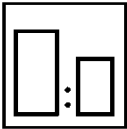


High Build Surfacer Gray

FOR PROFESSIONAL USE ONLY

Description

High Build Surfacer is a medium grey colored primer surface based on 2K polyurethane technology. It is dedicated to fast curing high build primer surfacer for North American market for both National Rule and Low VOC markets in the US and Canada with a simple mixing ratio of 3:1 by volume.



3:1
High Build Surfacer
Colorbuild Plus 250 Hardener



Use Sikkens Measuring Stick #4



3x1
HVLP Gravity
0.067"–0.075" (1.7–1.9 mm)
29 PSI at the spray gun air inlet
Max 10 psi (max 0.8 bar)



3-5 minutes at 70°F (20°C)



3 hours at 70°F (20°C)
30 minutes at 140°F (60°C)



Use suitable respiratory protection
AkzoNobel Car Refinishes recommends to use of a fresh air supply respirator

Read complete TDS for detailed product information



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Product and additives

Product:	High Build Surfacer
Hardener:	Colorbuild Plus 250 Hardener
Additives:	- Primer PO LV - LV Elast-O-Actif

Basic raw materials

- High Build Surfacer :	Based on hydroxylated acrylic resin and polyester resin
- Colorbuild Plus 250 Hardener:	Polyisocyanate resins

Suitable surfaces

- Existing finishes, degreased and sanded with #P220 to #P320 grit paper dry.
- Steel, degreased and sanded with #P80 then #P120 grit dry.
- Aluminum, degreased and sanded with #P150 to #P180 grit dry.
- Galvanized steel, Zinc coated steel
- Autoprep Pre-Treatment Wipes
- Washprimer 1K CF after 15 minutes at 70°F (20°C).

Note: Although High Build Surfacer will provide adequate adhesion and protection if applied directly over bare steel or aluminum, for larger areas we recommend applying one coat of Sikkens etch primers or Autoprep Pre-Treatment Wipes.

Mixing ratio

3 parts by volume of High Build Surfacer
1 part by volume of Colorbuild Plus 250 Hardener
For easy and accurate mixing, use the Sikkens Measuring Stick #4

Plastic parts

For use over plastic body parts, mix High Build Surfacer as follows:

Flexible Parts:

- 90 parts by volume of High Build Surfacer
- 10 parts by volume of LV Elast-O-Actif

This will then require further mixing:

- 3 parts by volume of High Build Surfacer with LV Elast-O-Actif
- 1 part by volume of Colorbuild Plus 250 Hardener



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Spraying viscosity

The proper spraying viscosity is achieved by using the recommended mixing ratio. 20-25 sec (DIN cup #4) at 70°F (20°C).

Pot life

1 hour at 70°F (20°C)

NOTE: As with all chemically drying paints, when the hardener is introduced to the main paint product, a chemical reaction is initiated. Therefore, it is important to apply the mixed paint before the stated pot life has expired. Failure to do this may result in product performance defects.

Spray gun & pressure

	Fluid Tip	Spraying Pressure
HVLP Gravity	0.067"-0.075" (1.7-1.9 mm)	max. 10 psi (max. 0.8 bar)

Application method

Mixture A (Surfacer)

Apply 3 single coats. Allow a 3-5 minutes flash-off time between each coat or until completely mat. The number of coats depends on the film thickness desired. Allow 5-10 minutes flash-off time prior to curing.

Film thickness

2.7 mils per single coat. With the recommended application of 3 single coats, this should provide a dry film thickness of 8.0 mils prior to sanding.

Drying time

	70°F (20°C)	100°F (38°C)	140°F (60°C)
To Sand	3 hours	45 minutes	30 minutes

Note: In extremely dry conditions, the dry time of High Build Surfacer may be slightly extended.

Sanding

Wet: May be presanded with #P400 grit paper wet, final sand with #P500 to #P600 grit wet.
Dry: May be presanded with #P240 to #P320 grit dry, moving in stages to final sanding with #P400 to #P500 grit dry.

Recoatability

High Build Surfacer can be topcoated with all Sikkens Autobase Plus or Autowave after sanding.

Cover rate

Approximately 198.4 sq. ft./liter of unmixed paint per single coat at 2.7 mils.



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Shelf-life

High Build Surfacer

One years if stored unopened at room temperature.

Safety aspects**Ready to spray VOC:**

High Build Surfacer

3:1

1.95 lb/gal

233 g/liter

Notice: Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Material Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air supplied respirator when exposed to vapors or spray mist.

Akzo Nobel Car Refinishes Inc. North America**Address:** 3587 Parkway Lane, Norcross. GA 30092 USA**Tel:** 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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