Headlight repair

Restoration instead of replacement

Recoating of Headlights

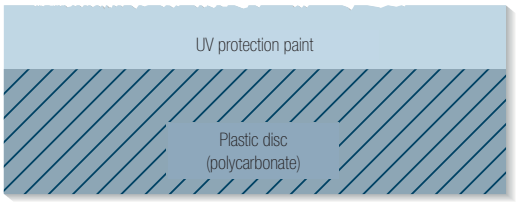
The alternative.
restoration instead of replacement.

Vehicle headlight polycarbonate covers are permanently exposed to a variety of external impacts. Stone chips, UV- light, damages during parking and other mechanical influences dull the surfaces 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
- 2 in 1 / two in one - Primer and Clearcoat
- High elasticity of the new coat
- Permanent protection thanks to subsequent protective coating finish

Preparation

Superficial weathering damage, yellowing

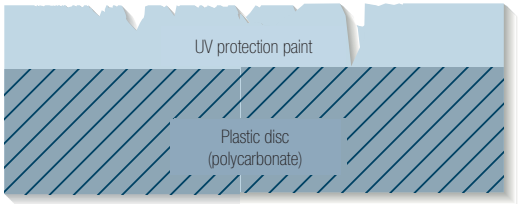


Clearcoat Prepararion
Step 1: mechanically wet sanding with P 1000
Step 2: mechanically wet sanding with P 2000

Clean surface between the sanding steps with SprayMax Aqua-Silicon Remover 680094.

Recoating

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

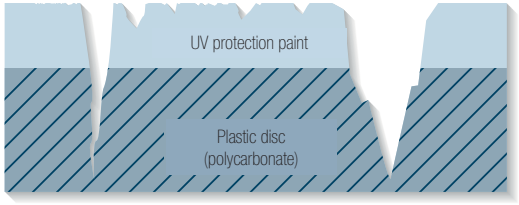


Clearcoat Repair:
Step 1: mechanically dry sanding P 180
Step 2: mechanically dry sanding P 320 (with soft pad)
Step 3: mechanically dry sanding P 500 (with soft pad)
Step 4: mechanically dry sanding P 800 (with soft pad)
Step 5: mechanically dry sanding P 1000
Step 6: mechanically dry sanding P 2000

Clean surface between the sanding steps with SprayMax Aqua-Silicon Remover 680094.

No Repair

Strong damage of the plastic surface



No Repair, replacement

Headlight repair process

1

BEFORE

Matting / yellowing, slight superficial scratches to the coating.

2

CLEANING

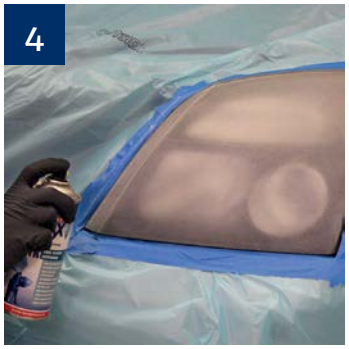
Mask the rear part of the headlight and clean the surface with SprayMax Silicone remover.

3

SANDING

Use different grits, start with P 180.

4



CLEANING

Clean, remove abrasive dust with tag rag and SprayMax Aqua Silicone remover.

5

CLEANING

Clean surface between the sanding steps with Spay-Max Aqua-Silicone-Remover 680094.

6

ACTIVATE HARTENER

7

APPLY 2K 2 in 1 CLEARCOAT

Apply a very thin (misty) layer of Clearcoat first, directly followed by continuous. Film-forming spray pass.

8

DRYING

Drying at 20°C room temperature over night or with IR.

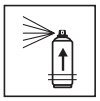
9

AFTER

Surface is permanent high quality sealed.

Technical Data

2K 2in1 Headlight Clear, 250 ml, Art.Nr.: 684 068

Processing steps	Application
 **Pre-treatment**	Pre-treatment Prepare headlight lens according to process description.
 **Preparation**	Preparation Activate 2K – can according to description (shake/activate/shake). Spray to test.
 **Spray to test**	After shaking the can, test spray and check compatibility with the surface and the colour.
 **Spray passes**	Dry film thickness 40 µm (approx. 2 spray coats). Apply a thin, film building spray coat, flash off and apply again another film building spray coat to achieve a smooth surface.
 **Drying**	Drying 20°C: overnight; forced: Meet a final flash-off time of 10 min then dry for 30 min at 60°C object temperature.
 **Continue**	Continue After drying overnight at room temperature (20°C) or 30 min at 60°C, if necessary use recommended fine polish against dust inclusions.
 **Potlife/Processing time**	Potlife/Processing time approx. 8h / 20°C room temperature. Processing time depends on ambient temperature. Higher temperatures lead to a shorter / lower temperatures to a longer pot life.
 **Attention**	Recommendation Optimum application at 18°C-25°C and a relative humidity from 40 - 50 %.

Product system
Recommendation:
- Use for thorough basic and initial cleaning SprayMax Silicone Remover, Art. Nr. 680090
- Use for quck, thorough cleaning between standing steps SprayMax Silicone-Remover, Art. Nr. 680094

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