

# MOBIHEL®

... for the cars we love

## 2K HS 3:1 FILLER W/W LOW VOC

Primer and filler combination for car bodies, with good corrosion protection. The filler is applied according to the "wet on wet" system (requires thinning) or as a normal sanding filler that is ready for spraying after a suitable hardener is added.

Particularly recommended for use on new cataphoresis-coated spare parts.



<b>PACKING DATA</b>	<b>Packing:</b>	<b>Index:</b>
	6 x 0.75	47843502

<b>ASSOCIATED PRODUCTS</b>	<b>MOBIHEL 2K HARDENER 700</b>	
	<b>Packing:</b>	<b>Index:</b>
	6 x 0.25 l	41825601
	6 x 1.0 l	41825612
	4 x 5.0 l	41825614



<b>HYGIENE &amp; PERSONAL PROTECTION</b>	
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<b>TECHNICAL CHARACTERISTICS</b>	<b>Colour:</b>	Grey
	<b>Product type:</b>	Acrylic resins
	<b>Density:</b>	1,386 g/ml
		2004/42/II B(c) (540) 515 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 515 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%.

<b>SUBSTRATE</b>	Steel sheet metal Cathaphoresis coatings Old enamels
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<b>SUBSTRATE PREPARATION</b>	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.
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<b>PRODUCT PREPARATION/MIXING</b>		<b>Mixing ratio by volume:</b>	3 parts MOBIHEL 2K HS 3:1 FILLER W/W 1 part MOBIHEL 2K HARDENER 700
		<b>Mixing ratio by weight:</b>	100 g MOBIHEL 2K HS 3:1 FILLER W/W 23 g MOBIHEL 2K HARDENER 700
		<b>Pot life of the mixture at 20°:</b>	min.1 h

<b>PRODUCT PREPARATION/MIXING</b>		<b>Viscosity (RFU):</b>	<b>WET ON WET</b> 15 - 17 sec. DIN 53211 φ4 mm /20°C MOBIHEL 2K THINNER 2100 (10%)	<b>SANDING FILLER</b> <b>NO THINNING</b>
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## APPLICATION



**Application with spray gun:**

**WET ON WET**  
1,2 - 1,4 mm  
2 – 2,5 bar

**SANDING FILLER**  
1,2 - 1,4 mm  
2 – 2,5 bar



**Number of layers:**

1 - 2 layers  
DFT: 30 - 40 µm

2 - 3 layers:  
DFT. 60 - 100 µm

### 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.



**Flash-off:**

**WET ON WET**  
5 - 10 min between layers  
20 - 30 min before application of  
**MOBIHEL solvent-based** top coating  
min. 30 min before application of  
**MOBIHEL HYDRO Base**

**SANDING FILLER**

5 - 10 min between layers

## DRYING



**Drying time at 20°C:**

**WET ON WET**  
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.

**SANDING FILLER**  
20°C: 3 - 4 hours  
60°C: 30 min



**Drying time (infra-red short-wave):**

**SANDING FILLER**  
15 - 20 min  
Distance to the object: 70 - 80 cm

## SABDING



**Dry sanding:**

**SANDING FILLER**  
P360 - P600



**Wet sanding:**

**SANDING FILLER**  
P600 - P1200

## SHELF LIFE



**Shelf life:**

18 months

## SAFETY ADVICE

Flammable liquid and vapour. Causes skin irritation. Harmful to aquatic life with long lasting effects. Repeated exposure may cause skin dryness or cracking. Product contains organic solvents

**ONLY FOR PROFESSIONAL USE**