

# Technical Data Sheet



The United States of America:  
by Peter Kwasny Inc.  
62-64 Enter Lane  
Islandia, NY 11749

Distributed in

Canada:  
Peter Kwasny Spraypaint Canada Inc.  
40 University Avenue, Suite 904  
Toronto, ON. M5J 1T1

Toll free North America  
Phone: 1-844-426-6330 / Fax: 1-866-226-6434  
order@kwasny.us / service@kwasny.us  
www.spraymax.com

## **SprayMax®** **2K 2in1 Headlight Clear** **Art. Nr. 3684068**



### **Product**

#### **Description / Purpose**

SprayMax® Special 2K Clear Coat is a protective coating for polycarbonate lenses suitable for fixing scratches, yellowness or foggy headlights. Cristal clear, easy to apply comes in a 250 ml size. Resistance to environmental and for day to day use. Increases protection against UV light, salt water, car wash, etc. increases night visibility.

#### **Properties**

- Special product for the preparation of headlights coated with clear lacquer
- Provides durable UV and weathering resistance
- Protection against physical damages (Stonechips)

#### **Material base**

Two-component acrylic resins  
Activator: aliphatic isocyanates

#### **Gloss level**

gloss  
92 gloss units at 20° measuring angle

#### **Solid content**

approx. 58 % by weight relating to the diluted paint

#### **EPA Coating Category**

CCP Clear Coatings Product  
PWR Limit 1.50

#### **CARB Aerosol Rule Coating Category (01/2017)**

TCC Two Component Coating  
PWR Limit 1.20

## Substrate

### Surface preparation:

Step by step Pre-treatment of the Headlights

1. Clean surface with Soap and Water and dry Surface.
2. Spray and wipe dry with SprayMax Wax & Grease Remover 3680094
3. Mask area around the headlights.

Note: avoid any over spray on vehicle

Sanding of Headlights.

4. Sand manually or with a mechanical sander, sand the surface of the lens with the least aggressive sandpaper (dry or wet) working towards a P 1000.

### IMPORTANT NOTE:

Clean and dry between sandpaper grit changes using SprayMax Wax & Grease Remover and dry.

5. Final sanding of the lens, manual or mechanical with P 3000 wet.

Final Preparation of lens prior to the 2K Clearcoat 3684068 application.

6. Clean and dry lens using SprayMax Wax & Grease Remover 3680094.
7. First Application of Clear Coat: Apply a thin even coat of 2K 2in1 Clear 3684068. Allow a flash time of 10 min at 68° F / 20° C and apply a medium wet coat for film build and finish.

Note: Use in a well ventilated area

## Processing

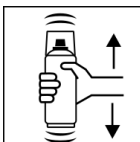
### **Protection measures**



Wear personal protection equipment.  
(respiratory mask / gloves / goggles)

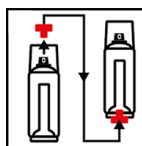
For more information, see safety data sheet.

### **Shake**



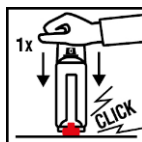
Before activating, shake can thoroughly for 2 minutes from when the mixing balls are heard.

## Place red button



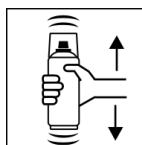
Remove the red button from the cap. Turn the can by 180° and fit the button onto the pin.

## Press red button



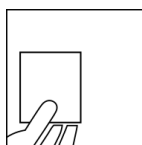
Turn the can upside down and place on a firm surface. Press the red button with the palm of your hand until it clicks into place.

## Shake



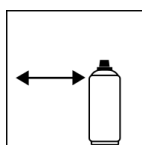
After activating, shake can again thoroughly for 2 minutes, again from when the mixing balls are heard.

## Spray to test



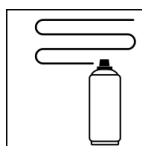
After shaking the can, test spray and check compatibility with the surface and the colour.

## Spraying distance



6 - 8 inches / 15 - 20 cm

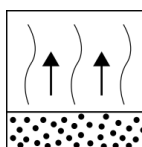
## Spray passes



Dry film thickness 1.6 mil (40 µm)  
(approx. 2 spray coats)

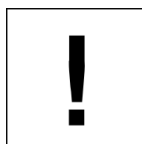
Apply a thin even coat of 2K 2in1 Clear 3684068.  
Allow a flash time of 10 min at 68°F/20°C and apply a medium wet coat for film build and finish.

## Flash-off time



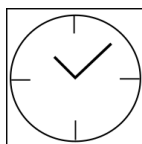
Flash time: approx. 10 min between each spray coat

## Processing conditions



Optimum application at 64° F - 77° F (18° C - 25° C)  
and a relative humidity from 40 - 60 %.

## Drying



dust dry: 15 - 20 min

dry to touch: 3 h

Ready for polishing: over night

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

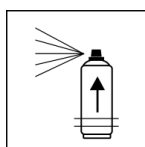


IR- drying possible,  
Observe equipment description  
10 min end flash off; after  
25 - 30 min at 140° F / 60° C object temperature

## Continue

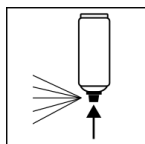
Can be polished over night at room temperature  
or 30 min at 140° F / 60° C

## Pot life



Approx. 8 h at at 68° F (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.

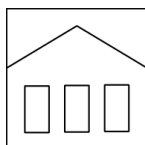
## Finish



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 68° F / 20° 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 dis-  
posed 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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