

# Colorbuild™ Plus

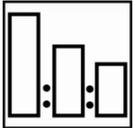
FOR PROFESSIONAL USE ONLY

## Description

Colorbuild Plus consists of six colored primers which, when mixed in proper combination with each other, achieve colors closely resembling the most popular topcoat colors. Depending on the mixing ratio utilized, Colorbuild Plus can be used as either a sanding surfacer or wet on wet primer surfacer.

## Sanding

ECOLOGICAL



3 Colorbuild Plus  
1 Colorbuild Plus Hardener Sanding  
+10% Colorbuild Plus Activator Sanding



Use Sikkens measuring stick

**9** Grey

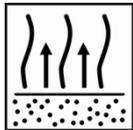


Spray gun set-up:  
1.5-2.0mm

Application pressure:  
1.7-2.2 bar at the air inlet  
HVLP max 0.6-0.7 bar at the air cap



2-3 x 1 coat



Between coats:  
4-6 minutes at 20°C

Before curing:  
4-6 minutes at 20°C



1 ½ hours at 20°C  
3 coat application

30 minutes at 60°C



Final sanding step: P500  
See TDS S8.06.01



Recoatable with all Sikkens topcoats

# Colorbuild™ Plus

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Use suitable respiratory protection  
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

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Read complete TDS for detailed product information

# Colorbuild™ Plus

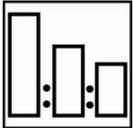
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## Wet-on-wet

ECOLOGICAL



100 Colorbuild Plus  
25 Colorbuild Plus Hardener Non Sanding  
35 Colorbuild Plus Activator Non Sanding



Use Sikkens measuring stick

**5** Orange

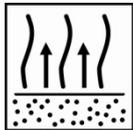


Spray gun set-up:  
1.3-1.5mm

Application pressure:  
1.7-2.2 bar at the air inlet  
HVLP max 0.6-0.7 bar at the air cap



1 coat



Flash-off time:  
15 minutes at 20°C

Recoat within:  
24 hours at 20°C



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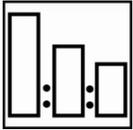
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## Sanding



4 Colorbuild Plus  
1 Hardener P25  
1 Plus Reducers



Use Sikkens measuring stick

**5** Orange

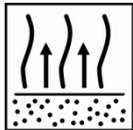


Spray gun set-up:  
1.5-2.0mm

Application pressure:  
1.7-2.2 bar at the air inlet  
HVLP max 0.6-0.7 bar at the air cap



2-3 x 1 coat



Between coats:  
4-6 minutes at 20°C

Before curing:  
4-6 minutes at 20°C



3 hours at 20°C  
3 coat application

30 minutes at 60°C



Final sanding step: P500  
See TDS S8.06.01



Recoatable with all Sikkens topcoats

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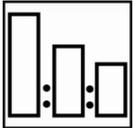
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## Wet-on-wet



3 Colorbuild Plus  
1 Hardener P25  
1 Plus Reducers



Use Sikkens measuring stick

**9** Grey

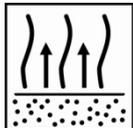


Spray gun set-up:  
1.3-1.5mm

Application pressure:  
1.7-2.2 bar at the air inlet  
HVLP max 0.6-0.7 bar at the air cap



1 coat



Flash-off time:  
15 minutes at 20°C

Recoat within:  
4 hours at 20°C



Recoatable with all Sikkens topcoats



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Colorbuild Plus consists of six colored primers which, when mixed in proper combination with each other, achieve colors closely resembling the most popular topcoat colors. Depending on the mixing ratio utilized, Colorbuild Plus can be used as either a sanding surfacer or wet on wet primer surfacer.

## Suitable substrates

Existing finishes	Glass Reinforced Polyester laminates (GRP)
Steel	Polyester bodyfillers
Aluminium	Sikkens Polysurfacer
Galvanized steel	Primer Surfacer EP
OEM electro coat	Sikkens Washprimer 1K CF

	Colorbuild Plus Sanding / non sanding	Colorbuild non sanding in combination with Plastic Additive
Direct to steel	Yes 1)	Yes 1)
Direct to aluminum	Yes 1)	<b>No</b>
Direct to galvanized steel	Yes 1)	<b>No</b>
Direct to new plastic parts	<b>No</b>	Yes 2)
Direct to unsanded OEM electrocoat	Yes 3)	Yes 3)
Sanded existing finishes	Yes 3)	Yes 3)

- 1) **Colorbuild Plus will provide adequate adhesion if applied directly to all metals. However, it is advised to use Sikkens Washprimer 1K CF in the following cases:**
  - a. **When the system is required to meet the highest standard**
  - b. **Repairs that requires an extensive metal priming such as complete panel**
- 2) Only in combination with Colorbuild Plus Plastic Additive  
Only when plastic parts are properly pretreated, sanded and cleaned  
On all plastics, with the exception of pure PP and pure PE  
When mixed with Colorbuild Plus Plastic Additive no plasticizer is needed
- 3) Surfaces should be thoroughly cleaned and degreased

## Products and additives

**Products** Colorbuild Plus; White-Black-Red-Blue-Green-Yellow  
Colorbuild Plus; Dark Grey

**Hardeners** Hardener P25

**Reducers** Plus Reducer Medium  
Plus Reducer Slow  
Plus Reducer Extra Slow

**Additives** Elast-O-Actif: to elasticize Colorbuild Plus. See S8.06.03  
Colorbuild Plus Plastic Additive: for non sanding application on plastics. See S8.06.03

# Colorbuild™ Plus

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## Basic raw materials

Colorbuild Plus: Acrylic and polyester resins  
P25 Hardeners: Polyisocyanate resin  
Plus Reducers: Solvents

## Surface preparation



Surface cleaning; remove any surface contamination prior to sanding using Sikkens M700 or M600 surface cleaner.  
Pre-clean the surface with warm water and detergent, rinse sufficiently with clean water.



Sanding; final dry sanding steps; P220 - P320  
Direct applicable on non-sanded, thoroughly cleaned and degreased rigid OEM electro-coated parts.  
Sikkens Polykit IV and Polysurfacers; finished with; P120 – P220  
Featheredge sanding for spot repair, finish outer area with P400  
For detailed surface preparation see TDS S8.06.02



Surface cleaning; remove any surface contamination prior to Colorbuild application using Sikkens M700 or M600 surface cleaner. Where bodyfiller is exposed, avoid contact with water (e.g.M850 Solfree or M200).

## Stir before use



Stir each Colorbuild Plus color thoroughly before mixing

## Mixing Colorbuild Plus colors

With the exception of the Black and White, Colorbuild Plus colors **must always** be intermixed according to the mixing formulas to achieve the desired color, layer thickness and coverage prior to the addition of hardener, activator or thinner. Colorbuild Plus Black and White can be mixed in each mixing ratio, see Quick-Mix table below

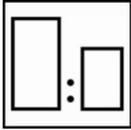
Black - White		
0 : 100	White	
1 : 5	Light grey	
1 : 2	Medium light grey	
1 : 1	Medium grey	
2 : 1	Medium dark grey	
5 : 1	Dark grey	
100 : 0	Black	

Colorbuild Plus mixtures must be stirred thoroughly before adding Colorbuild Plus Hardener.  
Stir thoroughly once more before adding additional reducer (if required).

# Colorbuild™ Plus

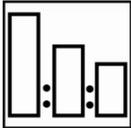
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## Under the hood colors



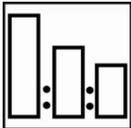
In the engine compartment of some cars a matt to semi gloss finish is present. More and more car brands utilize this finish, so-called under the hood colors. Colorbuild Plus colors can be used to imitate such colors. Addition of Autoclear Plus HS helps to reach required semi-gloss level.

Make a mixture of Colorbuild Plus color: Autoclear Plus HS or Autocryl Plus A065; 80:20 by weight



3 Under the hood Colorbuild Plus mixture  
1 Hardener P25 or P35  
1 Plus Reducers

## Mixing



### Sanding:

4 Colorbuild Plus  
1 P25 Hardener  
1 Plus Reducer

### Non sanding (wet-on-wet):

3 Colorbuild Plus  
1 P25 Hardener  
1 Plus Reducer

### Plastic application (Non Sanding):

3 Colorbuild Plus  
1 P25 Hardener  
1 Colorbuild Plus Plastic Additive

**Notes:** Colorbuild Plus under the hood mix and Colorbuild Plus with Plastic Additive can be used as regular sealers for (mild steel) metal.  
When aluminium and galvanized steel is used, it should be preceded by Washprimer 1K CF.  
Non sanding (w-o-w) version should be applied over suitable plastic primer for optimum adhesion properties

## Flexible parts

Sanding: Once elasticized to the required level, Colorbuild Plus can be applied on plastic parts. All flexible plastic parts should be pre-coated with a suitable plastic primer (in the case of unprimed plastic), or OEM finish. See TDS.S8.06.03.

Non sanding: Colorbuild Plus with Plastic Additive can be applied as non-sanding primer directly on all plastics with the exception of pure PE and PP. See TDS.S8.06.03.

## Spray gun set-up / application pressure



### Spray gun

Gravity feed

Gravity feed

### Fluid tip-set-up

#### Sanding

1.5-2.0 mm

#### Wet on wet

1.3-1.5 mm

### Application pressure

1.7-2.2 bar at the spray gun air inlet  
HVLP max 0.6-0.7 bar at the air cap

1.7-2.2 bar at the spray gun air inlet  
HVLP max 0.6-0.7 bar at the air cap

For maximum build use large fluid tip and lower application pressure.

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## Pot-life

P25 Plus Reducers

1 hour

at 20°C

## Application

**Sanding;** Apply one coat over the total sanded area. Next apply the 2<sup>nd</sup> and 3<sup>rd</sup> coat within each preceding coat. Where a full panel application is required apply 2-3 coats over the total panel dependent on the required film build.



Allow each coat to flash-off naturally until the surface is completely matt; this also supports to achieve higher film build. Do not force-dry by air support. Flash-off between the coats is dependent on ambient temperature, applied layer thickness and airflow. For maximum build use large fluid tip and lower the application pressure.

### Wet on wet (non sanding/surfacers)

Apply 1 full wet coat over the total area.

## Drying time sanding



3 hours at 20°C

30 minutes at 60°C

Drying times relate to recommended application (3 coats) and object temperature

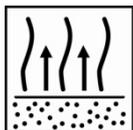


Allow 5 minutes flash-off prior to infra red curing

The panel must not reach a temperature above 100°C while curing.

For additional infra red drying information; see TDS S9.01.01

## Flash-off time wet-on-wet



Allow for a minimum flash-off time of 15 minutes at 20°C prior to topcoat application.

Apply topcoat within 4 hours at 20°C.

Should this maximum time be exceeded, abrade the surface with P500 dry or P1000 wet sanding paper.

## Denibbing wet-on-wet

For minor defects (e.g. dust) Colorbuild Plus can be denibbed with either P500 dry or P1000 wet sanding paper. After a drying time of longer than 4 hours thorough sanding is necessary!

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## Final sanding



Final sanding step P500  
Initial sanding steps may be executed with a coarser sanding grit; P360 - P400  
Respect a maximum 100 sanding grit step difference or less throughout the sanding procedure.  
For detailed surface preparation see TDS S8.06.02



Final sanding step P1000  
Initial sanding steps may be executed with a coarser sanding grit P600 - P800  
Respect a maximum 200 sanding grit step difference or less throughout the sanding procedure.  
For detailed surface preparation see TDS S8.06.02



Surface cleaning; remove any surface contamination prior to the application of the topcoat using Sikkens M700 or M600 surface cleaner. In case of Autowave application also clean with M850 Solfree or M200.

## Recoatable with

Autowave  
Autobase Plus  
Autocryl Plus  
Autocryl Plus LV

## Film thickness

Sanding	per coat	40 - 45 µm
	3 coats	120 - 130 µm
Wet-on-wet	1 coat	25 - 30 µm

## Theoretical coverage

**Sanding:** Ready for use mixture at 1 µm dry film thickness: 400 m<sup>2</sup>/liter  
**Wet-on-wet:** Ready for use mixture at 1 µm dry film thickness: 389 m<sup>2</sup>/liter

The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.

## Cleaning of equipment

Sikkens Solvents or Guncleaners

## VOC

The VOC content of this product in ready to use form is 553 g/liter for the sanding version and 570 g/liter for the wet-on-wet version, 572g/liter for elastisized version, 589g/liter with Colorbuild Plus Plastic Additive and 562g/liter for the under the hood version.

## Product storage

Product shelf-life is determined when products are stored unopened at 20°C.  
Avoid extreme temperature fluctuation.  
Product shelf life data see TDS S9.01.02

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**Akzo Nobel Car Refinishes (Singapore) Pte Ltd**

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#### **FOR PROFESSIONAL USE ONLY**

**IMPORTANT NOTE** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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