



# RECOATING HEADLIGHTS

2 IN 1 HEADLIGHT CLEAR



# THE ALTERNATIVE

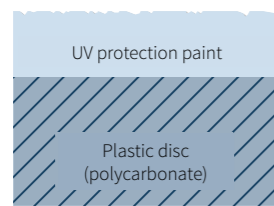
## RECOATING INSTEAD OF REPLACEMENT.

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.

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



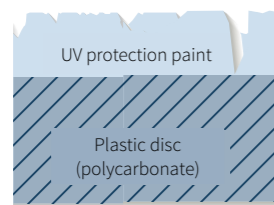
### Superficial weathering damage, yellowing



Clear coat Preparation.  
Step 1: mechanically wet sanding with P1000  
Step 2: mechanically wet sanding with P2000

Clean Headlight with 1K Aqua silicone remover 680 094. Clean surface between the sanding steps with SprayMax 1K Aqua silicone remover.

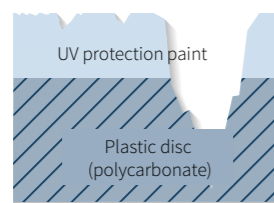
### Scratches, stone chips (in UV coated layer) or down to the plastic



Clear coat Preparation.  
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 1K Aqua silicone remover 680 094. Clean surface between the sanding steps with SprayMax 1K Aqua silicone remover.

### Strong damage of the plastic surface



No restoration.  
Replacement recommended.

## HEADLIGHT RECOATING PROCESS



BEFORE

Matting / yellowing, slight superficial scratches to the coating.



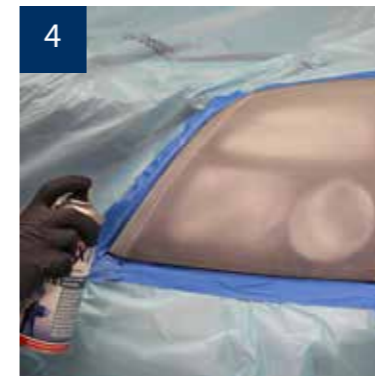
CLEANING

Clean the entire surface of the headlight with 1K Aqua silicone remover 680 094 prior to masking.



SANDING

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



CLEANING

Clean surface between changes of sanding grits with SprayMax 1K Aqua silicone remover 680 094.



PRE-PAINT

Clean surface with 1K Aqua silicone remover followed by use of tack cloth.



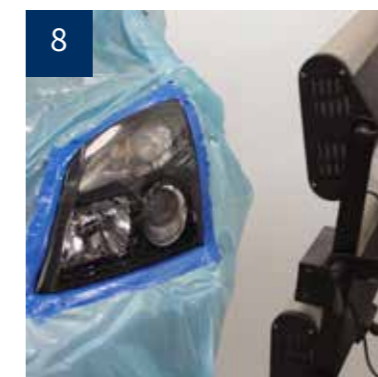
ACTIVATE CLEAR

Activate 2K 2 in 1 Clear 684 068 as per instructions on can.



APPLY 2K 2 in 1 CLEAR COAT

Apply a thin even coat of 2K 2in1 Clear 684 068. Allow a flash off time of 10 min at 20°C and apply a medium wet coat for film build and finish.



DRYING

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



AFTER

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

More safety



Save cost



Increase value



TECHNICAL DATA

2K 2IN1 HEADLIGHT CLEAR, 250 ML, PART NO. 684 068

	<p><b>Surface Preparation</b> Pre-clean surface with 1K Aqua silicone remover 680 094.</p>
	<p><b>Activation</b> To activate 2 in 1 Clear 684 068 follow instructions on can: shake well/activate/shake.</p>
	<p><b>Spray to test</b> After activation step completed, test spray for fan pattern and flow.</p>
	<p><b>Spray passes</b> Apply a thin even coat of 2K 2in1 Clear 684 068. Allow a flash off time of 10 min at 20°C and apply a medium wet coat for film build and finish.</p>
	<p><b>Drying</b> 20°C overnight or forced dry: allow to flash off for 10 min. then dry for 30 min. at 60°C surface temperature.</p>
	<p><b>Polishing</b> After drying overnight at room temperature 20°C or forced dry at 60°C wet sand and polish as necessary to achieve desired finish.</p>
	<p><b>Potlife</b> Approx. 8h at 20°C room temperature. Potlife dependent on ambient temperature. Higher temps lead to shorter pot life/lower temps lead to longer pot life.</p>
	<p><b>Recommendation</b> Optimum application at 18°-25°C and a relative humidity of 40-50%.</p>

Product system recommendation:

- Use SprayMax 1K Aqua silicone remover 680 094 for initial cleaning and between changes in sanding grit steps.
- Use SprayMax 1K Aqua silicone remover 680 094 followed by use of a tack cloth prior to application of SprayMax 2 in 1 Clear 684 068.



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