

Technical Data Sheet

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Properties: AKEMI® Marble Fillers 1000 S/T/G 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 also on vertical surfaces due to paste-like consistency
- 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 S/T/G are mainly used in stone processing industry for filling natural stones. Due to their paste-like consistency it is possible to model corners and edges, fill bigger holes without sagging, fix slabs and window sills and to bond vertical surfaces. Special attention is laid on the product S-Neutral which does not contain any colour pigments and can thus easily be coloured to any shade required by adding AKEMI Polyester Colouring Pastes or Colouring Concentrates.

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 has a low tendency to yellowing.

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- 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.

Technical Data:

Colour: 1000 S: jura-light, neutral, white, black
1000 T: olive
1000 G: beige-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

Mechanical Properties:

Tensile strength DIN 53455: 20 – 30 N/mm²Bending strength DIN 53454: 150 – 160 N/mm²**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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