

# System Data Sheet.

## Headlight Repair Kit.

Permahyd Silicone Remover 7080 / Permahyd 1K Headlight Primer 4018 / Permacron 2K Clear Coat 8018

Spies Hecker\* expressly states that this document is merely a recommendation on the possible use of the headlight repair kit. Any liability of Spies Hecker related to the recommendation is excluded and the use of the headlight repair kit is at the user's own risk and responsibility unless provided differently by law.

\* Spies Hecker means the local Axalta entity.

### Description:

Modern repair system with high-grade paint materials in aerosol cans. Developed to repair small scratches and yellowing of headlight lenses made of polycarbonate.

### Features:

- Dedicated paint system
- Repair instead of costly replacement
- The waterborne Permahyd 1K Headlight Primer 4018 protects polycarbonate and provides adhesion to the substrate and to our Permacron 2K Clear Coat 8018
- Lasting protection thanks to protective coating

### Usage:

For repairing superficial weathering defects and scratches or stone impact. Please note: polycarbonate lenses with deformation, cracks, holes and breaks may not be repaired. The headlight has to be completely replaced.

For professional use only!

VR Technical Data Sheet No. EN / SYS\_915s / 00



## Substrate.

### Substrate pretreatment:

Prepare headlight lens as follows:



1. Mask the rear part of the headlight.
2. Carefully clean lens with Permahyd Silicone Remover 7080.



Use only Permahyd Silicone Remover 7080 to avoid damaging the substrate.

The sanding process always refers to the complete headlight lens.

### Repair:

Sand the complete headlight lens by machine (starting with P180, ending with P3000).

Between the individual sanding steps, clean with Permahyd Silicone Remover 7080.



Sanding step 1: dry sand by machine with P180 using Mirka Abranet (manually at edges and corners)  
Sanding step 2: dry sand by machine with P320 using Mirka Abranet (manually at edges and corners)  
Sanding step 3: dry sand by machine with P500 using Mirka Abranet (manually at edges and corners)  
Sanding step 4: dry sand by machine with P800 using Mirka Abranet (manually at edges and corners)



Sanding step 5: wet sand by machine with P1000 using Mirka Abralon (manually at edges and corners)  
Sanding step 6: wet sand by machine with P3000 using Mirka Abralon (manually at edges and corners)



Clean with Permahyd Silicone Remover 7080.

### Check:



Check if the substrate is transparent and free of sanding marks.

## Notes on safety.



This product is classified according to regulation (EC) 1272/2008 (CLP).

The relevant Material Safety Data Sheet and Warnings displayed on the aerosol can label need to be observed. It is strongly recommended to use appropriate personal protection equipment during application.

**VOC value:**  
2004/42/IIB(e)(840)690

The EU limit value for this product (product category IIB.e) in ready to use form is max. 840 g/litre of VOC.

The VOC content of this product in ready to use form is max. 690 g/litre.

## Application of Permahyd 1K Headlight Primer 4018

**Use:**



Shake aerosol can well for at least 2 minutes.



Make a spray test after shaking.



Apply Permahyd 1K Headlight Primer 4018 in one coat until film is closed and milky.  
10 - 15 µm film thickness

**Distance to object:**



10 - 15 cm

**Drying:**



Allow to flash off for approx. 40 min. at +20°C.  
No IR lamp



Permahyd 1K Headlight Primer 4018 forms an opaque film. Full transparency is only achieved by the following protective coating with Permacron 2K Clear Coat 8018.

It is important that the primer homogeneously covers the entire headlight lens.

**End of application**



After use, hold aerosol can upside down and spray briefly to clean nozzle.  
You can use the primer for further objects.

**VOC value:**  
2004/42/IIB(e)(840)660

The EU limit value for this product (product category IIB.e) in ready to use form is max. 840 g/litre of VOC.

The VOC content of this product in ready to use form is max. 660 g/litre.

## Application of Permacron 2K Clear Coat 8018

### Use:



Before spraying, shake aerosol vigorously for 2 min. after the mixing balls in the aerosol can be heard.

### Two-component product:



Remove red push button from the cap and place it on the hardener mixing valve at the can bottom.



Press hardener mixing valve inwards.



After activating the hardener in the aerosol, shake aerosol vigorously for 2 min. after the mixing balls in the aerosol can be heard to ensure proper crosslinking.

### Pot life.

Approx. 14 hours at +20°C ambient temperature  
Pot life depends on ambient temperature. Higher temperatures lead to reduced pot life, lower temperatures lead to longer pot life.

### Notes on safety.



Ready to use paint materials containing isocyanates can cause irritation of the mucous membranes - and of the respiratory organs, in particular - and cause hypersensitive reactions.

There is a risk of hypersensitization if the vapour or spray mist is inhaled.

When using materials containing isocyanates, all precautions relating to the handling of solvents should be carefully followed.

In particular, care should be taken not to inhale spray mist or vapour.

Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

The relevant Material Safety Data Sheet and Warnings displayed on the aerosol can label need to be observed. The relevant Material Safety Data Sheet and Warnings displayed on it is strongly recommended to use appropriate personal protection equipment during application.

**Preparation:**



Make a spray test after shaking.

**Number of coats:**



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

**Distance to object:**



15 - 20 cm



No intermediate flash-off time between coats. Allow 10 min. final flash-off time.

**End of application**



After use, hold aerosol can upside down and spray briefly to clean nozzle.

**Drying.**

Air drying:

Force drying:



At +20°C ambient temp.:                      overnight  
Drying time    25 - 30 min.  
at +60°C metal temperature:

**Further steps.**



The object can be polished after drying overnight at ambient temperature (+20°C) or 30 min. at +60°C with any standard polishing compound.

**Waste disposal:**

Dispose of the empty aerosol cans as re-usable material.

**Data.**

**VOC value:**

2004/42/IIB(e)(840)820

The EU limit value for this product (product category IIB.e) in ready to use form is max. 840 g/litre of VOC.

The VOC content of this product in ready to use form is max. 820 g/litre.

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