

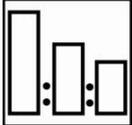
Colorbuild Plus

FOR PROFESSIONAL USE ONLY

Description

Colorbuild Plus consists of colored primers which, when mixed in a proper combination with each other, achieve colors closely resembling the most popular topcoat colors. Colorbuild Plus can be used as a sanding surfacer or non sanding primer surfacer.

Sanding



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



Use Sikkens measuring stick

35 Orange

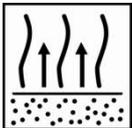


Spray gun set-up:
1.5-1.8 mm

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

45 minutes at 40°C

30 minutes at 60°C



Final sanding step: P500
See TDS S8.06.02



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

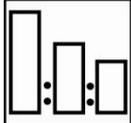
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Description

Colorbuild Plus consists of colored primers which, when mixed in proper combination with each other, achieve colors closely resembling the most popular topcoat colors. Colorbuild Plus can be used as a sanding surfacer or non sanding primer surfacer.

Wet on wet



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



Use Sikkens measuring stick

5 Orange

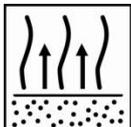


Spray gun set-up:
1.3-1.4 mm

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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Colorbuild Plus consists of colored primers which, when mixed in proper combination with each other, achieve colors closely resembling the most popular topcoat colors. Colorbuild Plus can be used as a sanding surfacer or non sanding primer surfacer

Suitable substrates

Existing finishes	Glass Reinforced Polyester laminates (GRP)
Steel	Polyester bodyfillers
Aluminium	Sikkens Polysurfacer
Galvanized steel	Primer Surfacer EPII
OEM electro coat	Sikkens Washprimers
	AutoPrep Pre-Treatment Wipes (see TDS A2.06.01)

	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)	X
Direct to galvanized steel	Yes 1)	X
Direct to new plastic parts	X	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. For systems which should meet the highest standards, apply Colorbuild Plus over Sikkens Washprimer.
- 2) Only in combination with Colorbuild Plus Plastic Additive (HT)
Only when plastic parts are properly pretreated, sanded and cleaned
On all plastics, with the exception of pure PP and pure PE and PP-E/P blends
When mixed with Colorbuild Plus Plastic Additive (HT) no plasticizer is needed
- 3) Surfaces should be thoroughly cleaned and degreased

Product and additives

Products	Colorbuild Plus; White-Black-Red-Blue-Green-Yellow
Hardeners	Colorbuild Plus Hardener Sanding Colorbuild Plus Hardener Non Sanding
Activator	Colorbuild Plus Activator Sanding Extra Fast; spot repairs and application at lower temperatures. 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.
Additives	Colorbuild Plus Plastic Additive (HT): for non sanding application on plastics. See S8.06.03 Autocryl Structure Paste Fine: additive to create different surface textures, See TDS 6.57

Basic raw materials

Colorbuild Plus: Acrylic and polyester resins
Colorbuild Plus Hardeners: Polyisocyanate resin

Colorbuild Plus

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Surface preparation



Remove contamination using an appropriate cleaner.



Final dry sanding steps; P280 – P320

For detailed surface preparation see TDS S8.06.02



Remove contamination using an appropriate 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

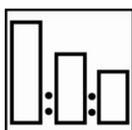
With the exception of the Black and White, Colorbuild Plus colors **must always** be intermixed according to the mixing formulas to achieve the desired color, layer thickness and coverage prior to the addition of hardener, activator or thinner. Colorbuild Plus Black and White can be mixed in each mixing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

Stir thoroughly before adding Colorbuild Plus Hardener.

Stir thoroughly once more before adding reducer.

Under the hood colors



Engine compartments can contain a matt or semi matt finish, so-called under the hood colors.

Colorbuild Plus can be used to imitate such colors.

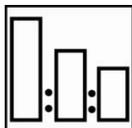
Addition of Autoclear LV Superior Fast / Autoclear 2.0, U is needed to reach the required gloss level.

70	Colorbuild Plus color	100	Under the hood Colorbuild Plus mixture
30	Autoclear LV Superior Fast / Autoclear 2.0	25	Colorbuild Plus Hardener Non Sanding
		35	Colorbuild Plus Activator Non Sanding

Colorbuild Plus

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Mixing



Sanding:

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

Non sanding (wet-on-wet):

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

Plastic application

100	Colorbuild Plus
25	Colorbuild Plus Hardener Non Sanding
35	Colorbuild Plus Plastic Additive (HT)

Note:

Colorbuild Plus under the hood and Colorbuild Plus with Plastic Additive can be used as regular sealers for metal.

When aluminium and galvanized steel is used, it should be preceded by Washprimer 1K CF

Flexible parts

Sanding: Once elasticized to the required level, Colorbuild Plus can be applied on plastic parts. All virgin plastic parts should be pre-coated with a suitable plastic primer, See TDS.S8.06.03.

Non sanding: Colorbuild Plus with Plastic Additive (HT) can be applied directly on all plastics with the exception of pure PE. See TDS.S8.06.03.

Spray gun set-up / application pressure



Spray gun

Fluid tip-set-up

Application pressure

Gravity feed

Sanding

1.5-1.8 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

1.3-1.4 mm

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

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:

Spot application:

Apply one coat over the total sanded area. Flash off until completely matt and apply the 2nd and 3rd coat within each preceding coat. Flash off until completely matt after each coat.

Panel application:

Apply 2-3 coats and flash off until completely matt after each coat.

Non sanding

Apply 1 full wet coat over the total area.

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Drying time sanding



1½ hours at 20°C

45 minutes at 40°C

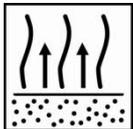
30 minutes at 60°C

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.

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

- *For detailed surface preparation see TDS S8.06.02*



Final sanding step P1000

- *For detailed surface preparation see TDS S8.06.02*



Remove contamination using an appropriate cleaner.

Recoatable with

Autowave
Autowave 2.0
Autocryl Plus LV

Film thickness

Sanding	Per coat :	40-45 µm
	3 coats:	120-130 µm
Non sanding /wet-on-wet;	1 coat	25-30 µm

Colorbuild Plus

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

- **Sanding:** Ready for use mixture at 1 µm dry film thickness: 400 m²/liter
- **Wet-on-wet:** Ready for use mixture at 1 µm dry film thickness: 389 m²/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**2004/42/IIB(c)(540)540**

The EU limit value for this product (product category: IIB. c) in ready to use form is max. 540 g/liter of 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*

Akzo Nobel Coatings LTD

Address: Unit 2B, Didcot Park
Churchward, Southmead Industrial Estate
Didcot, Oxfordshire, OX11 7HB
Tel: +44 (0)1235 862226

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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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Head Office

AkzoNobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. www.sikkenscr.com