

BUILD+

BUILD+ 2K HS HIGH BUILD PRIMER

Technical Data Sheet

Product Name: SBP4 BUILD+ 2K HS HIGH BUILD PRIMER

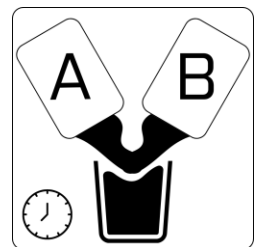
Revision date: August 2026

General Information

SBP BUILD+ Primer is a 2K High Solids High Build Primer filler with excellent sanding properties, which can also be used as a non-sanding primer. It is very easy to apply and gives high durability and appearance. This TDS is for the high build sanding version. Good flow on application, excellent build, fast drying and easy to sand.

Substrate Compatibility

BUILD+ should only be applied over well sanded/scuffed and degreased primed bare steel and primed aluminium. Well sanded GRP, polyester fillers, OEM primer and old paint systems that are in good condition. (Use etch primer for maximum durability and rust protection). Pre-treatment: BUILD+ must be applied over or onto thoroughly sanded and well-degreased substrates. NB: Soluble substances such as TPA, cellulose and synthetic based products are susceptible to attack and reactions by 2K materials. When spot priming ensure the applied product is through cured as per air or force dry instructions.



Mixing Ratio & Components

4:1 + up to 20% thinner

- 4 parts SUNOX® BUILD+ Primer
- 1 part SUNOX® BUILD+ Activator

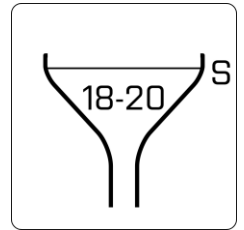
Volume

100ml / 25ml

- Optional: Up to 20% SUNOX® UNI Thinner

Components

SBPG4 [BUILD+ 2K HS HIGH BUILD PRIMER (GREY)]
SBPB4 [BUILD+ 2K HS HIGH BUILD PRIMER (BLACK)]
SBPW4 [BUILD+ 2K HS HIGH BUILD PRIMER (WHITE)]
SBAF1 [BUILD+ 2K HS PRIMER FAST ACTIVATOR]
SUNST5 [2K UNI THINNER]



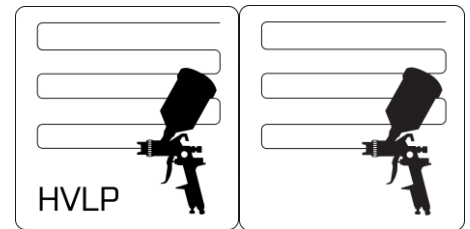
Spray Viscosity & Pot Life

- Viscosity:

- 18-22 sec 4mm DIN [sanding filler]
- 14-16 sec 4mm DIN [wet on wet]
- 25-30 sec 4mm DIN [high build]

- Pot life:

50 – 70 minutes



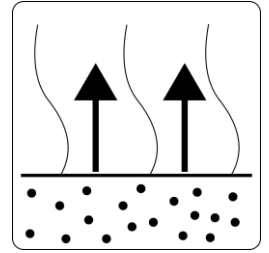
Recommended Spray Guns

High build

- Fluid tip: 1.6mm – 2.5mm
- Working pressure: 1.6 – 2.0 bar

Wet on wet

- Fluid tip: 1.2-1.4mm
- Working pressure: 1.6 – 2.0 bar



Application Guidelines, Flash Times and Pot Life

Pot Life:

- 50 – 70 minutes @ 20°C

Number of Coats:

- High build – 2-3 coats
- Wet on wet – 1-1.5 coats

Flash-off time

6-8 minutes between coats at 20°C

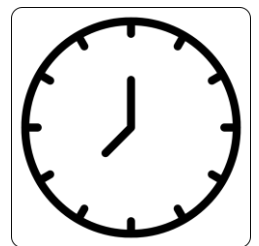
10-15 minutes before bake or infrared drying

Film Thickness

- High build – 50-80 microns
- Wet on wet – 20-50 microns

Do not overapply — allow correct flash-off between coats.

Product should be at 20°C prior to use.



Curing Schedule

SBAF1 Activator

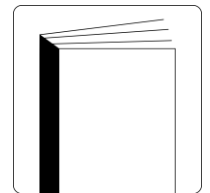
- Bake: 25-30 minutes @ 80°C (metal temp 60°C)
- Air Dry: 2.5 – 3.5 hours @ 80°C
- Recoatable: 10 minutes wet on wet



Infrared Curing Schedule [after flash off and at proper distance]

SBAF1 Activator

- 20-30 minutes @ metal temp 60°C



Physical Data

- Type: 2K HS High Build Primer

EU Regulations

- VOC Classification: Compliant with Directive 2004/42/CE
- VOC (ready-for-use): 420 g/l (EPA limit value for this product is 540 g/lite of VOC)
- Solids Content (RFU): 45.5% by weight
- Appearance: Black, Light Grey, White & Colourless
- Shelf Life: 24 months (unopened container)
- Pack Sizes: 4L & 1L

Health & Safety

For professional use only. Always consult the Safety Data Sheet (SDS) before use. Observe all label instructions and workplace PPE requirements.