Polyester Spray Filler 60 minutes

Technical Instruction Sheet

Characteristics:

AKEMI® Polyester Spray Filler 60 minutes is a 2 component spray filler based on unsaturated polyester resins dissolved in styrene. The product is distinguished by the following qualities:

- extremely high filling properties and very good non-sag properties
- fast hardening in case of higher temperatures (60°C, infrared)
- facile grindability (dry and wet) and high abrasive properties
- very good adhesion on metal (iron, steel, 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:

AKEMI® Polyester Spray Filler 60 minutes is mainly used in body shops, commercial vehicle construction or in the engineering industry as well as in wood processing industry for levelling of small dents, furrows, scratches or grinding traces on large areas.

Instructions for Use:

1. The surface to be treated must be derusted, degreased, dry, dustless and slightly roughened. All prior coats both unhardened lacquers and thermoplastic acrylic varnish must be removed.
2. Stir contents of the can well.
3. Add 2 to 4 g of Polyester Spray Filler hardener to 100 g of Polyester Spray Filler. The scale on the hardener tube corresponds to a hardener proportion of 3 %.
4. Viscosity can be reduced by adding up to 5 % of AKEMI Dilution P.
5. Both components are mixed well. The mixture can be worked for about 60 to 75 minutes.
6. The mixture is applied with a spray gun (spray nozzle: 1.5 to 3 mm, spray gun pressure: 2,5 to 3 bar).
7. Once hardened, the spray filler can be grind after 20 to 40 minutes (60°C), or grind after 4 to 5 hours (20°C).
8. The hardening process is accelerated by heat and delayed by cold.
9. The filled surface can be worked over with all fillers and lacquers which are commercially available.
10. Tools can be cleaned with AKEMI Universal-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 2 % delay hardening; in the event of low temperatures the surface will remain tacky.

- Apply a primer or a „Non-Sanding Sealer“ prior to coating with a 2K acrylic lacquer to avoid blistering.
- 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:

Quantity to be applied:	approx. 150 µm of dry coat strength per criss-cross pattern
Colour:	light green
Density:	approx. 1.62 g/cm³
Viscosity:	3000-3500 mPas
VOC-Content:	< 540 g/l

Working time / min.:

a) at 20°C

2% of hardener:	90 - 120
3% of hardener:	60 - 75
4% of hardener:	40 - 60

b) with 3% of hardener

at 10°C:	90 - 120
at 20°C:	60 - 75
at 30°C:	30 - 40

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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