

**Description**

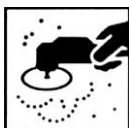
Colorbuild Plus is a versatile undercoat system that consists of six colored primers. When mixed together in proper combinations, primer surfacer or primer sealers closely resembling the most popular OEM under hood primers can be achieved. For small repairs Colorbuild Plus can be used as a direct to metal primer.

**Primer Surfacer**



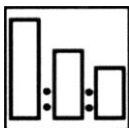
**Safety Considerations**

Use suitable personal protection.  
AkzoNobel Car Refinishes recommends the use of a fresh air supply respirator.  
Refer to the product Material Safety Data Sheet (MSDS) for more complete safety information.



**Preparation for Primer Surfacer**

- Polyester bodyfiller final sanded with #P180 to #P220 grit sand paper dry.
- Existing OEM finishes final sanded with #P220 to #P360 grit sand paper dry.



**Mixing**

- |          |   |
|----------|---|
| <b>3</b> | Colorbuild Plus   |
| <b>1</b> | Colorbuild Plus Surfacer Hardener                           |
| <b>1</b> | Colorbuild Plus Surfacer Activator Medium or Spot and Panel |



**HVLP or Compliant Spray-Gun Set-Up:**

1.7 – 2.0 mm

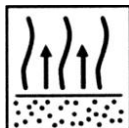
**Application Air Pressure:**

Consult spray gun manufacturers' specifications.  
HVLP maximum 10 psi at the air cap.



**Application**

2 – 3 x 1 Coats



**Flash Between Coats at 70°F (20°C)**

4 – 6 Minutes between coats.

**Flash Before Force Drying at 70°F (20°C)**

4 – 6 Minutes before curing.



**Dry to Sand – 3 Coats**

- 90 Minutes at 70°F (20°C)
- 45 Minutes at 100°F (40°C)
- 30 Minutes at 140°F (60°C)

**Dry to Sand – Infra-Red**

- Low Power 5 Minutes
- Full Power 10 Minutes



**As a Sanded Primer Surfacer Re-Coatable with:**

- All Sikkens primer sealers
- All Sikkens top-coats

Read complete TDS for detailed product information.

**Description**

Colorbuild Plus is a versatile undercoat system that consists of six colored primers. When mixed together in proper combinations, primer surfacer or primer sealers closely resembling the most popular OEM under hood primers can be achieved. For small repairs Colorbuild Plus can be used as a direct to metal primer.

**Primer Sealer**



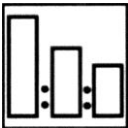
**Safety Considerations**

Use suitable personal protection.  
AkzoNobel Car Refinishes recommends the use of a fresh air supply respirator.  
Refer to the product Material Safety Data Sheet (MSDS) for more complete safety information.



**Preparation for Primer Sealer**

- OEM factory E-Coat thoroughly cleaned requires no sanding except for defects.
- Existing finishes final sanded with #P320 to #P400 dry or #P500 to #P600 wet sand paper.



**Mixing**

- |            |   |
|------------|---|
| <b>100</b> | Colorbuild Plus   |
| <b>25</b>  | Colorbuild Plus Sealer Hardener or Sealer Hardener Slow |
| <b>35</b>  | Colorbuild Plus Sealer Reducer or Sealer Reducer Slow   |

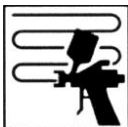


**HVLP or Compliant Spray-Gun Set-Up:**

1.4 – 1.5 mm

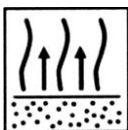
**Application Air Pressure:**

Consult spray gun manufacturers' specifications.  
HVLP maximum 10 psi at the air cap.



**Application**

1 x 1 Coats

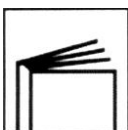


**Flash before Top-Coat at 70°F (20°C)**

15 Minutes minimum

**Maximum Re-Coat Window at 70°F (20°C)**

4 Hours maximum



**As a Wet-On-Wet Primer Sealer Re-Coatable with:**

- All Sikkens top-coats

Read complete TDS for detailed product information.

**Description**

Colorbuild Plus is a versatile undercoat system that consists of six colored primers. When mixed together in proper combinations, primer surfacer or primer sealers closely resembling the most popular OEM under hood primers can be achieved. For small repairs Colorbuild Plus can be used as a direct to metal primer.

**Suitable Substrates**

- Existing finishes
- Steel
- Aluminum
- Galvanized steel
- OEM E-Coat (electro-coat)
- AutoPrep Wipes or AutoPrep Pen
- Glass reinforced laminates (GRP) with intact and un-broken surface
- Polyester body filler
- Sikkens Polysurfacer
- Non-Polyolefin type plastics
- Sikkens Primer PO

- 1) For many applications, Colorbuild Plus can be used as a direct-to-metal primer.
- 2) Although Colorbuild Plus provides adequate adhesion to bare metal, repairs which require extensive metal priming such as whole panels or panels that have had the existing paint system completely removed should be pre-treated with AutoPrep Pre-Treatment Wipes.
- 3) Under no circumstances should Colorbuild Plus be applied to glass reinforced laminates (GRP) that have the gel-coat or surface coating broken through. Polysurfacer should be used for these repairs.
- 4) Before painting plastic refer to the Plastic Identification and Systems Technical Data Sheet for specific information about painting plastics.

**Products and Additives**

- Product**
- **Colorbuild Plus** – White, Black, Red, Blue, Green, Yellow

- Hardeners**
- **Colorbuild Plus Surfacer Hardener** – Used for all primer surfacer mixtures.
  - **Colorbuild Plus Sealer Hardener** – Standard sealer hardener for small to medium sized repairs. Temperature range between 65°F (18°C) and 90°F (32°C).
  - **Colorbuild Plus Sealer Hardener Slow** – Sealer hardener for larger repairs and higher temperatures. Normally used above 90°F (32°C). Use in combination with Colorbuild Sealer Reducer Slow.

- Activators / Reducers**
- **Colorbuild Plus Surfacer Activator Medium** – A standard surfacer activator for use on larger repairs. Temperature range of 75°F (24°C) and above.
  - **Colorbuild Plus Surfacer Activator Spot & Panel** – Surfacer activator for small to medium sized repairs. Temperature range between 65°F (18°C) and 85°F (29°C).
  - **Colorbuild Sealer Reducer** – A standard reducer for sealer mixtures intended for small to medium sized repairs. Temperature range between 65°F (18°C) and 90°F (32°C).
  - **Colorbuild Plus Sealer Reducer Slow** – Used for larger sealer applications or higher temperatures. To enhance application it may be used with Colorbuild Plus Sealer Hardener. To improve application and pot-life it is used with Colorbuild Sealer Hardener Slow. Temperature range between 65°F (18°C) and 90°F (32°C).

**FOR PROFESSIONAL USE ONLY**

**Additives**

- **Elast-O-Actif** – For use on flexible parts. When mixed in Colorbuild Plus it increases the flexibility of both surfacer and sealer mixtures.
- **Colorbuild Plus Under Hood Additive** – Can be used to make a single application, colored matt under hood coating for cutting in parts.
- **Sikkens SuperTop** – A special accelerator used to speed curing for spot repairs. Speeds curing and cuts pot life by approximately 50%.
  - 1) For use in primer surfacer only. Do not use in sealer.
  - 2) Careful mixing is important to maintain the quality of the primer. Do not use more than ½ ounce per ready to spray (RTS) quart or 15 ml per RTS liter of primer surfacer.
  - 3) Accelerated Colorbuild Plus should not be used on bare metal. It may be used over the AutoPrep Pre-Treatment Wipes or AutoPrep Pen material.

**Basic Raw Materials**

- Colorbuild Plus Primer - Acrylic and polyester resins
- Colorbuild Plus Hardeners - Polyisocyanate resins
- Colorbuild Plus Activators - Activated solvents
- Colorbuild Plus Reducers - Activated solvents
- Additives - Refer to individual TDS for information.

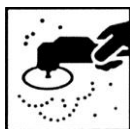
**Substrate Preparation**



**Pre-Cleaning**

- If needed pre-wash the repair with warm soap and water. Rinse completely with clean water.
- Clean with Sikkens M600, Autoclean or Anti-Static surface cleaners.
- Avoid saturating body filler with water or cleaners while washing the repair.

**Sanding Preparation**



- Existing Finishes
- OEM E-Coat
- Polyester Bodyfiller
- Steel
- Galvanized Steel
- Aluminum
- Gel-Coat
- Polyolefin Plastic
- Non-Polyolefin Plastic

	Colorbuild Plus Surfacer	Colorbuild Plus Sealer	
	Dry Sanding	Dry Sanding	Wet Sanding
Existing Finishes	#P220 to #P360	#P320 – #P400	#P500 – #P600
OEM E-Coat	Not Required	Not Required	Not Required
Polyester Bodyfiller	#P180 to #P220	N / A	N / A
Steel	#P80 then #P120	#P80 then #P120	N / A
Galvanized Steel	#P120 to #P180	#P120 – #P180	N / A
Aluminum	#P180 or Red Scuff Pad	#P180 – Red Pad	N / A
Gel-Coat	#P220 to #P360	#P320 – #P400	#P500 – #P600
Polyolefin Plastic	#P320 to #P400	#P400	#P500 – #P600
Non-Polyolefin Plastic	##P320 to #P400	#P320 – #P400	#P500 – #P600



**Surface Cleaning**

- Clean with Sikkens M600, Autoclean or Anti-Static surface cleaners prior to priming.

**Pre-Treatment of Bare Substrates**

**Pre-Treatment**

- Colorbuild Plus provides adequate adhesion to small bare metal areas. For larger areas or for improved corrosion protection Colorbuild Plus should be applied over a metal pre-treatment such as the AutoPrep Pre-Treatment Wipes or AutoPrep pen materials.
- Polyolefin plastics require a pre-treatment adhesion promoter. Prime polyolefin plastics with Primer PO or Primer PO LV prior to the application of flexed Colorbuild Plus. For more information about painting plastic refer to the Plastic Identification and Systems Technical Data Sheet.

**Product Agitation**



**Stirring**

- Because Colorbuild Plus is a high solids product it needs to be thoroughly agitated before use.
- Before installing a mixing lid on a new can of Colorbuild Plus shake on a mechanical shaker for a minimum of 10 minutes to ensure a consistent mixture.
- Stir the several times per day.
- Stir after primer formula is completed, after the addition of hardener and again after adding activator or reducer for the most complete mixing.

**Mixing Colorbuild Plus Colors**

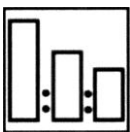
**Formulas**

- A wide range of Colorbuild Plus formulas are available to match the most popular OEM primer colors. These are available on formula swatches or in MixitPro.

**Hand Mixing Colors**

- Colors can be custom mixed. However it is important to include Colorbuild Plus White and/or Black to all colors. This includes adding black to white or white to black for example.

**Mixing – Primer Surfacer**



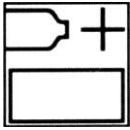
#9 Stick

**Surfacer**

- 3 Parts by volume Colorbuild Plus
  - 1 Parts by volume Colorbuild Plus Surfacer Hardener
  - 1 Parts by volume Colorbuild Plus Surfacer Activator
- Use the Sikkens #9 (Gray) measuring stick when mixing by hand.

**Mixing – Primer Surfacer with Accelerator**

Only use accelerator in Colorbuild Plus Surfacer. Do not add more than stated amount to maintain product quality.



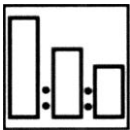
1 quart  
+  
½ ounce

**Accelerated Surfacer**

Colorbuild Plus Surfacer – Mixed ready to spray with hardener and activator.

Sikkens SuperTop Accelerator and stir thoroughly.

**Mixing – Primer Sealer**



#5 Stick

100  
25  
35

**Sealer**

Parts by volume Colorbuild Plus

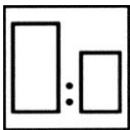
Parts by volume Colorbuild Plus Sealer Hardener

Parts by volume Colorbuild Plus Sealer Reducer

Use the Sikkens #5 (Orange) measuring stick when mixing by hand.

**Mixing – Flexible Parts**

If the part to be can be deformed by hand, increase the flexibility of Colorbuild Plus as follows.



#9 Stick

3  
1

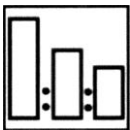
**Make a Mixture of**

Parts by volume Colorbuild Plus

Parts by volume Elast-O-Actif

Use the Sikkens #9 (Gray) measuring stick when mixing by hand.

**Stir the paint and Elast-O-Actif mixture together then step #2 mix surfacer or sealer –**



#9 Stick

3  
1  
1

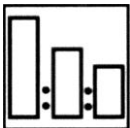
**Surfacer**

Parts by volume Colorbuild Plus / Elast-O-Actif mixture (Previous step)

Parts by volume Colorbuild Plus Surfacer Hardener

Parts by volume Colorbuild Plus Surfacer Activator

Use the Sikkens #9 (Gray) measuring stick when mixing by hand.



#5 Stick

100  
25  
35

**Sealer**

Parts by volume Colorbuild Plus / Elast-O-Actif mixture (Previous step)

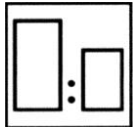
Parts by volume Colorbuild Plus Sealer Hardener

Parts by volume Colorbuild Plus Sealer Slow Reducer

Use the Sikkens #5 (Orange) measuring stick when mixing by hand.

**Mixing – Under Hood Colors**

Under the hood or deck lid, in the engine compartment or even in door jambs some cars have a solid color matt finish. More and more vehicles use these so called under hood colors. Colorbuild Plus can be used to imitate the most popular colors with the use of Colorbuild Plus Under Hood Additive. When used it provides an eggshell gloss level of approximately 40 gloss units (GU at 60° viewing angle). This option also offers adequate mar and stain resistance for under hood applications. Colorbuild Plus Under Hood Colors can also be used as primer sealer on the entire part when painting pieces off of the car. Colorbuild Plus Under Hood cannot be used on bare aluminum and when used as a sealer on the outside of parts, it must be top-coated.



#5 Stick

**100**  
**60**

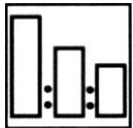
**Make a Mixture of**

Parts by volume Colorbuild Plus color formula

Parts by volume Colorbuild Plus Under Hood Additive

- Use the Sikkens #5 (Orange) measuring stick. Colorbuild Plus in the first column then to the top of the orange bar of the number in the right (:35) column with the Under Hood Additive.

**Stir the Colorbuild Plus with Under Hood Additive mixture together then step #2 further mix –**



#5 Stick

**100**  
**25**  
**35**

**Under Hood Color**

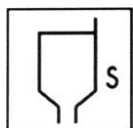
Parts by volume Colorbuild Plus / Under Hood Additive mixture (Previous step)

Parts by volume Colorbuild Plus Sealer Hardener

Parts by volume Colorbuild Plus Surfacer Activator Medium or Spot and Panel

Use the Sikkens #5 (Orange) measuring stick when mixing by hand.

**Viscosity When Mixed**



DIN #4

**Seconds**  
**17 – 22**  
**16 – 19**  
**15 – 19**

**Measured with a DIN #4 viscosity cup at 70°F (20°C).**

Colorbuild Plus Surfacer – Sanding

Colorbuild Plus Sealer – Non-Sanding

**Colorbuild Plus Under Hood Sealer Color**

**Pot-Life When Mixed**

<b>Product Mix</b>	<b>70°F (20°C)</b>	<b>85°F (35°C)</b>
Colorbuild Plus Primer Surfacer	60 – 85 Minutes	30 – 35 Minutes
Colorbuild Plus Primer Surfacer – With SuperTop Accelerator	20 – 25 Minutes	15 Minutes
Colorbuild Plus Primer Sealer	35 – 45 Minutes	20 – 30 Minutes
Colorbuild Plus Primer Sealer – With Slow Hardener and Slow Reducer	90 – 120 Minutes	30 – 40 Minutes
Colorbuild Plus Under Hood Sealer Color	60 – 70 Minutes	30 – 35 Minutes



**Spray Gun Set-Up**

Consult spray gun manufactures instructions for specific spray gun pressure specifications.

**SURFACER**



Surfacer Spray Guns	Fluid Tip	Application Pressure
HVLP Gravity Fed	1.7 – 2.0mm	29 psi at the spray gun inlet (Maxium10 psi at cap).
Compliant Gravity Fed	1.7 – 2.0mm	29 to 35 psi at the spray gun inlet.

**SEALER**



Sealer Spray Guns	Fluid Tip	Application Pressure
HVLP Gravity Fed	1.4 – 1.5mm	29 psi at the spray gun inlet (Maxium10 psi at cap).
Compliant Gravity Fed	1.4 – 1.5mm	29 to 35 psi at the spray gun inlet.

**Application**

**Primer Surfacer**

- Apply 2-3 single wet coats. For use on repair (polyester bodyfiller) or sanded areas apply one coat over the repair, and then after a flash dry apply the second and third coats.
  - Flash off between the coats until the surface becomes totally matt, this will depend on ambient temperature, applied thickness/wetness and airflow.
  - Alternate application; Colorbuild Plus mixed as a surfacer (3:1:1) may be used wet-on-wet when edging in parts. For this, apply one coat of Colorbuild Plus. Apply topcoat after 15 minutes to a maximum of 45 minutes at 70°F (20°C).



**Primer Sealer**

- Apply 1 thin but flowing coat over the desired area.
  - Over any sand through areas, first apply a thin coat to make all the substrate layers uniform before continuing with a normal coat.

**Under Hood Sealer Color**

- Apply 1-2 thin but flowing coats. If two coats are applied, flash between coats.

**Film Thickness – Using Suitable Application**

**Primer Surfacer**

- 3 Coats will achieve a thickness of 4.8 – 5.2 mils (120 – 130µm).

**Primer Sealer**

- 1 Coat will achieve a thickness of 1.0 – 1.2 mils (25 – 30µm).

**Under Hood Color**

- 1 Coat will achieve a thickness of 1.0 – 1.2 mils (25 – 30µm).



**Drying / Curing Time – Primer Surfacer**

Times are stated following recommended application method, film thickness and object temperature.

**Primer Surfacer Air Dry**



- 90 Minutes at 70°F (20°C)
- 45 Minutes at 100°F (40°C)
- 60 Minutes 70°F (20°C) when mixed with SuperTop Accelerator.

**Primer Surfacer Force Dry Bake**

- 30 Minutes at 140°F (60°C)
- 12 Minutes at 140°F (60°C) when mixed with SuperTop Accelerator.

**Primer Surfacer Infra-Red Short Wave Curing**

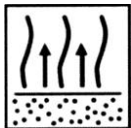


Drying / Curing with short wave light IR equipment and a surface distance of 20 – 27 inches (50 – 70cm). The object temperature must not reach a temperature above 212°F (100°C).

- Allow 3 to 5 minute flash off before infra-red curing.
- Cure 5 minutes on low power followed directly by a 10 minute full power cure.

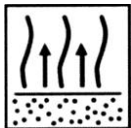
**Drying Flash Time – Primer Sealer**

**Primer Sealer Flash Time**



- Prior to top-coating primer sealer, allow a minimum flash off time of 15 minutes at 70°F (20°C).
- May be sanded to de-nib after a minimum flash dry time of 15 – 20 minutes at 70°F (20°C). Extend flash prior to de-nibbing if Elast-O-Actif was added during mixing.
- Maximum re-coat time when using Colorbuild Sealer Hardener and Colorbuild Plus Sealer Reducer is 60 minutes at 70°F (20°C).
- Maximum re-coat time when using Colorbuild Sealer Hardener Slow and Colorbuild Plus Sealer Reducer Slow is 4 hours at 70°F (20°C).
- If the maximum flash time be exceeded, Colorbuild Plus sealer must be sanded prior to topcoat application, with #P500 to #P600 dry or #P800 wet sand paper.

**Flash Time / Dry Time – Under Hood**



**Under Hood Sealer Color Flash Time**

- Prior to top-coating Colorbuild Plus Under Hood used as a sealer, allow a minimum flash off time of 15 minutes at 70°F (20°C). Maximum flash time of 1 hour.



**Under Hood Sealer Color – Dry to Handle Time**

- One coat at 70°F (20°C) dry to handle in 15 minutes.
- One coat at 80°F (27°C) dry to handle in 10 minutes.

**Final Preparation – For Top Coat Application**



**Dry Sanding – Machine**

- When dry sanding, respect a maximum 200 sanding grit step or less throughout sanding.
- Initial sanding may be done with #P320 to P400.
- Final sanding should be done using #P500 to #P600 before application of Sikkens top-coats.



**Wet Sanding – By Hand**

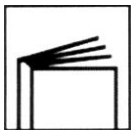
- When wet sanding, respect a maximum 200 sanding grit step or less throughout sanding.
- Initial sanding may be done with grits courser than #P600.
- Final sanding should be completed using #P800 before application of Sikkens top-coats.



**Surface Cleaning**

- Clean with Sikkens M600, Autoclean or Anti-Static surface cleaners prior to top-coating.

**Re-Coating**



- Sikkens Colorbuild Plus can be re-coated with all Sikkens sealers and top-coats.

**Cleaning of Equipment**



Clean equipment following local and federal regulations. For national rule regions, use Sikkens Cleaning Solvent 790 or high quality lacquer thinner.

**Theoretical Coverage**

Theoretical coverage is dependent of many factors. These may include; the shape of the object, surface smoothness and application technique variables among others.

- |                                 |  |
|---------------------------------|--|
| Colorbuild Plus Primer Surfacer | - Per coat of ready to spray paint 104 ft <sup>2</sup> / liter (9.6m <sup>2</sup> /liter). |
| Colorbuild Plus Primer Sealer   | - Per coat of ready to spray paint 100 ft <sup>2</sup> / liter (9.2m <sup>2</sup> /liter). |



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VOC / Regulatory Information

System	Mix Ratio	VOC
- Primer Surfacer	3:1:1	4.64 lb/gal (557g/liter)
- Primer Sealer	100:25:35	4.51 lb/gal (540g/liter)
- Flexible Parts, Primer Surfacer	3:1 with E-O-A then 3:1:1	4.71 lb/gal (564g/liter)
- Flexible Parts, Primer Sealer (Slow Reducer Only)	3:1 with E-O-A then 100:25:35	4.51 lb/gal (540g/liter)
- Under Hood Additive – Sealer	100:60 with UHA then 100:25:35	4.56 lb/gal (547g/liter)

Product Storage

Stock unopened or used products in approved closed containers with proper labeling. Store in moderate temperatures between 40°F - 95°F (5°C – 35°C). Avoid too much temperature fluctuation. Optimum storage temperature is approximately 70°F (20°C).

Colorbuild Plus	2 Years	Colorbuild Plus Surfacer Activator	1 Year
Colorbuild Plus Surfacer Hardener	6 Months	Colorbuild Plus Sealer Reducer	1 Year
Colorbuild Plus Sealer Hardener	6 Months	Under Hood Additive	1 Year

AkzoNobel Car Refinishes Inc, North America  
Address: 3587 Parkway Lane, Norcross GA 30092 USA  
Telephone: 770-662-8464

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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Head Office

AkzoNobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. [www.sikkenscr.com](http://www.sikkenscr.com)

