

Technical Data Sheet

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- Properties:** AKEMI® Poly-Soft 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:
- very good working properties due to creamy-soft consistency, especially on vertical surfaces
 - fast hardening (20 to 60 minutes)
 - good working properties (grinding, milling, drilling)
 - good 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
 - emission class A+ (confirmed by an external testing institute)
- Application Area:** AKEMI® Poly-Soft is mainly used in the stone processing industry for filling and bonding natural and artificial stone. Due to its creamy-soft consistency the product is suited to fill larger areas, especially on vertical surfaces.
- 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 up to max. 5%. Dilution is possible in any ratio by adding AKEMI® Poly-Liquid transparent.
 3. Add 1 to 4 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 completely mixed, the mixture can be worked for approx. 3 to 20 minutes (20°C).
 5. After 20 to 60 minutes the treated parts can be further processed and transported.
 6. The hardening process is accelerated by heat and delayed by cold.
 7. Tools can be cleaner with AKEMI® Nitro Dilution.
- Special Notes:**
- For professional use only.
 - Hardener portions higher than 4% reduce the adhesion and deteriorate surface drying.
 - Hardener portions less than 1% and low temperatures (< 5°C) considerably delay hardening.
 - The bonding layers should be as thin as possible (< 2 mm) due to shrinkage (2 - 8%) 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.
 - Only limited durability of bondings which are frequently exposed to humidity and frost.
 - Only moderate adhesion on fresh, alkaline building material (e.g. concrete, concrete bricks).
 - The hardened filler has a slight tendency to yellowing.
 - Once hardened, solvents can no longer remove the filler. Removal is only possible mechanically or by higher temperatures (> 200°C).
 - Recycling in accordance with the guidelines of EU Decision 97/129 EC on the Packaging Directive 94/62/EC.

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Technical Data: Colours: white, black, paglierino light, paglierino dark, paglierino extra dark, paglierino yellow, transparent

Density: 1.75 - 1.85 g/cm³ (coloured)
1.10 - 1.15 g/cm³ (transparent)

Working time / min.:

a) At 20°C	<u>coloured</u>	<u>transparent</u>
1% of hardener	8 - 10	16 - 20
2% of hardener	6 - 7	10 - 12
3% of hardener	4 - 5	8 - 10
4% of hardener	3 - 4	6 - 8

b) With 2% of hardener		
At 10°C	10 - 12	20 - 25
At 20°C	6 - 7	10 - 12
At 30°C	3 - 4	5 - 6

Storage: If stored in dry and cool condition (5 - 25°C) 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 trials of the product, in an inconspicuous area or fabrication of a sample piece.

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