

## Technical Data Sheet

Page 1 of 2

**Properties:**

AKEMI® Alu Metal Filler is a two-component filler on the basis of unsaturated polyester resins dissolved in styrene. It is distinguished by the following properties:

- very good adhesion to metal (iron, steel, aluminum), wood, stone and various plastics (e.g. unplasticized PVC, polyester) even at higher temperatures (up to approx. 100°C)
- high filling properties and rigidity; a layer thickness up to 5 mm on large areas respectively up to 10 mm on small areas is possible in one single working process
- easy to spread on account of its creamy consistency
- fast hardening (10 - 15 minutes)
- easy to grind and high abrasion factor
- resistant to water, petrol, mineral oils, diluted lye and acids

**Application Area:**

AKEMI® Alu Metal Filler is mainly used in bodymaking, in the construction of commercial road vehicles or in the machine construction industry to fill in uneven surfaces or to equalize larger surface irregularities. In addition, it is also used in many hobby sectors and for bonding parts made of the above materials which are not exposed to particularly high mechanical wear and tear.

**Instructions for Use:**

1. The surface to be treated must be free of rust and dust, dry and slightly roughened. All prior coats not hardened and thermoplastic acrylic lacquers must be removed.
2. Add 1 to 4 g of red hardener paste to 100 g of filler (4 to 5 cm of paste pressed out of the screw tube correspond to 1 g).
3. Both components are mixed until a homogeneous shade of colour is achieved. The mixture can be worked for about 2 to 8 minutes.
4. After 15 to 30 minutes the hardened filler can be worked (ground, drilled, milled)
5. The hardening process is accelerated by heat and delayed by cold.
6. The filled surface can be worked over with all fillers and lacquers which are commercially available.
7. Tools can be cleaned with AKEMI® Nitro-Dilution.

**Special Notes:**

- Use AKEMI® »Liquid Glove« to protect your hands.
- Apply filler in a short interval after grinding of metal surface to guarantee good adhesion.
- Hardener portions higher than 4 % reduce adhesion and deteriorate surface drying.
- Hardener portions less than 1 % delay hardening or low temperatures cause an incompletely hardening and the surface will remain tacky.
- Before coating with a 2-component lacquer apply a primer or a „Non-Sanding Sealer to avoid blistering.
- When the product is to be applied in thicker layers we recommend to use as little hardener as possible or apply several layers
- 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.

TDS 10.19

**Technical Data Sheet**

Page 2 of 2

**Technical Data:** Colour: metallic grey  
Density: approx. 1.72 g/cm<sup>3</sup>

Working time / min.:

a) at 20°C

1% of hardener: 8 - 10

2% of hardener: 4 - 5

3% of hardener: 3 - 4

4% of hardener: 2 - 3

b) with 2% of hardener

at 10°C: 9 - 11

at 20°C: 4 - 5

at 30°C: 2 - 3

**Storage:** If stored in dry and cool condition (5-25°C/41-77°F) 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.