

Colorbuild Plus

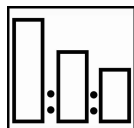
FOR PROFESSIONAL USE ONLY

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.

Sanding

EMEA



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



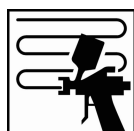
Use Sikkens measuring stick

35 Orange

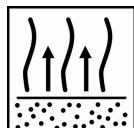


Spray gun set-up:
1.5-2.0 mm

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

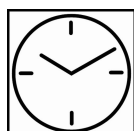


2-3 x 1 coat



Between coats:
4-6 minutes at 20°C

Before curing:
4-6 minutes at 20°C



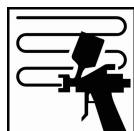
1 ½ hours at 20°C
3 coat application

45 minutes at 40°C

30 minutes at 60°C



Final sanding step: P500
See TDS S8.06.02



Recoat 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

Colorbuild Plus

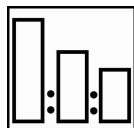
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Wet on wet

EMEA



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



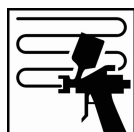
Use Sikkens measuring stick

5 Orange

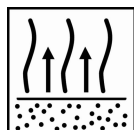


Spray gun set-up:
1.3-1.5 mm

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

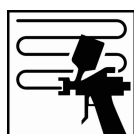


1 coat



Flash-off time:
15 minutes at 20°C

Recoat within:
24 hours at 20°C



Recoatable with all Sikkens topcoats



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Colorbuild Plus

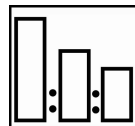
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Sanding

US

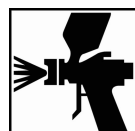


3 Colorbuild Plus
1 Colorbuild Plus Surfacer Hardener
1 Colorbuild Plus Surfacer Activator Medium / Activator Spot & Panel



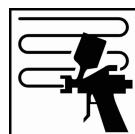
Use Sikkens measuring stick

9 Grey

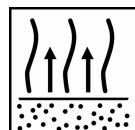


Spray gun set-up:
1.5-2.0 mm

Application pressure:
28-30 psi at the air inlet
HVLP max 8-10 psi at the air cap

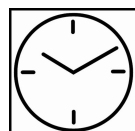


2-3 x 1 coat



Between coats:
4-6 minutes at 70°F

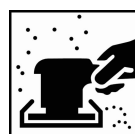
Before curing:
4-6 minutes at 70°F



1 ½ hours at 70°F
3 coat application

45 minutes at 100°F

30 minutes at 140°F



Final sanding step: P500
See TDS S8.06.02



Recoatable with all Sikkens topcoats



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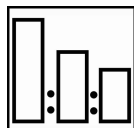
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Wet on wet US



100 Colorbuild Plus
25 Colorbuild Plus Sealer Hardener
35 Colorbuild Plus Sealer Reducer



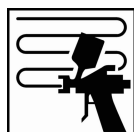
Use Sikkens measuring stick

5 Orange

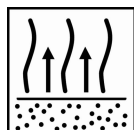


Spray gun set-up:
1.3-1.5 mm

Application pressure:
28-30 psi at the air inlet
HVLP max 8-10 psi at the air cap



1 coat

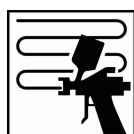


Flash-off time:

15 minutes at 70°F

Recoat within:

24 hours at 70°F



Recoatable with all Sikkens topcoats



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Colorbuild Plus

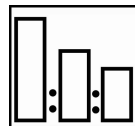
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Description

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Sanding

APAC



4 Colorbuild Plus
1 Hardener P25
1 Plus Reducer



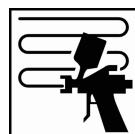
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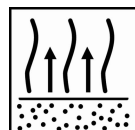


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1.5-2.0 mm

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

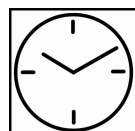


Between coats:

4-6 minutes at 20°C

Before curing:

4-6 minutes at 20°C



3 hours at 20°C

45 minutes at 40°C

30 minutes at 60°C

3 coat application



Final sanding step: P500
See TDS S8.06.02



Recoat with all Sikkens topcoats



Use suitable respiratory protection

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Read complete TDS for detailed product information

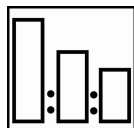
Colorbuild Plus

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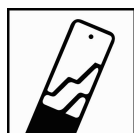
Description

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 APAC



3 Colorbuild Plus
1 Hardener P25
1 Plus Reducer



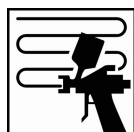
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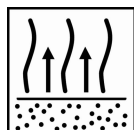


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Application pressure:
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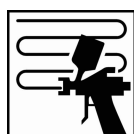


1 coat



Flash-off time:
15 minutes at 20°C

Recoat within:
24 hours at 20°C



Recoatable with all Sikkens topcoats



Use suitable respiratory protection
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Colorbuild Plus

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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.

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

	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
Only when plastic parts are properly pretreated, sanded and cleaned
On all plastics, with the exception of pure PE and PP-E/P blends.
When mixed with Colorbuild Plus Plastic Additive no plasticizer is needed
- 3) Surfaces should be thoroughly cleaned and degreased

Product and additives

Products	Colorbuild Plus White, Black, Red, Blue, Green, Yellow Colorbuild Plus Dark Grey, Light Grey	
Hardeners	Colorbuild Plus Hardener Sanding Colorbuild Plus Hardener Non Sanding Colorbuild Plus Sealer Hardener Colorbuild Plus Sealer Hardener Slow Hardener P25	
Activator	Colorbuild Plus Activator Sanding Extra Fast: Colorbuild Plus Activator Sanding Fast: Colorbuild Plus Activator Sanding Slow: Colorbuild Plus Activator Non Sanding	spot repairs and application at lower temperatures. spot and panel repairs. application on larger surfaces and at higher temperatures
Reducers	Colorbuild Plus Sealer Reducer Slow Colorbuild Plus Sealer Reducer Extra Slow	
Additives	Colorbuild Plus Underhood Activator (US) Elast-O-Activ: Colorbuild Plus Plastic Additive (HT): All Plastic Primer Reducer (US): Autocryl Structure Paste Fine:	See TDS S8.06.03 for non sanding application on plastics. See S8.06.03 for non sanding application on plastics. See S8.06.03 SeeTDS 6.57

Colorbuild Plus

FOR PROFESSIONAL USE ONLY

Basic raw materials

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

Surface preparation



Remove contamination using an appropriate cleaner



Final dry sanding steps; P220 - 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 thoroughly before mixing.

Mixing Colorbuild Plus colors

With the exception of the Black and White, Colorbuild Plus colors **must always** be intermixed according to mixing formulas.

Colorbuild Plus Black and White can be intermixed according to the Quick-Mix table below

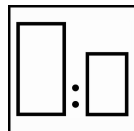
Black - White		
0 : 100	White	
1 : 5	Light grey	
1 : 2	Medium light grey	
1 : 1	Medium grey	
2 : 1	Medium dark grey	
5 : 1	Dark grey	
100 : 0	Black	

*Stir thoroughly before adding hardener.
Stir thoroughly once more before adding reducer.*

Colorbuild Plus

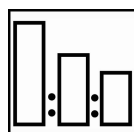
FOR PROFESSIONAL USE ONLY

Under the hood colors



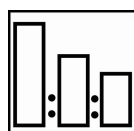
Engine compartments can contain a matt or semi matt finish, so-called under the hood colors. Colorbuild Plus can be used to imitate such colors. Addition of Autoclear LV Superior Fast / Autoclear 2.0, Under the hood Activator (US) or Autoclear Plus HS is needed to reach the required gloss level.

Colorbuild Plus : Autoclear LV Superior Fast / Autoclear 2.0	70:30
Colorbuild Plus : Under the hood Activator	70:30
Colorbuild Plus : Autoclear Plus HS	80:20



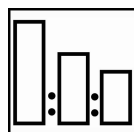
100	LV Superior Fast / 2.0	100
25	Under the hood Colorbuild Plus mixture	25
35	Colorbuild Plus Hardener Non Sanding	25
	Colorbuild Plus Activator Non Sanding	35

Under the hood Activator
Under the hood Colorbuild Plus mixture
Colorbuild Plus Sealer Hardener
Colorbuild Plus Sealer Reducer



3	Autoclear Plus HS
1	Under the hood Colorbuild Plus mixture
1	Hardener P25
1	Plus Reducer

Mixing



Sanding:

3	EMEA	4	APAC
1	Colorbuild Plus	1	Colorbuild Plus
10%	Colorbuild Plus Hardener Sanding	1	Hardener P25
	Colorbuild Plus Activator Sanding	1	Plus Reducer

US

3	Colorbuild Plus
1	Colorbuild Plus Surfacer Hardener
1	Colorbuild Plus Surfacer Activator Medium / Activator Spot & Panel

Non sanding (wet-on-wet):

100	EMEA	3	APAC
25	Colorbuild Plus	1	Colorbuild Plus
35	Colorbuild Plus Hardener Non Sanding	1	Hardener P25
	Colorbuild Plus Activator Non Sanding	1	Plus Reducer
100	US	100	Plastic application
25	Colorbuild Plus	25	Colorbuild Plus
35	Colorbuild Plus Sealer Hardener Slow	25	Colorbuild Plus Hardener Non Sanding
	Colorbuild Plus Sealer Reducer (Extra) Slow	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

Colorbuild Plus

FOR PROFESSIONAL USE ONLY

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 can be applied directly on all plastics with the exception of pure PE and PP-E/P blends. 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

28-30 psi / 1.7-2.2 bar at the spray gun air inlet
HVLP max 8-10 psi / 0.6-0.7 bar at the air cap

Gravity feed

Non sanding

1.3-1.5 mm

28-30 psi / 1.7-2.2 bar at the spray gun air inlet
HVLP max 8-10 psi / 0.6-0.7 bar at the air cap

Pot-life

Colorbuild Plus Activator Sanding Extra Fast and Fast

35 minutes at 70°F / 20°C

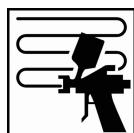
Colorbuild Plus Activator Sanding Slow

1 hour at 70°F / 20°C

Colorbuild Non Sanding

1 hour at 70°F / 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.

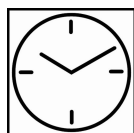
Panel application:

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

Non sanding

Apply 1 full wet coat over the total area.

Drying time sanding



1½ hours at 70°F / 20°C

45 minutes at 100°F / 40°C

30 minutes at 140°F / 60°C

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



Allow 5 minutes flash-off prior to infra red curing

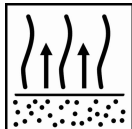
The panel temperature should not exceed 100°C.

For additional information, see TDS S9.01.01

Colorbuild Plus

FOR PROFESSIONAL USE ONLY

Flash-off time wet-on-wet



Allow for a minimum flash-off time of 15 minutes at 70°F / 20°C before topcoat application.
Apply topcoat within 24 hours at 70°F / 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

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
Autobase Plus
Autocryl Plus
Autocryl Plus LV

Film thickness

Sanding	per coat	1.6 - 1.8 mils	40 - 45 µm
	3 coats	4.8 - 5.2 mils	120 - 130 µm
Wet-on-wet	1 coat	1.0 - 1.2 mils	25 - 30 µm

Theoretical coverage

	sq.ft/liter	m ² /liter
Sanding: Ready for use mixture at 1 µm dry film thickness:	4306	400
Wet-on-wet: Ready for use mixture at 1 µm dry film thickness:	4187	389

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

Colorbuild Plus

FOR PROFESSIONAL USE ONLY

Cleaning of equipment

Sikkens Solvent 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 70°F / 20°C.
Avoid extreme temperature fluctuation.

- Product shelf life data see TDS S9.01.02

Akzo Nobel Car Refinish bv.

Address: Rijksstraatweg 31, PO Box 3, 2170 BA Sassenheim

Tel: +31(0)71308-6944

FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

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

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