

Description

Colorbuild Plus 250 is a versatile VOC compliant 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 250 can be used as a direct to metal primer.

Primer Surfacer



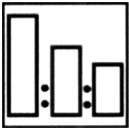
Safety Considerations

Use suitable personal protection.
AkzoNobel recommends the use of a fresh air supply respirator.
Refer to the product Safety Data Sheet (SDS) 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

- | | |
|---|-------------------------------|
| 4 | Colorbuild Plus 250 |
| 1 | Colorbuild Plus 250 Hardener |
| 1 | Colorbuild Plus 250 Activator |



HVLP or Compliant Spray-Gun Set-Up:

1.7 – 1.9 mm

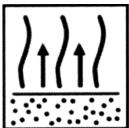
Application Air Pressure:

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 (21°C)

5 – 10 Minutes between coats.

Flash at 70°F (21°C) Before Force Drying

5 – 10 Minutes before curing.

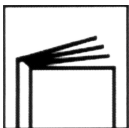


Dry to Sand – 3 Coats

- 3 Hours at 70°F (21°C)
- 30 Minutes at 140°F (60°C)

Dry to Sand – Infra-Red

- Low Power 5 Minutes flash then
- Full Power 10 Minutes bake



As a Sanded Primer Surfacer Re-Coatable with:

- All Sikkens primer sealers
- All Sikkens topcoats

Read complete TDS for detailed product information.

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Primer Sealer



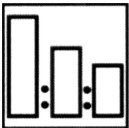
Safety Considerations

Use suitable personal protection.
AkzoNobel recommends the use of a fresh air supply respirator.
Refer to the product Safety Data Sheet (SDS) 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

- 3** Colorbuild Plus 250
- 1** Colorbuild Plus 250 Hardener
- 1** Colorbuild Plus 250 Activator Slow or Extra-Slow



HVLP or Compliant Spray-Gun Set-Up:

1.3 – 1.5 mm

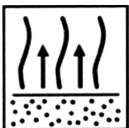
Application Air Pressure:

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



Application

1 x 1 Coats

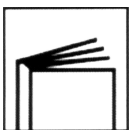


Flash before Top-Coat at 70°F (21°C)

15 Minutes minimum

Maximum Re-Coat Window at 70°F (21°C)

1-1/2 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 250 is a versatile VOC compliant 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 250 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 LV or Primer PO

- 1) For many applications, Colorbuild Plus 250 can be used as a direct-to-metal primer.
- 2) Although Colorbuild Plus 250 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 | <ul style="list-style-type: none"> • Colorbuild Plus 250 – White (Item #397937), Black (Item #397932), Red (Item #397933), Blue (Item #397934), Green (Item #397935), Yellow (Item #397936) |
| Hardeners | <ul style="list-style-type: none"> • Colorbuild Plus 250 Hardener (Item #397938)– Standard hardener for primer surfacer and primer sealer. Temperature range between 65°F (18°C) and 90°F (32°C). • Colorbuild Plus 250 Slow Hardener (Item #484451) – Designed for improved overspray melt-in for high temperature applications. Potlife is shorter when utilizing this hardener. |
| Activators / Reducers | <ul style="list-style-type: none"> • Colorbuild Plus 250 Activator Spot & Panel (Item #397939)– Activator for surfacer mixtures on small to medium sized repairs. Temperature range between 65°F (18°C) and 85°F (29°C). • Colorbuild Plus 250 Activator Medium (Item #397940)– Activator for surfacer used on larger repairs. Temperature range between 75°F (24°C) and 90°F (32°C). • Colorbuild Plus 250 Slow Activator (Item #397941)– A standard activator for surfacer or sealer mixtures intended for small to medium sized repairs. Temperature range between 65°F (18°C) and 90°F (32°C). • Colorbuild Plus 250 Activator Extra Slow (Item #397942)– Used for larger surfacer or sealer mixtures and higher temperatures. Temperature range above 90°F (32°C). |
| Additives | <ul style="list-style-type: none"> • LV Elast-O-Actif (Item #398218)– For use on flexible parts. When mixed in Colorbuild Plus 250 it increases the flexibility of both surfacer and sealer mixtures. • Colorbuild Plus 250 Under Hood Additive (Item #542679)– Can be used to make a single application, colored matt under hood coating for cutting in parts. • LV 250 Accelerator (Item #389353) |

Basic Raw Materials

- Colorbuild Plus 250 Primer
- Colorbuild Plus 250 Hardeners
- Colorbuild Plus 250 Activators
- Additives
- Acrylic and polyester resins
- Polyisocyanate resins
- Activated solvents
- 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 Autoclean surface cleaner.
- Avoid saturating body filler with water or cleaner 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

Dry Sanding

#P220 to #P360

Not Required

#P180 to #P220

#P80 then #P120

#P120 to #P180

#P180 or Red Scuff Pad

#P220 to #P360

#P320 to #P400

#P320 to #P400

Colorbuild Plus Sealer

Dry Sanding

#P320 – #P400

Not Required

N / A

#P80 then #P120

#P120 – #P180

#P180 – Red Pad

#P320 – #P400

#P400

#P320 – #P400

Wet Sanding

#P500 – #P600

Not Required

N / A

N / A

N / A

N / A

#P500 – #P600

#P500 – #P600

#P500 – #P600



Surface Cleaning

- Clean with Sikkens Autoclean surface cleaner or AutoPrep Ultra Prep prior to priming.

Pre-Treatment of Bare Substrates

Pre-Treatment

- Colorbuild Plus 250 provides adequate adhesion to small bare metal areas. For larger areas or for improved corrosion protection Color Build Plus 250 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 LV (or Primer PO in National Rule VOC areas) prior to the application of flexed Colorbuild Plus 250. For more information about painting plastic refer to the Plastic Identification and Systems Technical Data Sheet.

Product Agitation

Stirring



- Because Colorbuild Plus 250 is a high solids it needs to be thoroughly agitated before use.
- Before installing a mixing lid on a new can of Colorbuild Plus 250 shake on a mechanical shaker for a minimum of 10 minutes to ensure a consistent mixture.
- Stir Colorbuild Plus 250 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

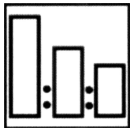
Formulas

- A wide range of Colorbuild Plus 250 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 250 White and/or Black to all colors. This includes adding black to white or white to black for example.

Mixing – Primer Surfacer

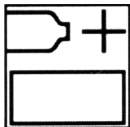


#5 Stick

- | | |
|---|--|
| | Surfacer |
| 4 | Parts by volume Colorbuild Plus 250 |
| 1 | Parts by volume Colorbuild Plus 250 Hardener |
| 1 | Parts by volume Colorbuild Plus 250 Activator |
| | Use the Sikkens #5 (Orange) measuring stick when mixing by hand. |

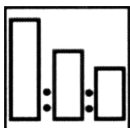
Mixing – Primer Surfacer with Accelerator

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



- | | |
|---------|--|
| | Accelerated Surfacer |
| 1 liter | Colorbuild Plus Surfacer 250 – Mixed ready to spray with hardener and activator. |
| + | |
| 5–7ml | Sikkens LV250 Accelerator and stir thoroughly. (Do not exceed 7 milliliters per ready to spray liter of primer.) |

Mixing – Primer Sealer

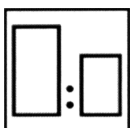


#9 Stick

- | | |
|---|--|
| | Sealer |
| 3 | Parts by volume Colorbuild Plus 250 |
| 1 | Parts by volume Colorbuild Plus 250 Hardener |
| 1 | Parts by volume Colorbuild Plus 250 Activator Slow or Extra Slow |
| | Use the Sikkens #9 (Gray) measuring stick when mixing by hand. |

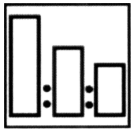
Mixing – Flexible Parts

If the part to be can be deformed by hand, increase the flexibility of Colorbuild Plus 250 as follows:



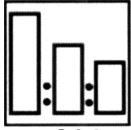
- | | |
|----------|-------------------------------------|
| | Make a Mixture of |
| 100 | Parts by volume Colorbuild Plus 250 |
| 15 parts | Parts by volume LV Elast-O-Activ |

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



#5 Stick

	Surfacer
4	Parts by volume Colorbuild Plus 250 / LV Elast-O-Actif mixture (Previous step)
1	Parts by volume Colorbuild Plus 250 Hardener
1	Parts by volume Colorbuild Plus 250 Activator
	Use the Sikkens #5 (Orange) measuring stick when mixing by hand.

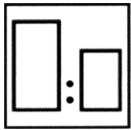


#9 Stick

	Sealer
3	Parts by volume Colorbuild Plus 250 / LV Elast-O-Actif mixture (Previous step)
1	Parts by volume Colorbuild Plus 250 Hardener
1	Parts by volume Colorbuild Plus 250 Activator Slow or Extra Slow
	Use the Sikkens #9 (Gray) measuring stick when mixing by hand.

Mixing – Under Hood Colors

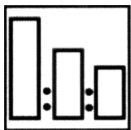
Under the hood or deck lid, in the engine compartment or even in door jambs some cars have a solid color matt finish. More and more vehicles use these so called under hood colors. Colorbuild Plus 250 can be used to imitate the most popular colors with the use of Colorbuild Plus 250 Under Hood Additive. 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 250 Hood Colors can also be used as primer sealer on the entire part when painting pieces off of the car. Colorbuild Plus 250 Under Hood cannot be used on bare aluminum and when used as a sealer on the outside of parts, it must be top-coated.



#32 Stick

	Make a Mixture of
100	Parts by volume Colorbuild Plus 250
40	Parts by volume Colorbuild Plus 250 Under Hood Additive
	o Use the Sikkens #32 measuring stick when mixing by hand.

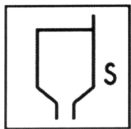
Stir the Colorbuild Plus 250 / Under Hood Additive mixture together then step #2 further mix –



#9 Stick

	Under Hood Sealer Color
3	Parts by volume Colorbuild Plus 250 / Under Hood Additive mixture (Previous step)
1	Parts by volume Colorbuild Plus 250 Hardener
1	Parts by volume Colorbuild Plus 250 Activator
	Use the Sikkens #9 (Gray) measuring stick when mixing by hand.

Viscosity When Mixed



DIN #4

Seconds	Measured with a DIN #4 viscosity cup at 70°F (21°C).
18 – 22	Colorbuild Plus 250 Surfacer – Sanding
13 – 16	Colorbuild Plus 250 Sealer – Non-Sanding
13 – 16	Colorbuild Plus 250 Under Hood

Pot-Life When Mixed

Product Mix	70°F (21°C)	85°F (29°C)
Colorbuild Plus 250 Primer Surfacer – Medium or Slow Activator	50 – 60 Minutes	25 – 35 Minutes
Colorbuild Plus 250 Primer Surfacer – Spot and Panel or Medium Activator and LV250 Accelerator	25 – 35 Minutes	10 – 15 Minutes
Colorbuild Plus 250 Primer Surfacer – Slow Hardener	25 – 35 Minutes	10 – 15 Minutes

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Colorbuild Plus 250 Primer Sealer – Slow Activator	2 Hours	70 – 90 Minutes
Colorbuild Plus 250 Under Hood Sealer Color	1.5 – 2.0 Hours	60 – 70 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 – 1.9mm	29 psi at the spray gun inlet (Maxium10 psi at cap).
Compliant Gravity Fed	1.7 – 1.9mm	29 to 35 psi at the spray gun inlet.

SEALER



Sealer Spray Guns	Fluid Tip	Application Pressure
HVLP Gravity Fed	1.3 – 1.5mm	29 psi at the spray gun inlet (Maxium10 psi at cap).
Compliant Gravity Fed	1.3 – 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, then after a flash dry apply and extend 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 250 mixed as a surfacer (4:1:1) may be used wet-on-wet when edging in parts. For this, apply one coat of Colorbuild Plus 250. Apply topcoat after 15 minutes to a maximum of 45 minutes at 70°F (21°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.

Accelerated Application

- Accelerated Colorbuild Plus 250 should not be used on bare metal. It may be used over the AutoPrep Pretreatment Wipes or Autoprep Pen material.

Film Thickness – Using Suitable Application

Primer Surfacer

- 3 Coats will achieve a thickness of 4.0 – 5.0 mils (100 – 125µm).

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



- 3 Hours at 70°F (21°C)
- 1.5 – 2.0 Hours at 70°F (21°C) when mixed with LV250 Accelerator

Primer Surfacer Force Dry Bake

- 30 Minutes at 140°F (60°C)
- 20 Minutes at 140°F (60°C) when mixed with LV250 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 (21°C).
- May be sanded to de-nib after a minimum flash dry time of 15 - 20 minutes at 70°F (21°C). Extend flash prior to de-nibbing if Elast-O-Actif LV was added during mixing.
- Maximum re-coat time is 4 hours at 70°F (21°C).
- If the maximum flash time be exceeded, Colorbuild Plus 250 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 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 (21°C). Maximum flash time of 1 hour.

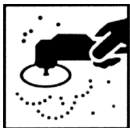
Under Hood Color – Dry to Handle Time



- One coat at 70°F (21°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



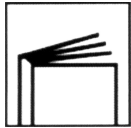
- When wet sanding, respect a maximum 200 sanding grit step or less throughout sanding.
- Initial sanding may be done with grits courser than #P600.
- Final sanding should be completed using #P800 before application of Sikkens top-coats.



Surface Cleaning

- Clean with Sikkens Autoclean cleaner prior to top-coating.

Re-Coating



- Sikkens Colorbuild Plus 250 can be re-coated with all Sikkens sealers and top-coats.

Cleaning of Equipment



Clean equipment following local and federal regulations. In compliant localities, use Sikkens LV Cleaning Solvent or high quality solvent borne gun cleaner.

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 250 Primer Surfacer - Per coat of ready to spray paint 105 ft²/ liter (9.5m²/liter).
- Colorbuild Plus 250 Primer Sealer - Per coat of ready to spray paint 129 ft²/ liter (12m²/liter).

VOC / Regulatory Information

System	Mix Ratio	VOC
- Primer Surfacer	4:1:1	1.7 lb/gal (212g/liter)
- Primer Surfacer + LV250 Accelerator	4:1:1+.7%	1.78 lb/gal (213g/liter)
- Primer Sealer	3:1:1	1.87 lb/gal (224g/liter)
- Flexible Parts, Primer Surfacer	100:15 with E-O-A then 4:1:1	1.79 lb/gal (215g/liter)
- Flexible Parts, Primer Sealer	100:15 with E-O-A then 3:1:1	1.88 lb/gal (226g/liter)
- Under Hood Additive Sealer	100:40 with UHA then 3:1:1	1.85 lb/gal (222g/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 (21°C).

Colorbuild Plus 250	1 Year	Colorbuild Plus 250 Activator	1 Year
Colorbuild Plus 250 Hardeners	1 Year	Under Hood Additive	1 Year
LV250 Accelerator			



North America

Colorbuild Plus 250™

Technical Data Sheet
Primers / Sealers
6/27/2017

FOR PROFESSIONAL USE ONLY

AkzoNobel 1845 Maxwell Street Troy, Michigan 48084
Telephone: 800-618-1010

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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