






















Technical information (08/22)

## MOBIHEL 4:1 HS COMPACTPRIMER PLUS

- As a high quality acrylic filler for partial and full automotive refinishes
- High solids content
- Good filling properties
- Good insulating properties
- Good vertical stability
- Good weathering resistance and good corrosion protection
- Colour: white, black and grey
- VOC compliant

|                              | FE   | ZN   | AL   |
|------------------------------|--|--|--|
| <b>SUBSTRATE PREPARATION</b> |  P220 – P280                  |  MOBIHEL Antisilicone cleaner |  MOBIHEL Antisilicone cleaner |
|                              |  MOBIHEL Antisilicone cleaner |  P220 – P280                  |  P220 – P280                  |
|                              |  |  MOBIHEL Antisilicone cleaner |  MOBIHEL Antisilicone cleaner |

|   |  |  |                               |
|---|--|--|-------------------------------|
|  | <b>Mixing ratio by Volume:</b>                 | MOBIHEL 4:1 HS COMPACTPRIMER PLUS<br>MOBIHEL 2K HARDENER 700 PLUS or 750 PLUS<br>MOBIHEL 2K THINNER 2100 | 4 parts<br>1 part<br>10 - 15% |
|  | <b>Mixing ratio by weight:</b>                 | MOBIHEL 4:1 HS COMPACTPRIMER PLUS<br>MOBIHEL 2K HARDENER 700 PLUS or 750 PLUS<br>MOBIHEL 2K THINNER 2100 | 100 g<br>16 g<br>7 - 11 g     |
|  | <b>Pot life of the mixture at 20°:</b>         | Min. 1 h   |                               |
|  | <b>Viscosity (RFU):</b><br>DIN 53211 φ4 / 20°C | 26 - 34 sec.   |                               |

|   |  |   |
|---|--|---|
|    | <b>Application with spray gun:</b>                         | 1,6 – 1,8 mm<br>1,8 – 2,0 bar   |
|    | <b>Number of layers:</b><br><b>Film thickness:</b>         | 2 – 3<br>120 – 180 µm   |
|    | <b>Flash-off:</b>  | 8 - 10 min./20°C between layers<br>15 - 20 min./20°C prior to dry in oven |
|    | <b>Drying time at 20°C:</b><br><b>Drying time at 60°C:</b> | 4 – 5 h<br>30 min.  |
|    | <b>Drying time (infra-red short-wave)</b>                  | 15 – 20 min.<br>Distance to the object: 70 - 80 cm                        |
|    | <b>Dry sanding:</b>  | P360 – P600   |
|  | <b>Wet sanding:</b>  | P600 – P1200  |
|  | <b>Further treatment:</b>                                  | All top coats from MOBIHEL program  |
|  | <b>Shelf life:</b>   | 2 years   |

2004/42/II B(c) (540) 530

EU limit value VOC for this type of product (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%.

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.