MOBIHEL®

... for the cars we love

2K ACRYLIC ENAMEL MIX

MOBIHEL 2K ACRYLIC ENAMEL is used as a Direct-Gloss Topcoat for the final painting of personal vehicles, buses, trucks and other vehicles as well as for other metal objects and is part of the MOBIHEL Mixing System.
The desired colour can be obtained by using the MOBIHEL Colour Navigator Formulation Software or by searching in the Mobihel Colour Box Expert.
The selected colour is subsequently mixed quickly and precisely using the software and computer-connected scale.

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HELIOS

PACKING DATA

Packing:
6 x 1.0 l
4 X 5.0 l

ASSOCIATED PRODUCTS

MOBIHEL 2K HARDENER 1100

Packing:	Index:
6 x 0.25 l	41672291
6 x 0.5 l	41672261
6 x 1.0 l	41672222
4 x 2.5 l	41672203
4 x 5.0 l	41672214

MOBIHEL 2K HARDENER 1300

Packing: :	Index:
6 x 0.5 l	41672661
6 x 1.0 l	41672602

MOBIHEL 2K HARDENER 1500

Packing:	Index:
6 x 0.5 l	41672701
6 x 1.0 l	41672702
4 x 5.0 l	41672714

MOBIHEL 2K THINNER 2100

Packing:	Index:
12 x 0.5 l	41672151
4 x 5.0 l	41672114

MOBIHEL 2K THINNER 2300

Packing:	Index:
12 x 0.5 l	41672351
12 x 1.0 l	41672302
4 x 5.0 l	41672314

MOBIHEL 2K THINNER 2500

Packing:	Index:
12 x 0.5 l	41672951
4 x 5.0 l	41672914

HYGIENE & PERSONAL PROTECTION

TECHNICAL CHARACTERISTICS

Colour:	MOBBIHEL Color box
Product type:	Acrylic resins
Density:	0,971 – 1,36 g/ml

MOBIHEL Colour Navigator Formulation Software

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%.

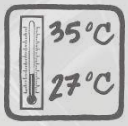
SUBSTRATE

MOBIHEL 2K Fillers

PRODUCT PREPARATION/MIXING

Stirring on mixing unit: MIX 101 – MIX 131

Mixing ratio by volume:



2 parts MOBIHEL 2K 2:1 ACRYLIC ENAMEL MIX
1 part MOBIHEL 2K HARDENER 1300
10% MOBIHEL 2K THINNER 2300

2 parts MOBIHEL 2K 2:1 ACRYLIC ENAMEL MIX
1 part MOBIHEL 2K HARDENER 1100
10% MOBIHEL 2K THINNER 2100

2 parts MOBIHEL 2K 2:1 ACRYLIC ENAMEL MIX
1 part MOBIHEL 2K HARDENER 1500
10% MOBIHEL 2K THINNER 2500

Mixing ratio by weight:

100 g MOBIHEL 2K 2:1 ACRYLIC ENAMEL MIX
48 g MOBIHEL HARDENER 1100 or 1300 or 1500
13 g MOBIHEL 2K THINNER 2100 or 2300 or 2500

Viscosity (RFU): 17 - 20 s
DIN 53211 Φ 4mm/ 20°C

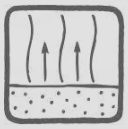
Colour test: The colour should be applied on to a piece of test cardboard to assess its suitability prior to application on the object.

APPLICATION

Application with spray gun: 1,2 – 1,3 mm
2 – 2,5 bar RP

Number of layers: 2 - 3 full layers
DFT: 50 - .60 µm

DRYING



Flash-off: 10 min/20°C between layers

NOTE: Flash-off prior to drying:
in case that spray booth doesn't have automatic flash-off, you need to flash-off 10 minutes prior to drying in the oven

Drying time at 20°C: 16 h

Drying time at 60°C: 30 min (object temperature)

Drying time (infra-red short-wave): 8 – 12 min
Distance to the object: 70 - 80 cm

SAFETY ADVICE

Shelf life: 4 years

SAFETY ADVICE

Keep away from heat, hot surfaces, sparks, open flames and other ignition sources. No smoking. Do not breathe dust/fume/gas/mist/vapours/spray. Avoid release to the environment. IF INHALED: Remove victim to fresh air and keep at rest in a position comfortable for breathing. Get medical advice/attention if you feel unwell. - If skin irritation occurs: Get medical advice/attention.
Product contains organic solvents.

ONLY FOR PROFESSIONAL USE

Version: 10 - 17