Technical Data Sheet

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 distinguished by the following qualities:

- very good working properties due to 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

Application Area:

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 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 Thinner.

Special Notes:

- Hardener portions higher than 4 % reduce adhesion and deteriorate surface drying.
- Hardener portions less than 1 % and low temperatures (below 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).

Technical Data:

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

AKEMI GmbH · Lechstraße 28 · 90451 Nürnberg · Germany
Tel. +49(0)911-64296-0 · Fax +49(0)911-644456 · www.akemi.com

Technical Data Sheet

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	6 – 7	10 - 12
at 30°C / 86°F	3 – 4	5 – 6

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

AKEMI GmbH · Lechstraße 28 · 90451 Nürnberg · Germany
Tel. +49(0)911-64296-0 · Fax +49(0)911-644456 · www.akemi.com