



Standex

Scheinwerfer-Reparaturset

Headlight repair kit

Standex Precleaner / Standox 1K Headlight Primer U3040 / Standox 2K Crystal Clear K9035

Standex* expressly states that this document is merely a recommendation on the possible use of the headlight repair kit. Any liability of Standox 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.

***Standox 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 Standox 1K Headlight Primer U3040 protects polycarbonate and provides adhesion to the substrate and to our Standox 2K Crystal Clear K9035**
- **Lasting protection thanks to protective coating**



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Substrate pretreatment:



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

Please consult the Safety Data Sheet. It is strongly recommended to use appropriate personal protection equipment during application.

Prepare headlight lens as follows:



1. Mask the rear part of the headlight.
2. Carefully clean lens with Stadox Precleaner.



Use only Stadox Precleaner to avoid damaging the substrate.

The sanding process always refers to the complete headlight lens.

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

Between the individual sanding steps, clean with Stadox Precleaner.



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 Stadox Precleaner.



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

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Application of Stadox 1K Headlight Primer U3040:



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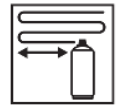
Shake aerosol can well for at least 2 minutes.



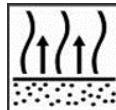
Make a spray test after shaking.



Apply Stadox 1K Headlight Primer U3040 in one coat until film is closed and milky. 10 - 15 μm film thickness



Keep a distance of 10 -15 cm to the object.



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



Stadox 1K Headlight Primer U3040 forms an opaque film. Full transparency is only achieved by the following protective coating with Stadox 2K Crystal Clear K9035.

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



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

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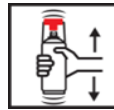
Application of Stadox 2K Crystal Clear K9035:



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

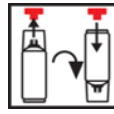
Please consult the Safety Data Sheet.

It is strongly recommended to use appropriate personal protection equipment during application.



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.

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.

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 coating materials containing isocyanates, all precautions relating to solvent-based coating materials must be carefully observed.

Spray mist and vapours in particular must not be inhaled. 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.

It is strongly recommended to use appropriate personal protection equipment during application.

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Application of Stadox 2K Crystal Clear K9035 (continued):



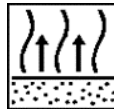
Make a spray test after shaking.



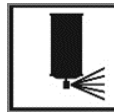
Apply one mist coat first
Then apply a closed, i.e. film-forming coat.



Keep a distance of 15 - 20 cm to the object



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



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



Air dry overnight / 18-22°C or
25-30 min. / 60-65°C panel temperature



The object can be polished after drying with any
standard polishing compound.

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VOC (2004/42/EC):

Stadox Cleaner

2004/42/II B(e)(840)690

The EU limit value for this product (productcategory II B.e) in ready to use form is max 840g/ltr. The VOC content of this product in ready for use form is max. 690 g/l.

Stadox 1K Headlight Primer

U3040

2004/42/II B(e)(840)660

The EU limit value for this product (productcategory II B.e) in ready to use form is max 840g/ltr. The VOC content of this product in ready for use form is max. 660 g/l.

Stadox 2K Crystal Clear K9035

2004/42/II B(e)(840)820

The EU limit value for this product (productcategory II B.e) in ready to use form is max 840g/ltr. The VOC content of this product in ready for use form is max. 820 g/l.

Important Remarks:

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

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. It is strongly recommended to use appropriate personal protection equipment during application.

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