

Technical Instruction Sheet

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Characteristics: AKEMI® Marble Filler Super is a highly liquid 2-component product based on acrylic resins containing methyl methacrylate. The product is distinguished by the following qualities:

- good penetration into porous areas and fissure due to fast wetting and highly liquid consistency
- fast and tack-free hardening (20 - 60 minutes)
- excellently polishable
- very good adhesion on natural and cast stones resp. on alkaline building materials (s. a. concrete, concrete bricks)
- resistant to water, petrol, mineral oils, diluted lye and acids.

Field of Application: Marble Filler Super is mainly used in stone processing and building industry for filling fissures, porous natural stone slabs and forming of rock substitutes with crushed rocks and sand, distinguished by a quite good resistance to light.

- Instructions for Use:**
1. The surface to be treated must be clean, completely dry and slightly roughened.
 2. Colouring is possible by adding AKEMI® Polyester Colouring Pastes up to max 5 %. Dilution is possible by adding Dilution S up to max 8 %.
 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 4 to 16 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 cleaned with AKEMI® Nitro-Dilution.

- Special Hints:**
- Use AKEMI® Liquid Glove to protect your hands.
 - Hardener portions higher than 4 % reduce adhesion and cause yellowing.
 - Hardener portions less than 1 % and low temperatures (under 5°C) considerably delay hardening.
 - The bonding layers should be as thin as possible (< 1 mm) due to shrinkage (approx. 5-8 %) caused by the high reactivity of the filler and development of heat during the hardening process.
 - Limited durability of bondings which are frequently exposed to humidity and frost.
 - The hardened filler has a slight tendency to yellowing.
 - 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.

Safety Measures: see EC Safety Data Sheet

Technical Data: Colour: colourless transparent
Density: 1.00 - 1.05 g/cm³

Working time / min.:

a) at 20°C

- 1% of hardener: 14 - 16
- 2% of hardener: 5 - 11
- 3% of hardener: 6 - 8
- 4% of hardener: 4 - 6

b) with 2% of hardener

at 10°C:	18 - 20
at 20°C:	9 - 11
at 30°C:	4 - 5

Mechanical Properties:

Tensile strength DIN 53455:	45 - 55 N/mm ²
Bending strength DIN 53452:	80 - 90 N/mm ²

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