

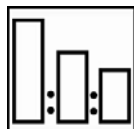
Colorbuild® Plus 250

FOR PROFESSIONAL USE ONLY

Description

Colorbuild Plus 250 consists of six colored primers which, when mixed in proper combination with each other, achieve colors closely resembling the most popular topcoat colors. Colorbuild Plus 250 can be used as either a sanding surfacer or non sanding / wet on wet primer sealer.

Sanding surfacer



100 Colorbuild Plus 250
25 Colorbuild Plus 250 Hardener
25 Colorbuild Plus 250 Activator



Use Sikkens mixing stick

5 (Orange)



Gravity spray gun set-up:
1.7-1.9 mm

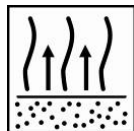
Application pressure:

HVLP Max 10 psi at air cap

➤ Check gun manufacturer specification



3 x 1 coat

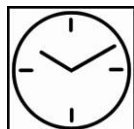


Between coats:

5 – 10 minutes at 70° F (20° C)

Before curing:

5 – 10 minutes at 70° F (20° C)

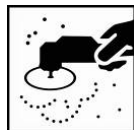


3 coat application

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

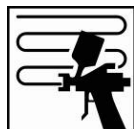


5 minutes low power
5 minutes high power



Sanding for top coat: Final sanding step: #P500 to P600 grit dry

Sanding for sealer: Final sanding step: #P400 to P500 grit dry



Recoatable with all Sikkens sealers and top coats



Use suitable respiratory protection

AkzoNobel Car Refinishes recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information

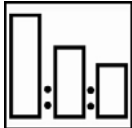
Colorbuild® Plus 250

FOR PROFESSIONAL USE ONLY

Description

Colorbuild Plus 250 consists of six colored primers which, when mixed in proper combination with each other, achieve colors closely resembling the most popular topcoat colors. Colorbuild Plus 250 can be used as either a sanding primer surfacer or non sanding / wet on wet primer sealer.

Non-sanding sealer



- 3 Colorbuild Plus 250
- 1 Colorbuild Plus 250 Hardener
- 1 Colorbuild Plus 250 Activator



Use Sikkens mixing stick

9 grey



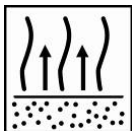
Gravity spray gun set-up:
1.3-1.5 mm

Application pressure:
HVLP Max 10 psi at air cap

➤ Check gun manufacturer specification



1 X 1 coat



Recoat, Wet – On – Wet time:

Recoat within:

15 minutes at 70° F (20° C)

1 ½ hours at 70° F (20° C)



Recoatable with all Sikkens topcoats



Use suitable respiratory protection

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Read complete TDS for detailed product information

Colorbuild® Plus 250

FOR PROFESSIONAL USE ONLY

Description

Colorbuild Plus 250 consists of six colored primers which, when mixed in proper combination with each other, achieve colors closely resembling the most popular topcoat colors. Colorbuild Plus 250 can be used as either a sanding primer surfacer or non sanding / wet on wet primer sealer.

Suitable substrates

Existing finishes	Glass Reinforced Polyester laminates (GRP)
Direct to steel	Polyester bodyfillers
Direct to aluminum	Sikkens Polysurfacer
Direct to galvanized steel	Sikkens Washprimers
OEM electro coat (Ecoat)	Primer PO, aerosol

- For most collision repair applications, Colorbuild Plus 250 can be used as a direct-to-metal primer.
- Although Colorbuild Plus 250 will provide adequate adhesion on bare metal, repairs which require extensive metal priming such as whole panel and panels that have had the existing paint system removed, Colorbuild Plus 250 should be applied over the area treated with AutoPrep Pre-Treatment Wipes or Washprimer EM CF. Ensure complete drying of the area treated with AutoPrep Pre-Treatment Wipes and allow a 30 minutes flash-off at 70°F (20°C) after Washprimer EM CF application.

(GRP) Under no circumstance should Colorbuild Plus 250 be applied if the gelcoat has been broken or sanded through on polyester laminates. Recommended is the use of Polysurfacer.

Product and additives

Products **Colorbuild Plus 250:** White-Black-Red-Blue-Green-Yellow

Hardeners **Colorbuild Plus 250 Hardener:** one hardener for the sanding surfacer and wet-on-wet sealer assemblies.

Activator / Reducers **These Activators are used in the sanding surfacer and wet-on-wet sealer assemblies.**

Colorbuild Plus 250 Spot & Panel Activator: an activator to be used for application on small to medium repairs, temperatures of 65°F (18°C) to 85°F (29°C)

Colorbuild Plus 250 Medium Activator: an activator for small to medium size repairs, temperatures of 75°F (24°C) to 90°F (32°C)

Colorbuild Plus 250 Slow Activator: an activator to be used for application on large repairs, temperatures of 85°F (29°C) and above

Colorbuild Plus 250 Extra Slow Activator: an activator to be used for application on large vehicles, especially suited for the Wet-On-Wet Sealer application and at high temperatures, above 85°F (29°C)

Additives **LV Elast-O-Actif:** an additive to increase the flexibility level of the surfacer and sealer systems, for use on flexible plastic parts.

All Plastic Adhesion Promoter: a special additive to improve adhesion of the Colorbuild Plus 250 undercoat system. For use on untreated, raw plastic parts.

- *To be used in place of Colorbuild Plus 250 Medium Activator (for example).*
- For further information of All Plastic Adhesion Promoter, please see TDS

Colorbuild Plus 250 Under Hood Additive: an additive to use with Colorbuild Plus 250 when application is required for under hood colors. This additive will increase the gloss level to approximately 40 gloss units (GU at 60° viewing angle) [eggshell] and mar and stain resistance for colors that are applied under hood.



Colorbuild® Plus 250

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Basic raw materials

Colorbuild Plus 250:	Acrylic and polyester resins
Colorbuild Plus 250 Hardener:	Polyisocyanate resin
Colorbuild Plus 250 Activators:	Activated solvents

Surface preparation



M600 / Autoclean / Anti-Static, Surface Cleaners

- In areas where VOC emissions regulations apply, use recommended pre-cleaning product.

If necessary, pre-wash the surface with warm water and soap, rinse sufficiently with clean water.



Sanding Surfacers; final dry sanding steps; #P500 to #P600

- Sikkens polyester bodyfillers and Polysurfacer; finish with;#P180 to #P220 grit paper dry.

Wet on Wet Sealer; final dry sanding step #P320 to #P400

- Feather edge sanding in case of repair area, finish with #P400
- Colorbuild Plus 250 can be applied directly to non-sanded, rigid OEM Ecoated parts that have been thoroughly cleaned and degreased.



M600 / Autoclean / Anti-Static, Surface Cleaners

In case of polyester bodyfiller use, avoid contact with water (e.g. waterborne degreaser)

Stir before use



Stir each Colorbuild Plus 250 color thoroughly before use.

After adding Colorbuild Plus 250 Hardener, stir thoroughly prior to adding Colorbuild Plus 250 Activator.

Mixing Colorbuild Plus 250 colors

Colorbuild Plus 250 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 additive. Colorbuild Plus 250 Black and White can be mixed in each mixing ratio.

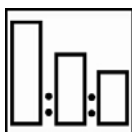
Colorbuild Plus 250 mixtures must be stirred thoroughly before adding Colorbuild Plus 250 Hardener.

Stir thoroughly once more before adding activator.

Colorbuild® Plus 250

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Mixing



Sanding Surfacers:

- 100** Colorbuild Plus 250
- 25** Colorbuild Plus 250 Hardener
- 25** Colorbuild Plus 250 Activator

Use the Sikkens mixing stick
#5 (orange)

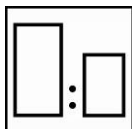
Non sanding sealer (wet-on-wet):

- 3** Colorbuild Plus 250
- 1** Colorbuild Plus 250 Hardener
- 1** Colorbuild Plus 250 Activator

Use the Sikkens mixing stick
#9 (grey)

Under the hood colors

Under the hood and in the engine compartment of some cars a matt finish is present. More and more cars utilize this finish, so-called under hood colors. Colorbuild Plus 250 can be used to imitate such colors with the addition of Colorbuild Plus 250 Under Hood Additive to reach the required semi-gloss level, eggshell (+ - 40GU at 60° angle).

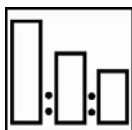


- 100 parts Colorbuild Plus 250 color
- 60 parts Colorbuild Plus 250 Under Hood Additive
 - (mixing stick #5 Orange) Use the left column for Colorbuild Plus 250 and the same number in the far right column (top of the orange stripe) for Under Hood Additive
 - (mixing stick #32 Blue) When spraying straight black CBP250, Underhood Additive should be added at a maximum of 40%

This mixture must be thoroughly stirred before further mixing with hardener and activator.

Further mixed as a sealer

- 3** Mixture of Colorbuild Plus 250 under hood color
- 1** Colorbuild Plus 250 Hardener
- 1** Colorbuild Plus 250 Spot & Panel Activator or Medium Activator
 - Use the Sikkens mixing stick #9 (grey)



Application:

Over thoroughly cleaned and/or sanded OEM E-Coat;
Apply one to two single coats.

- This under hood mixture must not be applied directly to bare aluminum

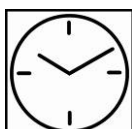


Dry to handle time:

15 minutes at 70° F (20° C) (for one single coat).

10 minutes at 80° F (27° C) (for one single coat).

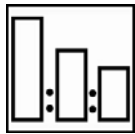
- Drying times relate to recommended application and object temperature.
- Colorbuild Plus 250 under the hood can be used as regular sealer for adjacent metal parts. In this case the maximum recoat time without sanding is 1 hour at 70°F (20°C)



Colorbuild® Plus 250

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Raw Plastic parts



Rigid Plastic:

Sanding Surfacer:

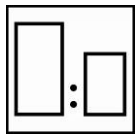
- 100 Colorbuild Plus 250
- 25 Colorbuild Plus 250 Hardener
- 25 All Plastic Adhesion Promoter

Ready To Spray

Non sanding sealer (wet-on-wet):

- 3 Colorbuild Plus 250
- 1 Colorbuild Plus 250 Hardener
- 1 All Plastic Adhesion Promoter

Ready To Spray



Flexible Plastic:

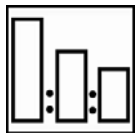
Sanding Surfacer

- 100 Colorbuild Plus 250
- 15 LV Elast-O-Actif

Non sanding sealer (wet-on-wet):

- 100 Colorbuild Plus 250
- 15 LV Elast-O-Actif

Stir before continuing



- 100 Colorbuild Plus 250 with LV Elast-O-Actif
- 25 Colorbuild Plus 250 Hardener
- 25 All Plastic Adhesion Promoter

Ready To Spray

- 3 Colorbuild Plus 250 with LV Elast_O_Actif
- 1 Colorbuild Plus 250 Hardener
- 1 All Plastic Adhesion Promoter

Ready To Spray



3:1:1 = use the # 9 (grey) mixing stick

100:25:25 = use the # 5 (orange) mixing stick

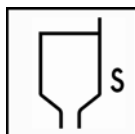
Raw plastic: All Plastic Adhesion Promoter should be used when spraying untreated (raw) plastic parts.

- All Plastic Adhesion Promoter: used to improve adhesion of Colorbuild Plus 250 to hard or flexible raw plastic parts. To be used in either the sanding surfacer or the wet-on-wet sealer systems.

Flexible parts: Once elasticized to the required level, Colorbuild Plus 250 can be applied on flexible parts.

- Colorbuild Plus 250 with All Plastic Adhesion Promoter can be used as regular sealer for adjacent metal parts. Prior to the topcoat application allow a minimum of 10-15 minutes flash off time, up to a maximum of 1 ½ hours at 70°F (20°C).

Viscosity



Sanding Surfacer:

18 – 22 seconds DIN cup #4 at 70°F (20°C)

Non sanding sealer:

14 – 16 seconds DIN cup #4 at 70°F (20°C)

Spray gun set-up / application pressure



Spray gun

Gravity feed

Fluid tip-set-up
Sanding

1.7-2.0 mm

Application pressure

29 psi at the spray gun air inlet
HVLP max 10 psi at the air cap

Wet on wet

Gravity feed

1.3-1.5 mm

29 psi at the spray gun air inlet
HVLP max 10 psi at the air cap

- Check gun manufacturer specification

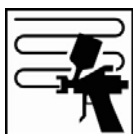
Colorbuild® Plus 250

FOR PROFESSIONAL USE ONLY

Pot-life

	At 70°F (20°C)	Sanding Surfacer:	Non sanding sealer:
Colorbuild Plus 250 Spot and Panel Activator		35 min. at 70°F (20°C)	35 min. at 70°F (20°C)
Colorbuild Plus 250 Medium Activator		50 min. at 70°F (20°C)	50 min. at 70°F (20°C)
Colorbuild Plus 250 Slow Activator		1 ½ hours at 70°F (20°C)	1 ½ hours at 70°F (20°C)
Colorbuild Plus 250 Extra Slow Activator		1 hours at 70°F (20°C)	2 hours at 70°F (20°C)
	At 95°F (35°C)		
Colorbuild Plus 250 Extra Slow Activator		35 min. at 95°F (35°C)	35 min. at 95°F (35°C)

Application



Sanding surfacer; For use on repair (polyester bodyfiller) or sanded areas apply one coat over the repair, and then apply the 2nd and 3rd coat.

Where a full panel application is required, apply 2-3 coats over the total panel

- Flash off between the coats until the surface becomes totally matt, this will depend on ambient temperature, applied layer thickness and airflow.
- **Alternate application;** Colorbuild Plus 250 mixed as a surfacer (4:1:1) may be used wet-on-wet when edging in parts. In this case, apply one coat of Colorbuild Plus 250. Apply topcoat after 15 minutes to a maximum of 45 minutes at 70°F (20°C). After a drying time of longer than 1.5 hours, thorough sanding is necessary for adhesion of top coat

Wet on wet (non sanding sealer)

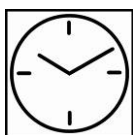
Apply 1 thin but flowing coat over the desired area.

- Over any sand through areas, first apply a thin coat to make all the substrate layers uniform before continuing with the normal coat.

Film thickness when using the recommended application

Sanding Surfacer: (mixing ratio 100:25:25)	1 coat	1.5 – 1.8 mils (37 - 45µm)
	3 coats	4.0 – 5.0 mils (100 -125µm)
Non sanding sealer: (mixing ratio 3:1:1)	1 coat	1.0 – 1.2 mils (25 - 30µm)

Drying time; sanding surfacer



3 hours at 70°F (20°C)

30 minutes at 140°F (60°C)

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



Distance between short wave IR unit and object. 20- 27inches (50-70 cm)

Allow 3 to 5 minutes flash off before Infra red curing

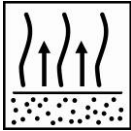
Cure 5 minutes low power setting followed by 5 minutes high power setting.

- The panel must not reach a temperature above 100°C while curing.

Colorbuild® Plus 250

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Flash-off time wet-on-wet Non sanding sealer:



Prior to the topcoat application allow a minimum of 10-15 minutes flash off time up to a maximum of 1 ½ hours at 70°F (20°C).
Should this maximum time be exceeded, Colorbuild Plus 250 wet on wet should be sanded prior to topcoat application, either with #P500 to #P600 dry or #P800 wet sanding paper.

Denibbing wet-on-wet

For minor defects (e.g. dust) Colorbuild Plus 250 can be denibbed with #P500 dry or #P800 wet after 15-20 minutes at 70°F (20°C)
After a drying time of longer than 1 ½ hours thorough sanding is necessary! If sanding is necessary, this may be done after 12 hours at 70°F (20°C) or 45 minutes at 140°F (60°C)

Final sanding; sanding surfacer



Final dry sanding step #P500 to #P600 before application of Sikkens topcoats

- Initial sanding steps may be executed with a coarser sanding grit; #P320 to #P400



Final wet sanding step #P800 before application of Sikkens topcoats.

Initial sanding steps may be executed with a coarser sanding grit #P600.

- 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.



Surface cleaning; remove any surface contamination prior to the application of the topcoat using an appropriate surface cleaner.

- In areas where VOC emissions regulations apply, use recommended pre-cleaning product.

Recoatable with

All Sikkens top coats that are VOC compliant for the area.

Theoretical coverage

Sanding Surfacer: per coat of unmixed paint; 96 sq.ft/liter (9 m²/liter)
Wet-on-wet Sealer: per coat of unmixed paint; 150 sq.ft/liter (14 m²/liter)

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

Cleaning of equipment

Sikkens LV Cleaning Solvent or solvent borne gun cleaner

Colorbuild® Plus 250

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VOC

System	Mix Ratio	VOC
Surfacer	100:25:25;	2.1 lb/gal (250 g/Liter)
Sealer	3:1:1;	2.1 lb/gal (250 g/Liter)
Flexible parts – Surfacer	100:15 with LV E-O-A and then 100:25:25;	2.1 lb/gal (250 g/Liter)
Flexible parts – Sealer	100:15 with LV E-O-A and then 3:1:1;	2.1 lb/gal (250 g/Liter)
Raw Flexible parts – Surfacer	100:15 with LV E-O-A and then 100:25:25 with APAP;	3.25 lb/gal (390 g/Liter)
Raw Flexible parts – Sealer	100:15 with LV E-O-A and then 3:1:1 with APAP;	3.25 lb/gal (390 g/Liter)
Rigid Raw Plastic Parts – Surfacer	100:25:25 with APAP	3.0 lb/gal (360 g/Liter)
Rigid Raw Plastic Parts – Sealer	3:1:1 with APAP	3.25 lb/gal (390 g/Liter)

Product storage

Store products unopened, and used products with closed lids preferably between 50°F-95°F (10°C-35°C)
Avoid too much temperature fluctuation, optimal storage temperature approximately 70°F (20°C)

Colorbuild Plus 250: 1 year Under Hood Additive: 1 year
Colorbuild Plus 250 Hardener: 6 months All Plastic Adhesion Promoter 1 year
Colorbuild Plus 250 Activator : 1 year

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Tel: (+ 1) 770-662-8464

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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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