

Technical Data Sheet

- Properties:** AKEMI® Marble Fillers 1000 Thixo are paste-like 2-component products based on unsaturated polyester resins dissolved in styrene containing mineral filling agents. The products are distinguished by the following qualities:
- good 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)
 - excellently polishable
 - very good adhesion on natural stones 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 Fillers 1000 Thixo are mainly used in the stone processing industry for filling and bonding natural and artificial stones. The products become soft and creamy when stirred and spread, thus making it very easy to fill larger areas on horizontal and especially vertical surfaces. Fast surface drying enables further processing without any problems.
- Instructions for Use:**
1. The surface to be treated 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 1000 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. Mix both components thoroughly. The mixture can be worked for about 3 to 10 minutes (20°C).
 5. After 10 to 20 minutes the treated parts can be further processed (grinding, milling, drilling).
 6. The hardening process is accelerated by heat and delayed by cold.
 7. Tools can be cleaned with AKEMI® Nitro-Dilution.
- Special Notes:**
- Use AKEMI® 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 bigger 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 bricks).
 - 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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- Being worked properly, the hardened filler is generally recognized as not injurious to health.

Technical Data:

Colour: white, black, paglierino light, paglierino dark, paglierino extra dark, jura-yellow, jura-light, structure Travertine light, structure Jura light brown, structure Impala dark grey

Density: 1.70 – 1.75 g/cm³

Working time (min.):

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:

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

Health & Safety:

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

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