

Part no. 609

## Polycarbonate Headlight Repair System

### 2 COMPONENT SYSTEM

Special two-component finish with excellent characteristics of resistance and adherence to polycarbonate-base plastic materials, such as lenses for vehicle lights, with excellent properties of expansion and UV protection of the underlying polycarbonate surface. Although they guarantee good adhesion to the polycarbonate, the raw materials used do not prejudice the polycarbonate's mechanical resistance (cracking), but protect it from the otherwise inevitable yellowing followed by decay caused by the powdering of the original UV protection that takes place on average in the course of the first five years of its working life. The special two-component formula enables plastics that have been deeply scoured or scratched to be repaired, as long as they are not actually broken.

### INSTRUCTIONS

- **Degrease/clean the surface of the headlight**
- **Mask the area to be treated**
- **Sanding in 3 steps; removing the complete UV protection film using a 3 inch orbital sander, grid P320 – P400 – Blue (by hand, P600) – Yellow (by hand, P800) – Orange (by hand, P1200)**
- **Clean the surface of the headlight with a degreaser using a clean lint free cloth.  
Dry it with a dry lint free cloth**
- **Mix the Clear Coat (609-1) with Activator (609-3)  
2:1 ratio i.e 2 parts Clear Coat with 1 part Activator**
- **Filter the mix using a 150 micron filter**
- **Pot life for the mix is 60 minutes at 20 degrees centigrade**
- **Remove the fine dust using a tag rag**
- **Apply a thin layer, allow to set for 30 seconds, then apply a full shiny layer using an HVLP mini spray gun with 0.8-1.3 nozzle at 1.5-2 bar pressure**
- **Thickness 25-40 micron**
- **Drying times - 30 mins. at 60 degrees centigrade or 10-15 mins. with a short wavelength infra-red lamp**
- **Any imperfections can be removed after curing and cooling down using a P2000 grid sanding paper and polish (fine)**

### Mixing Ratio:

Headlight Clear Coat	2
Headlight Activator	1