

MOBIHEL[®]

... for the cars we love

2K HS 4:1 COMPACTPRIMER LOW VOC

- High-build, acryl-isocyanate primer-filler,
- VOC compliant
- Adhesion on all types of metals substrates.
- Excellent (up to 180 µm) film-build
- Good vertical stability, filling properties
- Good isolating properties
- Easy to sand
- In-depth drying properties allow for a reduced process time and ensure an excellent surface for the subsequent top coats.



PACKING DATA

Packing: 6 x 1.0 l	Index: 41793802 – grey 41958002 – white 41958112 - black 41793833 – grey 41958033 – white 41958133 - black
3 x 3.5 l	

ASSOCIATED PRODUCTS

MOBIHEL 2K HARDENER 700

Packing: 6 x 0.25 l 6 x 1.0 l 4 x 5.0 l	Index: 41825601 41825612 41825614
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MOBIHEL 2K HARDENER 750 W

Packing: 6 x 0.25 l 6 x 1.0 l	Index: 47769311 47769302
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MOBIHEL 2K THINNER 2100

Packing: 12 x 0.5 l 4 x 5.0 l	Index: 41672151 41672114
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HYGIENE & PERSONAL PROTECTION



TECHNICAL CHARACTERISTICS

Colour:	White, black and grey – Possibility of mixing on the mixing unit
Product type:	Acrylic resins
Density:	1,486 – 1,589 g/ml



2004/42/II B(c) (540) 530
EU limit value VOC for this type of products (category II B (c)) in the form, which is ready for application is 540 g/l VOC of this product, prepared for use is 530 g/l.



2K materials react with humidity; take care that all containers and tools are absolutely dry.
While coating, the interior relative humidity should not exceed 80%.

SUBSTRATE

Steel sheet metal
Aluminium
Zink plated steel
Other polyester putties
2K fillers

NOTE:

In cases of unknown aluminium quality, we recommend the application of one layer of MOBIHEL PRIMER LOW VOC for guaranteed results.

SUBSTRATE PREPARATION

All substrates must be thoroughly sanded and cleaned with MOBIHEL ANTISILICONE CLEANER prior to application. Polyester products should be coated with 2K fillers to avoid peroxide transfer into the subsequent coats.

PRODUCT
PREPARATION/MIXING



Mixing ratio by volume:



4 parts MOBIHEL 2K 4:1 HS Compactprimer
low VOC
1 part MOBIHEL 2K HARDENER 700
10% MOBIHEL 2K THINNER 2100 (10%)



4 parts MOBIHEL 2K 4:1 HS Compactprimer
low VOC
1 part MOBIHEL 2K HARDENER 750
10% MOBIHEL 2K THINNER 2100 (10%)



Mixing ratio by weight:

100 g MOBIHEL 2K HS Compactprimer
15 g MOBIHEL 2K HARDENER 700 or
750W
7g MOBIHEL 2K THINNER 2100 (10%)



Pot life of the mixture at 20°:

2 h



Viscosity (RFU):

32 – 37 sec.
DIN 53211
Φ4 / 20°C

APPLICATION



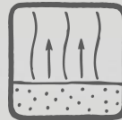
Application with spray gun

1,6– 2,0 mm
2 – 2,5 bar



Number of layers:

1 layer : 60 µm
3 layers: 180 µm



Flash-off:

10 - 15 min/20°C between layers

DRYING



Drying time at 20°C:

1,5h thickness 60 µm
4 - 5h thickness 180 µm

Drying time at 60°C:

20 min thickness 60 µm
30 min thickness 180 µm



Drying time
(infra-red short-wave):

10 min. – 60 µm
15 min. – 120 µm
20 min. - 180 µm
Distance to the object: 70 - 80 cm

SABDING



Dry sanding:

P360 – P600



Wet sanding:

P600 – P1200

FURTHER TREATMENT



Further treatment:

All MOBIHEL top coats

SHELF LIFE



Shelf life:

18 months

SAFETY ADVICE

Keep away from heat, hot surfaces, sparks, open flames and other ignition sources. No smoking. Do not breathe dust/fume/gas/mist/vapours/spray. Get medical advice/attention if you feel unwell. If skin irritation occurs: Get medical advice/attention. In case of fire: use powder, foam or CO2 for extinction. Product contains organic solvents.

ONLY FOR PROFESSIONAL USE

Version: 10-17