

Technical Instruction Sheet

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Characteristics:

AKEMI® Poly-Soft is a paste-like 2-component product based on unsaturated polyester resins dissolved in styrene, containing mineral filling agents. The products are distinguished by the following qualities:

- good working properties creamy-soft consistency, especially on vertical surfaces
- fast hardening (20 - 60 minutes)
- good working properties (grinding, milling, drilling)
- good polishing properties
- very good adhesion on natural stones also at higher temperatures (70 - 80°C / 158 – 176°F; in case of low exposure to strain: 100 - 110°C / 212 – 230°F)
- resistant to water, petrol and mineral oils.

Field of application:

AKEMI® Poly-Soft is mainly used in stone processing industry for filling and bonding natural and artificial stones. 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 slightly roughened.
2. Colouring is possible by adding AKEMI® Polyester Colouring Pastes up to max 5 %. Dilution is possible in any ratio by adding Poly-Liquid transparent.
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 - 20 minutes (20°C/68°F).
5. After 20 - 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 deteriorate surface drying.
- Hardener portions less than 1 % and low temperatures (under 5°C/41°F) considerably delay hardening.
- The bonding layers should be as thin as possible (< 2 mm) due to shrinkage (approx. 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.
- Limited durability of bonding which is frequently exposed to humidity and frost.
- Moderate adhesion on fresh, alkaline building materials (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/392°F).
- Being worked properly, the hardened filler is generally recognized as not injurious to health.

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Safety Measures: see EC Safety Data Sheet

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

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

Working time/min:

a) at 20°C / 68°F	(coloured)	(transparent)
1 % hardener	8 - 10	16 - 20
2 % hardener	6 - 7	10 - 12
3 % hardener	4 - 5	8 - 10
4 % hardener	3 - 4	6 - 8

b) with 2 % hardener		
at 10°C / 50°F	10 - 12	20 - 25
at 20°C / 68°F	5 - 6	10 - 12
at 30°C / 86°F	2 - 3	5 - 6

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

Notice: The above specifications were made in accordance with the present-day stage in development and the application technology research of our firm. Because the ways and means of application are beyond our control, the manufacturer cannot be made liable for the contents of this specification sheet.