









Technical information (08/24)






MOBIHEL 4:1 HS COMPACTPRIMER











- High-build, primer and filler
- Very high film thickens (to 180 µm in 3 layers)
- Good vertical stability, filling properties
- Easy to sand
- In-depth drying properties allow a time saving quick processing delivering an excellent surface for the subsequent painting
- Colour: grey, white and black - possibility of stirred in a mixing unit
- VOC compliant

	FE	ZN	AL
SUBSTRATE PREPARATION	 P220 - P280	 MOBIHEL ANTISILICONE CLEANER	 MOBIHEL ANTISILICONE CLEANER
	 MOBIHEL ANTISILICONE CLEANER	 P220 - P280	 P220 - P280
		 MOBIHEL ANTISILICONE CLEANER	 MOBIHEL ANTISILICONE CLEANER
		MOBIHEL PASSIVATOR	MOBIHEL PASSIVATOR

NOTE:

MOBIHEL PASSIVATOR can be applied with a soaked cloth or with spraying gun. Filler must be applied within 7–10 min (not more than 15 min).

	Mixing ratio by volume:	 MOBIHEL 4:1 HS COMPACTPRIMER 4 parts MOBIHEL 2K HARDENER 700 1 part MOBIHEL 2K THINNER 2100 10%  MOBIHEL 4:1 HS COMPACTPRIMER 4 parts MOBIHEL 2K HARDENER 750 W 1 part MOBIHEL 2K THINNER 2100 10%
	Mixing ratio by weight:	MOBIHEL 4:1 HS COMPACTPRIMER 100 g MOBIHEL 2K HARDENER 700 / 750 W 15 g MOBIHEL 2K THINNER 2100 7 g
	Pot life of the mixture at 20°C:	2 h

	Viscosity (RFU): DIN 53211 Φ 4 mm/20°C	32 - 37 s	
	Application with spray gun:	1.6 - 1.8 mm 2 - 2.5 bar	
	Number of layers:	1 layer	3 layers
	Film thickness:	60 μ m	180 μ m
	Flash-off:	10 - 15 min/20°C between layers 15 - 20 min/20°C before drying in oven	
	Drying time at 20°C: Drying time at 60°C:	1,5 h drying thickness: 60 μ m 20 min drying thickness: 60 μ m	4 - 5 h drying thickness: 180 μ m 30 min drying thickness: 180 μ m
	Drying time (infra-red short-wave):	10 min 60 μ m 15 min 120 μ m 20 min 180 μ m Distance to the object: 70 - 80 cm	
	Dry sanding:	P360 - P600	
	Wet sanding:	P600 - P1200	
	Further treatment:	All MOBIHEL top coats	
	Shelf life:	2 years	

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 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.

Version: 2024-2 (01.08.2024)

