

Technical Data Sheet**Properties:**

AKEMI® Marble Filler 1000 Transparent Waterclear and Transparent Waterclear L-Special are highly liquid or gel-like 2-component products based on UV-stabilized, unsaturated polyester resins dissolved in styrene.

The products are characterized by the following qualities:

- wide field of application due to different consistencies
- no inherent colour, therefore suited for light, mainly transparent-crystalline natural stone
- due to slow hardening and low tensions bigger defects, corners and edges can be filled
- easily polishable
- very good adhesion on natural stone
- resistant to water, petrol and mineral oils

Application Area:

AKEMI® Marble Fillers Waterclear are mainly used in the stone processing industry for filling and bonding light or white, transparent-crystalline natural stone s.a. Thassos, Carrara, Onyx, Palisandro, Estremoz or the like. Due to the liquid, colourless-transparent appearance waterclear bondings can be made which maintain the stereoscopic structure of the stone. By adding little quantities of AKEMI® Polyester Colouring Pastes, Colouring Concentrates liquid or Spectrum Pastes to AKEMI® Marble Filler Transparent Waterclear L-Special, corners and edges can be modelled or bigger holes can be filled. Thus, an appearance very similar to the stone or bonding joints which are almost invisible can be achieved. When working with crystalline natural stone we recommend mixing some crushed granular material in the filler to imitate the crystal structure of the stone.

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, Colouring Concentrates liquid or Spectrum Pastes up to max 5%. Dilution is possible by adding Thinner S up to 8%.
3. Add 1 to 2 g of hardener B liquid (25 - 50 drops) to 100 g of filler.
4. Mix both components thoroughly. The mixture can be worked for approx. 12 - 24 minutes (20°C).
5. After approx. 6 - 8 hours the treated parts can be exposed to strain, after 12 hours approx. they can be further processed (grinding, milling, drilling).
6. The hardening process is accelerated by heat and delayed by cold.
7. Tools can be cleaned with AKEMI® Nitro-Thinner.

Special Notes:

- For professional use only.
- Use afin® Liquid Glove to protect your hands.
- The products only harden with Hardener B Liquid.
- Hardener portions higher than 2% cause more or less intensive discolouring. Hardener portions less than 1% and low temperatures considerably delay hardening.
- Permanent influence of heat (> 50°C) causes discolouring and reduces the bonding properties.
- Non-durable resistance of bondings which are frequently exposed to humidity and frost.
- Only moderate adhesion on fresh, alkaline building materials (e.g. concrete, concrete bricks).

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- Once hardened, the filler can no longer be removed by solvents. Removal is only possible mechanically or by higher temperatures (> 200°C).
- For proper waste disposal the container must be completely emptied.
- Recycling in accordance with the guidelines of EU Decision 97/129 EC on the Packaging Directive 94/62/EC.

Technical Data:

Colour: colourless transparent (Waterclear)
colourless milky-turbid (Waterclear L-Sp.)

Density: 1.12 - 1.18 g/cm³

Working time (min.):

a) at 20°C

1 % of hardener B:	20 - 24
1.5 % of hardener B:	16 - 20
2 % of hardener B:	12 - 16

b) with 1.5 % of hardener:

at 10°C:	35 - 40
at 20°C:	16 - 20
at 30°C:	7 - 10

Mechanical Properties:

Tensile strength DIN EN ISO 527:	50 N/mm ²
Bending strength DIN EN ISO 178:	80 N/mm ²

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.

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