












Technical information (08/24)

## MOBIHEL CLEARCOAT MATT












- For painting of small plastic parts (bumpers, mirror covers, side crossbars etc.)
- It is distinguished by extremely matt effect (gloss grade 5-15%)
- High elasticity
- Excellent mechanical and chemical resistance
- Can be mixed with MOBIHEL 2K clearcoats to obtain different grades of matt effect
- The clearcoat must not be polished
- VOC compliant

<b>SUBSTRATE</b>	MOBIHEL BASE MIX MOBIHEL HYDRO BASE MIX
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	<b>Mixing ratio by volume:</b>		MOBIHEL CLEARCOAT MATT MOBIHEL 2K HARDENER 1300 MOBIHEL 2K THINNER 2100	2 parts 1 part 20%
			MOBIHEL CLEARCOAT MATT MOBIHEL 2K HARDENER 1100 MOBIHEL 2K THINNER 2100	2 parts 1 part 20%
			MOBIHEL CLEARCOAT MATT MOBIHEL 2K HARDENER 1500 MOBIHEL 2K THINNER 2100	2 parts 1 part 20%
	<b>Mixing ratio by weight:</b>		MOBIHEL CLEARCOAT MATT MOBIHEL 2K HARDENER 1100 / 1300 / 1500 MOBIHEL 2K THINNER 2100	100 g 48 g 26 g
	<b>Pot life of the mixture at 20°C:</b>	3 h		
	<b>Viscosity (RFU):</b> DIN 53211 Φ4 mm/20°C	17 - 19 s		
	<b>Application with spray gun:</b>	1.2 - 1.3 mm 2 - 2.5 bar		

	<b>Number of layers:</b> <b>Film thickness:</b>	2 full layers 50 - 60 µm
	<b>Flash-off:</b>	15 min/20°C between layers 10 - 15 min/20°C before drying in oven
	<b>Drying time at 20°C:</b> <b>Drying time at 60°C:</b>	16 h 30 min (object temperature)

OR

	<b>Mixing ratio by volume:</b>	 MOBIHEL CLEARCOAT MATT MOBIHEL 2K HS HARDENER 4300 MOBIHEL 2K THINNER 2100	3 parts 1 part 30%
		 MOBIHEL CLEARCOAT MATT MOBIHEL 2K HS HARDENER 4100 MOBIHEL 2K THINNER 2100	3 parts 1 part 30%
		 MOBIHEL CLEARCOAT MATT MOBIHEL 2K HS HARDENER 4500 MOBIHEL 2K THINNER 2100	3 parts 1 part 30%
	<b>Mixing ratio by weight:</b>	MOBIHEL CLEARCOAT MATT MOBIHEL 2K HS HARDENER 4100 / 4300 / 4500 MOBIHEL 2K THINNER 2100	100 g 33 g 35 g
	<b>Pot life of the mixture at 20°C:</b>	3 h	
	<b>Viscosity (RFU):</b> DIN 53211 Φ4 mm/20°C	17 - 19 s	
	<b>Application with spray gun:</b>	1.2 - 1.3 mm 2 - 2.5 bar	
	<b>Number of layers:</b> <b>Film thickness:</b>	2 full layers 50 - 60 µm	
	<b>Flash-off:</b>	15 min/20°C between layers 10 - 15 min/20°C before drying in oven	
	<b>Drying time at 20°C:</b> <b>Drying time at 60°C:</b>	16 h 30 min (object temperature)	


	<b>Shelf life:</b>	1 year
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Table of matt effect level Table shows weight ratio of mixing of clearcoats with regard to matt effect level.					
	GLOSS LEVEL			COMBINATION WITH DIFERENT HARDENERS	
	Semi-matt ca. 40%	Semi-gloss ca. 60%	Gloss ca. 80%	MOBIHEL 2K HARDENER	MOBIHEL 2K HS HARDENER
MOBIHEL CLEARCOAT MATT	87 g	80 g	70 g	2:1 MOBIHEL 2K hardener 1100/1300/1500 + 20% MOBIHEL 2K thinner 2100	3:1 MOBIHEL 2K HS hardener 4100/4300/4500 + 30% MOBIHEL 2K thinner 2100
MOBIHEL 2:1 HS CLEARCOAT DH	13 g	20 g	30 g		
MOBIHEL CLEARCOAT MATT	83 g	70 g	60 g	2:1 MOBIHEL 2K hardener 1100/1300/1500 + 10% MOBIHEL 2K thinner 2100 / 2300 / 2500	3:1 MOBIHEL 2K HS hardener 4100/4300/4500 + 20% MOBIHEL 2K thinner 2100 / 2300 / 2500
MOBIHEL 2:1 CLEARCOAT ANTI SCRATCH	17 g	30 g	40 g		
MOBIHEL CLEARCOAT MATT	85 g	80 g	70 g	2:1 MOBIHEL 2K hardener 1100 / 1300 / 1500 + 10% MOBIHEL 2K thinner 2100 / 2300 / 2500	3:1 MOBIHEL 2K HS hardener 4100 / 4300 / 4500 + 20% MOBIHEL 2K thinner 2100 / 2300 / 2500
MOBIHEL 2:1 CLEARCOAT FG ANTI SCRATCH	15 g	20 g	30 g		

Matt effect level depends on the following factors (influence of factors may cause change in gloss level also for 10 -20 %)		
FACTOR	HIGHER GLOSS	LOWER GLOSS
Deaeration time between coats	shorter	longer
Coat thickness	higher	lower
Hardener	slower	quicker
Thinner	slower	quicker
Working viscosity	higher	lower
Drying method	forced drying in the oven	air drying
Hardner solid substance	high solid substance	ow solid substance

2004/42/II B(e) (840) 620

EU limit value VOC for this type of products (category II B (e)) in the form, which is ready for application is **840 g/l** VOC of this product, prepared for use is **620 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 (02.08.2024)

