Technical Data Sheet

Properties:

AKEMI® Marble Filler 1000 Thixo is a paste-like 2-component product based on unsaturated polyester resins dissolved in styrene, containing mineral filling agents.

The product is characterized by the following properties:
- excellent working properties due to creamy-soft consistency, especially on vertical surfaces
- excellent and fast surface drying
- fast hardening (15 - 30 minutes)
- good working properties (grinding, milling, drilling)
- excellent polishing properties
- very good adhesion on natural stone also at higher temperatures (70 - 80°C; in case of low exposure to strain 100 - 110°C)
- resistant to water, petrol and mineral oils

Application Area:

AKEMI® Marble Filler 1000 Thixo is mainly used in the stone processing industry for filling and bonding of natural and artificial stone. Stirring or spreading gives the product a creamy-soft consistency, making it easy to fill even larger horizontal and especially vertical surfaces. Fast surface drying enables further problem-free processing.

Instructions for Use:

1. The surface must be clean, completely dry and roughened.
2. Colouring is possible by adding AKEMI® Polyester Colouring Pastes or AKEMI® Polyester Colouring Concentrates up to max. 5%. Dilution is possible in any ratio by adding AKEMI® Marble Filler Transparent extra liquid.
3. Add 1 to 4 g of white hardener paste to 100 g of filler (4 to 5 cm of paste pressed out of the screw tube correspond to 1 g).
4. Both components are mixed completely; the mixture can be worked for approx. 3 - 10 minutes (20°C).
5. After 10 - 20 minutes the treated parts can be further processed (grinding, polishing, milling) respectively transported.
6. The hardening process is accelerated by heat and delayed by cold.
7. Tools can be cleaned with AKEMI® Nitro-Dilution.

Special Notes:

- For professional use only.
- Use afin® Liquid Glove to protect your hands.
- Hardener portions higher than 4% reduce adhesion and deteriorate surface drying.
- Hardener portions less than 1% and low temperatures (below 5°C) considerably delay hardening.
- The bonding layers should be as thin as possible (< 2 mm) due to shrinkage (approx. 2 - 3%) caused by the high reactivity of the filler and development of heat during the hardening process.
- When filling larger holes or modelling corners and edges, use as little hardener as possible.
- Non-durable resistance of bondings which are frequently exposed to humidity and frost.
- Only moderate adhesion on fresh, alkaline building materials (e.g. concrete, concrete ashlar).
- The hardened filler tends to yellowing.
- 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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Technical Data Sheet

- Being worked properly, the hardened filler is generally not hazardous 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:

Colours:	paglierino dark, jura-yellow, jura-light, white, black, structure travertine light, structure jura light-brown
Density:	1.70 - 1.75 g/cm³

Working time/minutes:

a) at 20°C

1% of hardener:	8 - 10
2% of hardener:	5 - 6
3% of hardener:	4 - 5
4% of hardener:	3 - 4

b) with 2% of hardener

at 10°C:	10 - 12
at 20°C:	5 - 6
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 trails of the product, in an inconspicuous area or fabrication of a sample piece.

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