















Technical information (08/24)

## MOBIHEL 3:1 HS FILLER W/W

- Excellent filler for the protection of new cataphoresis protected spare parts
- Two application methods possible:
  - Wet on wet - (thinning required)
  - Normal sanding filler - (thinner not needed)
- Very easy to use
- Colour: grey
- Adding 30% HELIOS REFINISH PLASTIC ADDITIVE to the filler we get good adhesion to all paintable plastics used in car production
- VOC compliant







<b>SUBSTRATE PREPARATION</b>		
	 P220 - P280	 MOBIHEL ANTISILICONE CLEANER
	 MOBIHEL ANTISILICONE CLEANER	 P600 - P800
		 MOBIHEL ANTISILICONE CLEANER

		WET ON WET	SANDING FILLER
	<b>Mixing ratio by volume:</b>	3 parts MOBIHEL 3:1 HS FILLER W/W 1 part MOBIHEL 2K HARDENER 700	3 parts MOBIHEL 3:1 HS FILLER W/W 1 part MOBIHEL 2K HARDENER 700
	<b>Mixing ratio by weight:</b>	100 g MOBIHEL 3:1 HS FILLER W/W 23 g MOBIHEL 2K HARDENER 700	100 g MOBIHEL 3:1 HS FILLER W/W 23 g MOBIHEL 2K HARDENER 700
	<b>Pot life of the mixture at 20°C:</b>	min 1 h	min 1 h
	<b>Viscosity (RFU):</b> DIN 53211 φ4 mm/20°C	15 - 17 s  MOBIHEL 2K THINNER 2100 (10%)	NO THINNING
	<b>Application with spray gun:</b>	1.2 - 1.4 mm 2 - 2.5 bar	1.2 - 1.4 mm 2 - 2.5 bar

	<b>Number of layers:</b>	1-2 layers	2-3 layers
	<b>Film thickness:</b>	30 - 40 µm	60 - 100 µm
	<b>Flash-off:</b>	5 - 10 min/20°C between layers 20 - 30 min before application of solvent base coat 30 min before application of water base coat	5 - 10 min/20°C between layers 10 - 15 min/20°C before drying in oven

**NOTE:**

The surface should be lightly sanded with grey fine sanding mesh prior to applying the top coat if more than 5 hours have passed since application of the filler

	<b>Drying time at 20°C:</b>	CAUTION: The filler has a somewhat higher gloss than other fillers in the MOBIHEL program, therefore it is not necessary to wait until matt between layers.	3 - 4 h
	<b>Drying time at 60°C:</b>	/	30 min
	<b>Drying time (infra-red short-wave):</b>	/	15 - 20 Distance to the object: 70 - 80 cm
	<b>Dry sanding:</b>	/	P360 - P600
	<b>Wet sanding:</b>	/	P600 - P1200
	<b>Shelf life:</b>	18 months	

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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 540 g/l.

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

FOR PROFESSIONAL USE ONLY – See Safety Data Sheet

Close the packaging of the Hardener immediately after use, because the product reacts with air humidity and may cause defects in the product.

The data may vary under various conditions.

Any part of this information may change at any time without notice.

The information was derived from years of experience in the collaboration of Development and Technical Services and is the property of HELIOS Refinish.

We guarantee that the quality of work carried out according to our instructions delivers results while we disclaim any liability if any other products were used or if other factors influenced the final appearance.

The latest version of TDS supersedes all previous versions. You can obtain the latest version from general distributor in your country.

The user of this product should use the product in accordance with the laws and regulations for safety at work and waste management.

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