

Technical Data Sheet

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- Properties:** AKEMI® Poly-Fibre Filler is a 2-component filler based on unsaturated polyester resins with glass fibers, dissolved in styrene.
- The product is characterized by the following qualities:
- good drawing properties due to smooth consistency
 - high filling and non-sag properties
 - repair of small holes (up to a diameter of 3 cm approx.) respectively strengthening of thin sheet metals
 - fast hardening (10 - 15 minutes)
 - easy sanding and high abrasion
 - very good adhesion on metal (iron, steel and 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® Poly Fibre Filler is mainly used in body shops, commercial vehicle construction or in the engineering industry for repairing small holes (up to a diameter of 3 cm approx.), or for strengthening of thin sheet metals. Additionally the product is used in model making or other hobbies.
- Instructions for Use:**
1. The surface to be treated must be free of rust and dust, dry and slightly roughened. Hole edges should be slightly dented inwards with a hammer. Uncured old paint or thermoplastic acrylic paint 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. For the treatment of holes, the specified mixture is applied on a polyethylene or polypropylene foil and pressed on the hole to be closed. Once hardened the foil can be removed.
 5. After 15 to 30 minutes the hardened filler can be worked (ground, drilled, milled). Bruises can be levelled with AKEMI® Body Filler No. 4 or Super Soft Filler.
 6. The hardening process is accelerated by heat and delayed by cold.
 7. The finished filler surface can be reworked with all commercially available fillers and paints.
 8. Tools can be cleaned with AKEMI® Nitro-Thinner.
- Special Notes:**
- For professional use only.
 - In case of metallic surfaces, fillers should be applied as soon as possible after sanding in order to avoid a reduction in adhesion.
 - Hardener portions higher than 4% reduce adhesion and deteriorate surface drying.
 - Hardener portions less than 1% 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.
 - If the product is to be applied in thicker layers work with as little hardener as possible or in several layers
 - Once hardened, the filler can no longer be removed by solvents. Removal is only possible mechanically or by higher temperatures (> 200°C).

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- 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.

Technical Data:

Colour: olive green
Density: approx. 1.99 g/cm³
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 - 11
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.