

Headlight Repair



Restoration Instead of Replacement

Recoating of Headlights

The alternative.

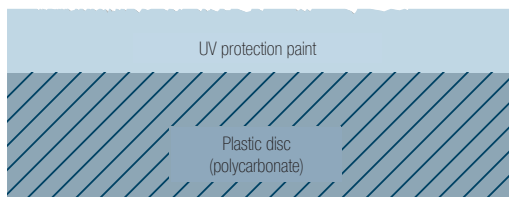
Restoration instead of replacement.

Vehicle headlight polycarbonate covers are permanently exposed to a variety of external impacts. Stone chips, UV, weathering and other influences dull the surface of the polycarbonate covers or leave scratches and marks.

- Restoration instead of replacement; Paint instead of polishing
- Can be used on all polycarbonate headlight covers
- Convenience of 2 in 1 - Primer and Clearcoat in one product
- High elasticity of the new finish to resist chipping
- 2 in 1 Clear provides permanent protection
- Can be recoated for continued protection and like-new appearance



Superficial weathering damage, yellowing

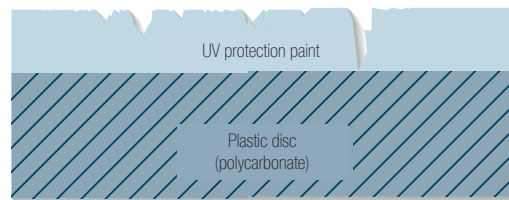


Clearcoat Preparation

- Step 1: mechanically wet sanding with P1000
- Step 2: mechanically wet sanding with P2000

Clean Headlight with Wax & Grease Remover 3680094.
Clean surface between the sanding steps with SprayMax Wax & Grease Remover.

Scratches, stone chips (in UV coated layer) or down to the plastic

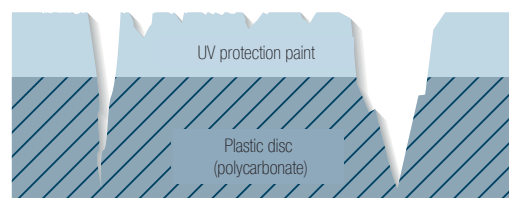


Clearcoat Repair:

- Step 1: mechanically dry sanding P180
- Step 2: mechanically dry sanding P320 (with soft pad)
- Step 3: mechanically dry sanding P500 (with soft pad)
- Step 4: mechanically dry sanding P800 (with soft pad)
- Step 5: mechanically dry sanding P1000
- Step 6: mechanically dry sanding P2000

Clean Headlight with Wax & Grease Remover 3680094.
Clean surface between the sanding steps with SprayMax Wax & Grease Remover.

Strong damage of the plastic surface



No Repair: replacement recommended

Headlight Repair Process



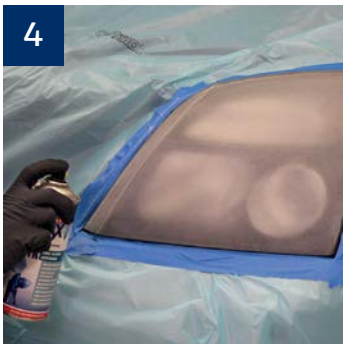
1
BEFORE
Matting / yellowing, slight superficial scratches to the coating.



2
CLEANING
Clean the entire surface of the headlight with Wax & Grease Remover 3680094 prior to masking.



3
SANDING
Sand evenly the entire surface of the headlight starting with P180 grit followed by: P320, P500, P800, P1000 and finish with P2000.



4
CLEANING
Clean surface between changes of sanding grits with SprayMax Wax & Grease Remover 3680094.



5
PRE-PAINT
Clean surface with Wax & Grease Remover followed by use of tack cloth.



6
ACTIVATE CLEAR
Activate 2K 2 in 1 Clear 3684068 as per instructions on can.



7
APPLY 2K 2 IN 1 CLEARCOAT
Apply a thin even coat of 2K 2in1 Clear 3684068. Allow a flash time of 10 min at 68°F/20°C and apply a medium wet coat for film build and finish.



8
DRYING
Dry at room temperature 68°F/20°C overnight or forced dry: allow to flash off for 10 min. then dry for 30 min. at 140°F/60°C surface temperature.



9
AFTER
Once dry, surface is permanently sealed. If necessary, can be wet sanded and polished.

Technical Data

2K 2in1 Headlight Clear, 250 ml, Part No. 3684068

Processing steps	Application
Surface Preparation	Pre-clean surface with Wax & Grease Remover 3680094.
Activation	To activate 2 in 1 Clear 3684068 follow instructions on can: shake well/activate/shake.
Spray to test	After activation step completed, test spray for fan pattern and flow.
Spray passes	Apply a thin even coat of 2K 2in1 Clear 3684068. Allow a flash time of 10 min at 68°F/20°C and apply a medium wet coat for film build and finish.
Drying	68°F/20°C overnight or forced dry: allow to flash off for 10 min. then dry for 30 min. at 140°F/60°C surface temperature.
Polishing	After drying overnight at room temperature 68°F/20°C or forced dry at 140°F/60°C wet sand and polish as necessary to achieve desired finish.
Potlife	Approx. 8h 68°F/20°C room temperature. Potlife dependent on ambient temperature. Higher temps lead to shorter pot life/lower temps lead to longer pot life.
Recommendation	Optimum application at 64°-77°F/18°-25°C and a relative humidity of 40-50%.



Product system

Recommendation:

- Use SprayMax Wax & Grease Remover 3680094 for initial cleaning and between changes in sanding grit steps.
- Use SprayMax Wax & Grease Remover 3680094 followed by use of a tack cloth prior to application of SprayMax 2 in 1 Clear 3684068.

