

Technical Instruction Sheet

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Characteristics:

AKEMI® Poly Fibre 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.), respectively strengthening of thin sheet metals
- fast hardening (10-15 minutes)
- facile grindability and high abrasive properties
- very good adhesion on metal (iron, steel and aluminium), wood, stone and various synthetic materials (e.g. rigid PVC, polyester) also in case of higher temperatures (up to 100°C).
- resistant to water, petrol, mineral oils, diluted lyes and acids.

Field of Application:

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 derusted, degreased, dry, dustless and slightly roughened. Edges of holes should be dent inside with a hammer. All prior coats both unhardened lacquers and thermoplastic acrylic varnishes 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. For the treatment of holes, the specified 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). Bruises can be levelled with AKEMI Autobody Filler No.4 or Filler Super Soft.
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 a 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 acrylic lacquer to avoid blistering.
- When the product is to be applied in thicker layers we recommend to use as little hardener as possible or rather be worked 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).
- Being worked properly, the hardened filler is generally recognised as not injurious to health.

Safety Measures: see EC Safety Data Sheet

Technical Data: Colour: olive green
Density: approx. 1.85 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

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 trials of the product, in an inconspicuous area or fabrication of a sample piece.