





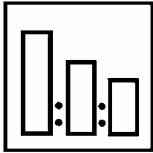
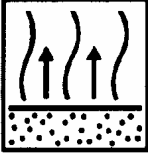


COLORBUILD™ 2.1–2.8 UNDERCOAT SYSTEM

DESCRIPTION: The Colorbuild 2.1–2.8 Undercoat System consists of six colored primers which, when mixed in proper combination with each other, achieve colors that closely resemble the most popular topcoat colors. Depending on the system and mixing ratio utilized, Colorbuild 2.1–2.8 can be applied as either a primer surfacer or a wet-on-wet primer sealer.

PRODUCT & ADDITIVES

- PRODUCT:** Colorbuild 2.1–2.8: white, red, blue, yellow, green and black
- HARDENER:** Colorbuild 2.1–2.8 Hardener
- ACTIVATORS:** —Colorbuild 2.1–2.8 Surfacer Activator
—Colorbuild 2.1–2.8 Sealer Activator
- ADDITIVES:** —Autocoat LV Flex: A flexible additive to increase the flexibility for use on plastic parts.
—Autocoat LV Retarder: For large jobs at high temperatures.
- BASIC RAW MATERIALS:** Colorbuild 2.1–2.8: Acrylic resins
Colorbuild 2.1–2.8 Hardener: Polyisocyanate
Colorbuild 2.1–2.8 Surfacer/Sealer Activator: Solvent

APPLICATION: Colorbuild 2.1–2.8 Primer Surfacer (Mixture A)



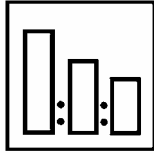
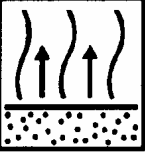
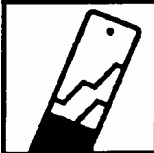

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|----|---|---|----|--|--|
| 1. |  | Contains acrylic resins and other ingredients. When mixed, also contains isocyanates. | 4. |  | 3–4 x 1 HVLP Siphon 0.071"–0.087" (1.8–2.2 mm) HVLP Gravity 0.055"–0.067" (1.4–1.7 mm) Max. 10 psi (max. 0.8 bar) |
| 2. |  | 100:25:25 Colorbuild 2.1–2.8 Colorbuild 2.1–2.8 Hardener Colorbuild 2.1–2.8 Surfacer Activator | 5. |  | 5–10 minutes at 70°F (20°C) |
| 3. |  | Use the Sikkens Measuring Stick #5 (Orange). | 6. |  | 3 hours at 70°F (20°C) 30 minutes at 140°F (60°C) |



COLORBUILD™ 2.1–2.8 UNDERCOAT SYSTEM

APPLICATION:

Colorbuild 2.1–2.8 Primer Sealer (Mixture B)

- | | | | | | |
|----|---|--|----|--|--|
| 1. |  | Contains acrylic resins and other ingredients. When mixed, also contains isocyanates. | 4. |  | 1 x 1 HVLP Siphon 0.071"–0.087" (1.8–2.2 mm) HVLP Gravity 0.051"–0.059" (1.3–1.5 mm) Max. 10 psi (max. 0.8 bar) |
| 2. |  | 100:25:35 Colorbuild 2.1–2.8 Colorbuild 2.1–2.8 Hardener Colorbuild 2.1–2.8 Sealer Activator | 5. |  | 10–15 minutes at 70°F (20°C) |
| 3. |  | Use the Sikkens Measuring Stick #5 (Orange). | 6. |  | (Wet-on-Wet) 10–15 minutes at 70°F (20°C) (Non-Sanding) Maximum 1½ hours at 70°F (20°C) |

SUITABLE SURFACES:

As a surfacer (Mixture A), Colorbuild 2.1–2.8 can be applied over:

- Existing finishes, degreased and sanded with #P220 to #P320 grit paper dry.
- Any premium bodyfiller sanded with #P180 to #P220 grit dry.
- Steel degreased and sanded with #P80 then #P120.
- Fiberglass gelcoat, degreased and sanded with #P220 to #P320 grit dry.
- Colorbuild 2.1–2.8 can be applied over the following primers non-sanding after the stated flash off times:
 - Washprimer EM after 30 minutes at 70°F (20°C)
 - Washprimer EM CF (1:1:1 ratio) after 30 minutes at 70°F (20°C)
 - Washprimer CR after 15 minutes at 70°F (20°C)
- OEM Ecoat, Colorbuild 2.1–2.8 may be applied to non-sanded, rigid Ecoated parts that have been thoroughly cleaned and degreased.

SUITABLE SURFACES:

As a sealer (Mixture B, wet-on-wet), Colorbuild 2.1–2.8 can be applied over:

- Existing finishes, degreased and sanded with #P320 to #P400 grit paper dry or #P500 to #P600 grit wet.
- Steel degreased and sanded with #P80 then #P120 grit dry.
- Fiberglass, free of release coat, degreased and sanded with #P320 grit dry. If the gelcoat is broken and has been sanded through, under no circumstances should Colorbuild 2.1–2.8 be applied.
- Colorbuild 2.1–2.8 can be applied over the following primers non-sanding after the stated flash off times:
 - Washprimer EM after 30 minutes at 70°F (20°C)
 - Washprimer EM CF (1:1:1 ratio) after 30 minutes at 70°F (20°C)
 - Washprimer CR after 15 minutes at 70°F (20°C)



COLORBUILD™ 2.1–2.8 UNDERCOAT SYSTEM

SUITABLE SURFACES (CONTINUED):

As a sealer (Mixture B, wet-on-wet) — Continued:

- Autowave Filler 790 sanded with #P320 to #P400 grit dry or #P500 to #P600 grit wet.
- Autosurfacers LV 2.1 sanded with #P320 to #P400 grit dry or #P500 to #P600 grit wet.
- OEM Ecoat, Colorbuild 2.1–2.8 may be applied to non-sanded, rigid Ecoated parts that have been thoroughly cleaned and degreased.

NOTE:

Although Colorbuild 2.1–2.8 will provide adequate adhesion and protection when applied directly over bare steel, for larger areas or new vehicles including zinc coating (galvanized) steel or aluminum, Colorbuild 2.1–2.8 must always be applied over a Washprimer.

MIXING RATIOS:

Surfacer:

- 100 parts by volume Colorbuild 2.1–2.8
 - 25 parts by volume Colorbuild 2.1–2.8 Hardener
 - 25 parts by volume Colorbuild 2.1–2.8 Surfacer Activator
- For easy and accurate mixing, use the Sikkens Measuring Stick #5 (Orange).

POT LIFE:

45 minutes at 70°F (20°C).

Sealer:

- 100 parts by volume Colorbuild 2.1–2.8
 - 25 parts by volume Colorbuild 2.1–2.8 Hardener
 - 35 parts by volume Colorbuild 2.1–2.8 Sealer Activator
- For easy and accurate mixing, use the Sikkens Measuring Stick #5 (Orange).

POT LIFE:

1 hour at 70°F (20°C).

NOTE:

For larger jobs at temperatures above 90°F (32°C), 10% Autocoat LV Retarder should be added to Colorbuild Sealer 2.1/2.8 and the spraying pressure should be lowered to 7 psi at the aircap. At 90°F (32°C), the recoat window is 45 minutes.

SPRAYING VISCOSITY:

15–18 seconds DIN cup #4 at 70°F (20°C)

RECOATABILITY: Colorbuild 2.1–2.8 can be recoated with Autocoat LV or Autobase.

FILM THICKNESS:

Approximately 1.5–1.8 mils per single coat as a surfacer.
Approximately 1.2–1.4 mils per single coat as a sealer.

NOTE:

- As a surfacer, Colorbuild 2.1–2.8 toners should be intermixed; however, both black and white can be either used on their own or intermixed.
- As a sealer, Colorbuild 2.1–2.8 toners should be intermixed; however, the black toner can be used on its own.

DENIB:

Colorbuild 2.1–2.8 Sealer can be denibbed in 15 minutes.



COLORBUILD™ 2.1–2.8 UNDERCOAT SYSTEM

DRYING TIMES: As a surfacer (Mixture A)

| | 70°F (20°C) | 140°F (60°C) |
|-----------|-------------|--------------|
| 1 Coat | 1 hour | 10 minutes |
| 2 Coats | 2 hours | 20 minutes |
| 3–4 Coats | 3 hours | 30 minutes |

As a sealer (Mixture B), Colorbuild 2.1–2.8 can be recoated wet-on-wet after 10–15 minutes at 70°F (20°C). After 1½ hours, thorough sanding is necessary before application of topcoat.

COVER RATE: Approximately 169 sq. ft./liter of unmixed paint at a film thickness of 1 mil.

CLEANING OF EQUIPMENT: Clean equipment with Sikkens cleaning Solvent 790.

SHELF LIFE: Colorbuild 2.1–2.8: One year if stored unopened at 70°F (20°C).
Colorbuild 2.1–2.8 Hardener: Six months if stored unopened at 70°F (20°C).
Colorbuild 2.1–2.8 Activators: One year if stored unopened at 70°F (20°C).

SAFETY ASPECTS:

READY TO SPRAY VOC:

Mixture A (100:25:25)

Colorbuild 2.1–2.8
Colorbuild 2.1–2.8 Hardener
Colorbuild 2.1–2.8 Surfacer Activator: 2.1 lb/gal (250 g/liter)

Mixture B (100:25:35)

Colorbuild 2.1–2.8
Colorbuild 2.1–2.8 Hardener
Colorbuild 2.1–2.8 Sealer Activator: 2.8 lb/gal (336 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 protective equipment while mixing and spraying this material. Protect skin with gloves and spray suit. Wear safety glasses or goggles when mixing, and wear a full hood fresh air fed respirator while spraying.