

## Technical Data Sheet

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- Properties:** AKEMI® Multi-Alu Filler is a 2-component filler based on unsaturated polyester resins dissolved in styrene.
- The product is characterized by the following properties:
- very good adhesion to metal (iron, steel, galvanized sheet metals even without grinding, aluminum), wood, stone and various plastics (e.g. unplasticized PVC, polyester) even at higher temperatures (up to approx. 100°C)
  - excellent drawing properties due to creamy consistency
  - high filling properties and rigidity
  - fast hardening (10 - 15 minutes)
  - easy to grind and high abrasion factor
  - resistant to water, petrol, mineral oils, diluted lye and acids
- Application Area:** AKEMI® Multi-Alu Filler is mainly used in paint shops, body shops, commercial vehicle construction or in mechanical engineering companies for levelling depressions or rough unevenness.
- 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 1 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 2 to 8 minutes.
  4. After 15 to 30 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-Thinner.
- Special Notes:**
- For professional use only.
  - 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.
  - 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 11.25

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**Technical Data:** Colour: metallic grey  
Density: approx. 1.76 g/cm<sup>3</sup>

Working time / min.:  
a) at 20°C  
1% of hardener: 8 - 10  
2% of hardener: 4 - 5  
3% of hardener: 3 - 4  
4% of hardener: 2 - 3

b) with 2% of hardener  
at 10°C: 9 - 12  
at 20°C: 4 - 5  
at 30°C: 2 - 3

**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.