

# Technical Data Sheet



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## SprayMax® 2K Headlight clear coat 250 ml Art. Nr. 684066



### Product

#### Description / Purpose

Special 2K clear coat for subsequent protective coating of polycarbonate lenses that have been pretreated with headlamp primer 684098. Highly transparent, light-fast and weather-resistant clear coat. Improves resistance to new damage.

#### Properties

- Ideally matched to the headlamp sealer (Art.No. 684 098)
- Seals the repaired surface
- Offers added protection against new damage
- Lends the lens a new shine
- Also available as a set (684 099) or as a repair case (680 485)

#### Material base

Two-component acrylic resins

Activator: aliphatic isocyanates

gloss

90+/-4 gloss units at 20° measuring angle

667 g/l

#### Gloss level

#### VOC Value (EU)

## Substrate

Polycarbonate (cleaned and sanded) primed with SprayMax® 1K Headlight Primer 684098

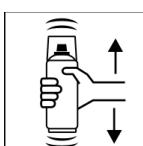
## Processing

### Protection measures



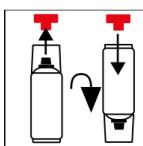
Wear personal protection equipment.  
(respiratory mask/gloves/goggles)  
For more information, see safety data sheet.

### Shake



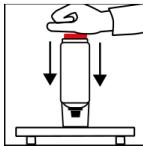
Before activating, shake can thoroughly for 2 minutes from when the mixing balls are heard.

### Place red button



Remove the red button from the cap. Turn the can by 180° and fit the button onto the pin.

### Press red button



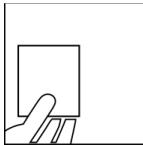
Turn the can upside down and place on a firm surface. Press the red button with the ball of your hand until it clicks into place.

### Shake



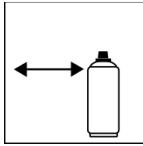
After activating, shake can again thoroughly for 2 minutes, again from when the mixing balls are heard.

### Spray to test



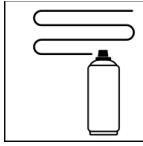
After shaking the can, test spray and check compatibility with the surface and the colour.

### Spraying distance



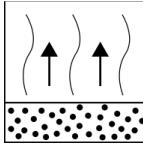
15 cm - 20 cm

### Spray passes



Apply 1 mist coat first. Then apply a closed, i.e. film-forming spray coat.

### Flash-off time



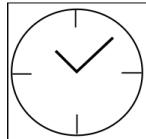
Flash time:  
approx. 2 min between each spray coat

## Processing conditions



Optimum application at 18°C - 25°C and a relative humidity from 40 - 50 %.

## Drying



over night

The stated values refer to the above-mentioned processing conditions. The level of dryness is determined pursuant to DIN 53150.

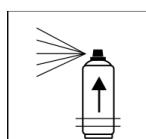


IR- drying: 10 min end flash off; after 25 – 30 min at 60 °C object temperatur

## Continue

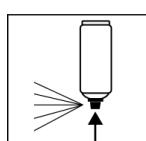
Can be polished after approx. 8 - 9 h after drying over night at (20 °C) or 30 min at 60 °C

## Pot life



Approx. 14 h at 20 °C room temperature and a relative humidity of approx. 40 - 50 %. The processing time depends on the ambient temperature. Higher temperatures reduce the pot life, lower temperatures will prolong it.

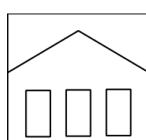
## Finish



After painting, turn the can upside down and spray the valve until empty.

## Additional Information

### Shelf Life



36 months (not activated)

The usage period refers to an unused can that is stored correctly at a temperature of 15 – 25 °C and a relative humidity below 60%. The can must be stored and transported in an upright position in a dry place where it is protected against chemical and mechanical influences. The safety information on the can and all statutory provisions applicable for the storage site must be observed.

## Disposal



The completely emptied spray cans must be disposed of in the recycling system. Cans with hardened material must be disposed of as special waste.

## Note

For professional use only.

Identification, see safety data sheet.

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