

**Technical Instruction Sheet**

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**Characteristics:**

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

- good adhesion to virtually all plastics parts which are common in the automobile industry, to galvanized sheet iron (even without previous abrading) as well as to many other surfaces such as iron, steel, pure aluminium, aluminium alloys, copper, wood and even at higher temperatures
- high elasticity and therefore suitable for parts exposed to vibration
- very good spreading properties on account of its creamy consistency
- 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
- minor scratches and surface irregularities can be levelled off on account of its particularly fine structure
- fast hardening (15-30 minutes)
- easy to grind and high abrasion factor
- resistant to water, petrol, mineral oils, diluted lye and acids.

**Areas of Application:**

AKEMI® Contour Filler for Plastic is suitable for use in body working and in commercial vehicle construction to level off uneven surfaces or scratches.

AKEMI® Contour Filler for Plastics is used, above all, to repair plastic parts, but can also be used on other surfaces such as galvanized sheet iron, iron, steel and aluminium. In addition, it is also used in a wide variety of hobby sectors.

**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 Hints:**

- 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.
- 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 recognised as not injurious to health.

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**Safety Measures:** see EC Safety Data Sheet**Technical Data:** Colour: dark grey  
Density: approx. 1.95 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

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.