

# SIKKENS

North America  
**Colorbuild Plus 250™**

Technical Data Sheet  
Primers / Sealers  
6/27/2017

**FOR PROFESSIONAL USE ONLY**

## 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 Sealer



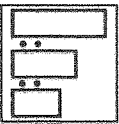
### Safety Considerations

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



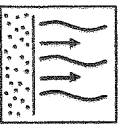
### HVL or Compliant Spray-Gun Set-Up:

1.3 – 1.5 mm  
**Application Air Pressure:**  
Consult spray gun manufacturers' specifications.  
HVL maximum 10 psi at the air cap.



### Application

1 x 1 Coats



**Flash before Top-Coat at 70°F (21°C)**

**Maximum Re-Coat Window at 70°F (21°C)**

15 Minutes minimum

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.

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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 Spray Guns	Fluid Tip	Application Pressure
HVLP Gravity Fed	1.7 – 1.9mm	29 psi at the spray gun inlet (Maximum 10 psi at cap).
Compliant Gravity Fed	1.7 – 1.9mm	29 to 35 psi at the spray gun inlet.



Sealer Spray Guns	Fluid Tip	Application Pressure
HVLP Gravity Fed	1.3 – 1.5mm	29 psi at the spray gun inlet (Maximum 10 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).

