

Technical Data Sheet

Page 1 of 2

- Properties:** AKEMI® Polyester Spray Filler is a 2-component spray filler based on unsaturated polyester resins dissolved in styrene.
- The product is characterized by the following qualities:
- extremely high filling properties and very good non-sag properties
 - fast hardening in case of higher temperatures (60°C, infrared)
 - easy sanding (dry and wet) and high abrasion
 - 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® Polyester Spray Filler is mainly used in body shops, commercial vehicle construction or in the engineering industry as well as in wood processing industry for levelling of small dents, furrows, scratches or grinding traces on large areas.
- Instructions for Use:**
1. The surface to be treated must be free of rust and dust, dry and slightly roughened. Uncured old paint or thermoplastic acrylic paint must be removed.
 2. Stir contents of the can well.
 3. Viscosity can be reduced by adding up to 5% of AKEMI® Thinner P.
 4. Add 2 to 4 g of Polyester Spray Filler hardener to 100 g of Polyester Spray Filler. The scale on the hardener tube corresponds to a hardener proportion of 3%.
 5. Both components are mixed well. The mixture can be worked for about 20 to 30 minutes.
 6. The mixture is applied with a spray gun (spray nozzle: 2 to 3 mm, spray gun pressure: 2 to 3 bar).
 7. Once hardened, the spray filler can be ground after 10 to 20 minutes (60°C) or after 2 to 3 hours (20°C).
 8. The hardening process is accelerated by heat and delayed by cold.
 9. The finished filler surface can be reworked with all commercially available fillers and paints.
 10. Tools can be cleaned with AKEMI® Universal Thinner.
- Special Notes:**
- For professional use only.
 - In case of metallic surfaces, fillers should be applied as soon as possible after sanding to avoid a reduction in adhesion.
 - Hardener portions higher than 4% reduce adhesion and deteriorate surface drying.
 - Hardener portions less than 2% delay hardening or low temperatures cause an incomplete hardening and the surface will remain tacky.
 - Before coating with a 2C acrylic paint, apply a primer or a „Non-Sanding Sealer to avoid blistering.
 - 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 not harmful to health.
 - For proper waste disposal the container must be completely emptied.
 - Recycling in accordance with the guidelines of EU Decision 97/129 EC on the Packaging Directive 94/62/EC.

TDS 07.25

Technical Data Sheet

Page 2 of 2

Technical Data:	Quantity to be applied:	approx. 150 µm of dry coat strength per criss-cross pattern
	Colour:	grey
	Density:	approx. 1.63 g/cm ³
	Viscosity:	3000 - 3500 mPas
	VOC contents:	< 540 g/l
	Working time / min.:	
	a) at 20°C	
	2% of hardener:	25 - 30
	3% of hardener:	20 - 25
	4% of hardener:	15 - 20
	b) with 3% of hardener	
	at 10°C:	30 - 40
	at 20°C:	20 - 25
	at 30°C:	8 - 10
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 trails of the product, in an inconspicuous area or fabrication of a sample piece.	

TDS 07.25