

Technical Instruction Sheet

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Characteristics:

AKEMI® Marble Silicone is a single-component, joint sealing material on the basis of silicone rubber which hardens in contact with atmospheric moisture. This product has the following particular properties:

- it does not discolour at the edges
- has excellent working and smoothing properties
- has a fungicidal property
- effectively tolerates expansion/contraction up to 25%
- builds a skin within 10 – 15 minutes
- stable at temperatures between –40°C - +150°C
- is extremely weather-resistant
- has a high resistance against abrasion, tearing and notching
- is compatible with paint
- can be supplied in all colours
- can be stored for 12 months under cool and dry conditions
- chlorine-resistant in the disinfectant concentration for swimming pools as well as stress-resistant against mechanical cleaning methods

Field of Application:

AKEMI® Marble Silicone is a special sealing material for expansion and connecting joint and can be used in combination with natural and artificial stone such as marble, granite, quartzite, sandstone, terrazzo (Venetian mosaic), concrete and the like. In addition this product adheres very well to plaster, ceramic, glass, wood and to many kinds of metal and plastic. AKEMI® Marble Silicone (with the exception of structure-effect colours) is also suited for underwater areas and those exposed to permanent humidity in swimming pools, sauna, public showers and changing rooms as well as pressure vessel construction.

Instructions for Use:

1. Contract surfaces must be dry and clean and free of fat and dust; natural and artificial stone, ceramic, glass, non-painted wood and metal can be cleaned with Cleaner A; Cleaner I is to be used on plastic and enamelled surfaces.
2. In order to prevent adhesion on three flanks and in the event of deeper joints AKEMI® joint cords should be used; closed-cell polyethylene (PE) joint tapes for wet/moist rooms (bathrooms, saunas etc.), for outdoors and areas exposed to permanent humidity, otherwise open-cell polyurethane (PUR) joint cords. Joint size: 3x5mm at the least.
3. Areas flanking the joint should be protected with AKEMI® special adhesive masking tape.
4. In wet/moist rooms and areas exposed to permanent humidity, outdoors and by particular surfaces (see primer table) we recommend the application of our primers on the flanks of the joints.
5. Working temperature –10°C - +40°C.
6. After application the silicone must be smoothed within 10 – 15 minutes. The best results are achieved with AKEMI® smoothing agent.
7. The hardening process, which is dependent upon the thickness of the layer, the temperature and the relative atmospheric humidity, takes for 1-3 mm 24 hours.
8. Tools can be cleaned with AKEMI® Cleaner A.

Special Hints:

- In order to protect the hands use AKEMI® 'liquid glove'.
- Keep out of the reach of children. Avoid contact with the eyes and the skin. In the event of contact rinse thoroughly with water and, if necessary, visit your doctor. Only use in well-ventilated areas or employ an air extractor. During application/vulcanisation a transient irritant is set free. If this inhaled in high concentrations, damage to health cannot be excluded.
- Discoloration occurs if the surfaces beneath are coated with tar or bitumen, the sample applies for elastomers such as EPDM, APTC or neoprene.

- Test the compatibility with the sealant prior to using the product on coated surfaces (e.g. paints, lacquer coats).
- In order to prevent stains the primer should not come into contact with surfaces in the field of vision.
- Excess smoothing agent must be removed in order to avoid staining.
- The silicone does not adhere or adheres poorly to plastics containing softening agents, to polyethylene (PE), polypropylene (PP) and polytetrafluoroethylene (teflon).
- Sealing materials with fungicide additives are not to be used in the construction of aquariums.
- Hardened sealing can only be removed mechanically. Sealing material which is still soft can be removed with Cleaner A or I – depending on the surface beneath.
- The hardened sealing presents no danger to health.

Attention swimming pool operation:

The formation of mildew can be highly reduced by means of disinfecting with chlorine, whereas the water composition in swimming pools should have a free chlorine fraction of 0.3 up to 0.6 mg/litre, in jacuzzis 0.7 up to 1.0 mg/litre, however, max. up to 1.2 mg/litre. Attention should be paid to a regular, uninterrupted water circulation with constant flooding of the edge of the pool, because otherwise the minimum concentration of chlorine of below 0.3 mg/litre can enhance the formation of mildew. This also happens when using acid cleaners. Please confer concerning the optimum ph-value of the water of swimming pools.

Technical Data:

| | |
|---|---|
| System: | oxime interlaced |
| Consistency: | soft, paste-like and stable |
| Density (DIN 53479-B) at 23°C: | approx. 1.02 g/cm ³ |
| Shore A hardness (DIN 53505): | approx. 30-35 |
| Effective tolerance of expansion/ contraction: | 25% |
| Working temperature: | -10°C - +40°C |
| Stable at temperatures from: | -40°C - +150°C |
| Time to build up skin at 23°C and 50% relative atmospheric humidity: | approx. 10 – 15 minutes |
| Hardening time at 23°C and 50% relative atmospheric humidity: | approx. 1-3mm per 24 hours |
| Modulus of elasticity: | 0.6N/mm ² |
| Tensile strength (DIN 53504): | 150%-200% |
| Storage: | Can be stored for 12 months under cool and dry conditions in the original sealed container. |

| Quantities required: | joint breadth | joint depth | m. per cartridge |
|----------------------|---------------|-------------|------------------|
| | 5mm | 5mm | 12 |
| | 10mm | 10mm | 3 |
| | 15mm | 10mm | 2 |
| | 20mm | 15mm | 1 |

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Primer table:

| | | | | | |
|----------------------------|----|------|---------------------------|----|------|
| sandstone | *1 | AP10 | copper | *3 | + |
| limestone | *2 | + | brass | *3 | + |
| marble | *2 | + | stainless steel | *6 | + |
| granite | *2 | + | zinc | | AP20 |
| quartzite | *2 | + | galvanised steel | | + |
| concrete | *5 | AP10 | aluminium | *6 | + |
| plaster | | AP10 | eloxadised aluminium | | AP20 |
| brick | | AP10 | hard PVC | | AP30 |
| fibrated concrete | | AP10 | polyester | | + |
| plaster of Paris | | AP10 | acrylic bathroom fittings | | + |
| ceramic, glazed/unglazed*5 | + | | polyacrylates | *4 | + |
| glass | | + | polycarbonates | *4 | + |
| untreated wood | | + | formic | | AP30 |
| varnished/painted wood*7 | | + | ABS | | + |

+ adheres well

*1 coat thinly with Primer AP10 twice

*2 in the event of application in wet/moist rooms or outdoors use Primer AP10

*3 prepare the surface with a fine sand or emery paper

*4 the sealing material may cause plastics under surface tension to break; test beforehand!

*5 in the event of application in underwater areas use Primer AP 70

*6 in the event of application in underwater areas use Primer AP 20

*7 test the compatibility of the coating/lacquer with the sealant prior to using the product

Notice:

These specifications were made in accordance with the up-to-date stage in development and application technology research of our firm. Because the ways and means of application are outside our control the manufacturer cannot be held liable for the contents of this instruction sheet.

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