Technical Instruction Sheet

Characteristics: AKEMI AKS System Filler is a several-component stone filler based on unsaturated polyester resins dissolved in styrene. Special about this product is the 1 : 1 mixing ratio of component I and component II, which therefore ensures a secure processing. The special liquid hardener is mixed with the component I. This mixture (comp. I and hardener) is several days stable depending on the temperature; through mixing component I and component II in equal parts of weight quick hardening takes place. Furthermore, the product is distinguished by the following qualities:

- easy, also mechanical processing possible through 1 : 1 dosing
- different viscosity setting depending on different problems
- very rapid hardening also in thin layers (10-15 minutes), by means of heat hardening time can be reduced to 5-10 minutes
- rapid surface drying
- easy to grind and polish
- very good adhesion on dry natural stones

Field of Application: AKEMI AKS System Filler is mainly used for working natural stone slabs in polishing line plants for filling holes and fissures. The product hardens very well in thin layers and at low temperatures due to its high reactivity. A good surface drying is reached already after a short period of time, thus polishing segments do not smear or clog.

Instructions for Use:

1. The surface to be treated must be clean, dry and free from dust.
2. Add 6% special liquid hardener to component I and mix thoroughly; this mixture is at least 3 days at approx. 20°C storable.
3. The mixture of component I (incl. hardener) and component II are mixed at a ratio of 1 : 1 according to weight; the mixture remains workable approx. 1 – 5 minutes (20°C).
4. After 10 to 15 minutes (20°C) treated slabs can be grind and polished.
5. The hardening process is accelerated by heat and delayed by cold.
6. Tools can be cleaned with AKEMI Nitro-Dilution.

Special Hints:

- For economical working the dosing apparatus DSK II or the Automatic Filling Machine SPK or SPG are recommended.
- Use AKEMI Liquid Glove to protect your hands.
- Poor adhesion on humid surfaces. Moderate adhesion on fresh, alkaline building material (e.g. concrete bricks).
- 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.

Safety Measures: see EC Safety Data Sheet

Technical Data:

Colour:	Component I:	light ivory
	Component II:	different colours
Density:	Component I:	1,90 – 2,00 g/cm³
	Component II:	1,60 – 1,70 g/cm³

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Working time in seconds; addition of hardener in component I, mixing of component I and II at 1:1 according to weight:

a) at 20°C

2% of hardener:	180 - 240
4% of hardener:	150 - 180
6% of hardener:	120 - 150
8% of hardener:	90 - 120

b) with 6% of hardener

at 10°C:	240	-	300
at 20°C:	120	-	150
at 30°C:	60	-	75

Storage of component I mixed with 6% special liquid gardener:

at 40°C:	8	-	12 hours
at 30°C:	1	-	2 days
at 20°C:	5	-	7 days
at 10°C:	15	-	20 days

Shelf life: 1 year approx. if stored in cool place free from frost in its tightly closed original container.

Notice: The above information is based on the latest stage of technical progress. It is to be considered as a non-binding hint and does not release the user from a performance test, since application, processing and environmental influences are beyond our realm of control.

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