

Intended use

Mipa Scheinwerfer-Reparatursystem is perfectly suitable to repair in a top quality headlight glasses which have lost their transparency by wear, opacity, yellowing, scratches and stone chips. Furthermore the appearance of the headlights is enhanced and returned in mint condition, which leads to a considerable upgrade of the car appearance.

Moreover, the professional refinishing of headlight glasses avoids the often expensive replacement or the labour intensive disassembly of headlights.

Repair the headlight glasses as follows:

Step 1

Clean the substrate thoroughly using Mipa WBS Reiniger Final. Solvent-based cleaning agent must never be used as this would dissolve the PC-plastic of the lenses.

Mask the areas of the headlights that must not be coated.

Dry sand the complete glass surface (preferably with an eccentric sander) as follows:

Rough sanding if necessary with P 240 - 320 in case of deep scratches and imperfections.

Sand thoroughly the complete headlight surface with P 400 until the UV-resistant clearcoat that has been applied by factory is completely removed.

Intermediate sanding with P 600.

Dry or wet finishing sanding starting with P 1000 and working up to P 3000.

Step 2

Clean the substrate thoroughly using Mipa WBS Reiniger Final.

Priming: Mipa WBS PC-Primer

Shake spray can vigorously before use. Apply a thin and uniform layer on the complete glass surface, dry coat thickness 5 - 10 µm.

Intermediate evaporation time before clearcoat application: approx. 35 - 45 minutes at room temperature.

Step 3

Clearcoat: Mipa 2K-Klarlack/ Mipa 2K-Klarlack-Spray

Shake spray can vigorously before use. Directly before application, remove the red button from the cap, turn the can 180 degrees and attach the button on the base of the aerosol. Place the can with the cap upside down on a solid surface. Press the red button with the ball of the thumb until a stop is reached. After the activation shake the can again vigorously. Test application, spray distance approx. 25 cm.

Apply 2 thin misty coats on the headlight glass; allow flash-off of approx. 2-3 minutes at room temperature between the coatings. After another intermediate evaporation time of 2-3 minutes apply a third even coat, complete coat thickness 40 - 50 µm.

Pot life approx. 5 - 6 hours at 20 °C.