

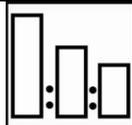
# Colorbuild™ Plus

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 non sanding / wet on wet primer surfacer.

## Sanding (Eco-Logical)



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



Use Sikkens measuring stick

**9** Grey

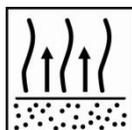


Spray gun set-up:  
 1.5-2.0 mm

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



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

Read complete TDS for detailed product information

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## Wet on wet (Eco-Logical)



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:  
1.3-1.5 mm

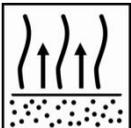
Application pressure:

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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## Suitable substrates

Sanded existing finishes (*note 3*)  
 Steel (*note 1*)  
 Aluminium (*note 1*)  
 Galvanized steel (*note 1*)  
 OEM electro coat (*note 3*)  
 New bare plastic part (*note 2*)

Glass Reinforced Polyester laminates (*note 3*)  
 Polyester bodyfillers  
 Sikkens Polysurfacer  
 Primer Surfacer EP  
 Sikkens Washprimers  
 1K All Plastic Primer

### Check relevant notes below

- 1) **Colorbuild Plus will provide adequate adhesion when applied directly on all properly abraded and cleaned/degreased metal substrates. 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 primer surfacer application, such as complete panel**
- 2) Only as non sanding in combination with Colorbuild Plus Plastic Additive  
 Only when plastic parts are properly pretreated, abraded and cleaned  
 On all plastics, with the exception of pure PE and PP  
 When mixed with Colorbuild Plus Plastic Additive, no plasticizer is needed
- 3) Surfaces should be thoroughly cleaned and degreased

## Product and additives

<b>Products</b>	Colorbuild Plus; White-Black-Red-Blue-Green-Yellow Colorbuild Plus; Dark Grey
<b>Hardeners</b>	Colorbuild Plus Hardener Sanding Colorbuild Plus Hardener Non Sanding
<b>Activator</b>	Colorbuild Plus Activator Sanding Fast; spot and panel repairs. Colorbuild Plus Activator Sanding Slow; standard application on larger surfaces and at higher temperatures Colorbuild Plus Activator Non Sanding; for non sanding / wet-on-wet application.
<b>Additives</b>	Colorbuild Plus Plastic Additive: for non sanding application on plastics. See TDS S8.06.03 Elast-O-Actif: to elasticize Colorbuild Plus. See TDS S8.06.03

## Basic raw materials

Colorbuild Plus: Acrylic and polyester resins  
 Colorbuild Plus Hardeners: Polyisocyanate resin  
 Colorbuild Plus Activators Sanding: Activated solvents

# Colorbuild™ Plus

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## 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 polyester bodyfillers and Polysurfacer; 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. waterborne degreaser).*

## Stir before use



Stir each Colorbuild Plus color thoroughly before mixing

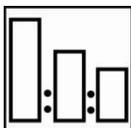
## Mixing Colorbuild Plus colors

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	

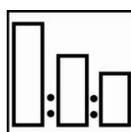
*Colorbuild Plus mixtures must be stirred thoroughly before adding Colorbuild Plus Hardener. Stir thoroughly once more before adding additional reducer (if required).*

# Colorbuild™ Plus

**FOR PROFESSIONAL USE ONLY**
**Under the hood colors**


In the engine compartment of some cars a matt 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 by the addition of Autoclear LV Superior Fast (by weight) to reach required semi-gloss level.

<b>70</b>	Colorbuild Plus color	<b>100</b>	Under the hood Colorbuild Plus mixture
<b>30</b>	Autoclear LV Superior Fast* *by weight	<b>25</b>	Colorbuild Plus Hardener Non Sanding
		<b>35</b>	Colorbuild Plus Activator Non Sanding

**Mixing**

**Sanding:**

<b>3</b>	Colorbuild Plus
<b>1</b>	Colorbuild Plus Hardener Sanding
<b>10%</b>	Colorbuild Plus Activator Sanding

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

<b>100</b>	Colorbuild Plus
<b>25</b>	Colorbuild Plus Hardener Non Sanding
<b>35</b>	Colorbuild Plus Activator Non Sanding

**Plastic application (wet-on-wet)**

<b>100</b>	Colorbuild Plus
<b>25</b>	Colorbuild Plus Hardener Non Sanding
<b>35</b>	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
- It is allowed to use 10 % Autoclear LV Superior Fast (or) Elas-O-Activ on total mixture to avoid overspray issues. The mixing ratio to be followed is 100:25:35:10 (AC LV Superior Fast (or) EOA)
- Under the hood mix can be re-coated with basecoat – Clearcoat (or ) Single Stage top coats.

**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**
**Fluid tip-set-up**
**Application pressure**

Gravity feed

Sanding  
1.5-2.0 mm

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

Gravity feed

Wet on wet  
1.3-1.5 mm

 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 the application pressure.*

# Colorbuild™ Plus

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## Pot-life

Colorbuild Plus mixed with Activator Sanding Extra Fast and Fast	35 minutes at 20°C
Colorbuild Plus mixed with Activator Sanding Slow	1 hour at 20°C
Colorbuild Plus Non Sanding (wet-on-wet):	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/surfacer)

Apply 1 full wet coat over the total area.

## Drying time sanding



1½ hours at 20°C

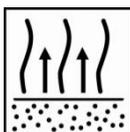
30 minutes at 60°C

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 24 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 24 hours thorough sanding is necessary!

## 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

# Colorbuild™ Plus

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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 for. In case of Autowave application also clean with M850 Solfree or M200.

## Recoatable with

Autowave  
 Autocryl Plus LV  
 Autobase Plus  
 Autocryl Plus

## Film thickness

Sanding	Per coat : 40-50 µm 3 coats: 120-150 µm
Non sanding / wet-on-wet (1 coat);	25-30 µm

## Theoretical coverage

By using the recommended application, the theoretical material usage is:

- **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 max. 540 g/liter.

## 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 Australia Pty Ltd**  
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**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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