temperatures cause an incompletely hardening and the surface will remain tacky.
- Before coating with a 2-component lacquer apply a primer or a „Non-Sanding Sealer to avoid blistering.
- When the product is to be applied in thicker layers we recommend to use as little hardener as possible or apply several layers
- Once hardened, the filler can no longer be removed by solvents. Removal is only possible mechanically or by higher temperatures (> 200°C).
- Being worked properly, the hardened filler is generally recognized as not injurious to health.

TDS 10.19

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Technical Data: Colour: green
Density: approx. 2.02 g/cm³

Working time / min.:

a) at 20°C

2% of hardener: 18 - 20

3% of hardener: 14 - 16

4% of hardener: 12 - 14

b) with 2% of hardener

at 10°C: 33 - 36

at 20°C: 18 - 20

at 30°C: 9 - 11

Storage: If stored in dry and cool condition (5-25°C/41-77°F) in its closed original container at least 12 months from production.

Health & Safety: Read Safety Data Sheet before handling or using this product.

Important Notice: The above information is based on the latest stage of development and application technology. Due to a multiplicity of different influencing factors, this information – as well as other oral or written technical advises – must be considered as non-binding hints. The user is obliged in each particular case to conduct performance tests, including but not limited to trials of the product, in an inconspicuous area or fabrication of a sample piece.