Technical Instruction Sheet

Properties:

AKEMI® Poly Glass Filler is a 2-component filler based on unsaturated polyester resins with glass fibres, dissolved in styrene. The product is distinguished by the following qualities:

- good drawing properties due to supple consistency
- high filling and non-sag properties
- repair of small holes (up to a diameter of 3 cm approx.) and cracks in glass-fibre reinforced plastic parts, respectively high bonding properties on glass-fibre reinforced plastic parts
- fast hardening (10-15 minutes)
- facile grindability and high abrasive properties
- very good adhesion on metal (iron, steel and aluminium), wood, stone and various plastics (e.g. rigid PVC, polyester), also in case of higher temperatures (up to 100°C)
- flame retardant due to its special filling agents
- resistant to water, petrol, mineral oils, diluted lye and acids.

Field of Application:

AKEMI® Poly Glass Filler is mainly used in the production, processing and repair of glass-fibre reinforced plastic parts (caravans, tanks, boats) for repairing of holes and cracks, as well as for strengthening and bonding.

Instructions for Use:

1. The surface to be treated must be rustproof, dry, dust-free and slightly roughened. All prior coats both unhardened lacquers and thermoplastic acrylic enamels 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 6 minutes.
4. The required mixture is applied on a polyethylene or polypropylene foil and pressed on the hole which is 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).
6. The hardening process is accelerated by heat and delayed by cold.
7. The filled surface can be worked over with all fillers and lacquers which are commercially available.
8. Tools can be cleaned with AKEMI® Nitro-Dilution.

Special Hints:

- 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; low temperatures may completely avoid the hardening process, in this instance the surface will remain tacky.
- Apply a primer or a „Non-Sanding Sealer“ prior to coating with a 2-component enamel to avoid blistering.
- When the product is to be applied in thicker layers we recommend to use as little hardener as possible.
- 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.

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Safety Measures: see EC Safety Data Sheet

Technical Data:

Colour:	light yellow
Density:	1.66 g/cm³

Working time / min.:

a) at 20°C

1% of hardener:	9 - 11
2% of hardener:	5 - 6
3% of hardener:	4 - 5
4% of hardener:	3 - 4

b) with 2% of hardener

at 10°C:	8 - 11
at 20°C:	5 - 6
at 30°C:	2 - 3

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 our 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.

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