PLASTIC REPAIR
STANDARD OPERATING PROCEDURE

1 PREP



Clean front and back with **Scuff & Clean** and damp, gray scuff pad. Rinse with water and dry or wipe with a clean, damp cloth until removed. Clean front and back with **SEM Solve, Plastic & Leather Prep** or **XXX Universal Surface Cleaner**. Wipe clean in one direction with dry, lint-free cloth.

2 SAND & DISH



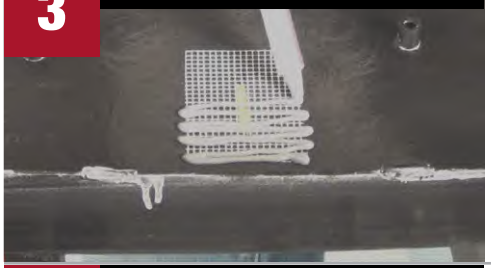
On front side, sand repair area with P80 grit. Dish out damage with P36 grit disc at a low RPM. On back side, grind repair area with P36 grit disc at a low RPM. Blow off surfaces.

ⓘ Paint does not need to be stripped from the repair if it has good adhesion. Do not grind too

❗ fast and cause plastic to melt. (Optional) Apply

ⓘ **XXX Adhesion Promoter** to all prepped surfaces.

3 REINFORCE & FILL BACK



Mask front side of repair to prevent repair material from flowing through. Apply **Plastic Repair Contouring Tape** (mesh only) to back side. Apply **Dual-Mix™ Multi-Plastic Repair Material** or **Dual-Mix Problem Plastic Repair Material** and cover mesh tape. Spread material firmly. Allow to set.

4 REINFORCE & FILL FRONT



Remove tape from front. Fill front with **Dual-Mix Multi-Plastic Repair Material** or **Dual-Mix Problem Plastic Repair Material.** Spread material firmly and build up higher than panel to allow for sanding. Allow to set before sanding.

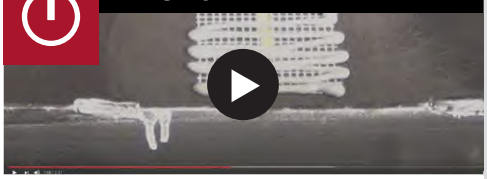
5 SAND & SKIM



Sand with P80 grit. Finish with P180 grit. If needed, use a skim coat of **Flexion Flexible Finishing Putty**. then sand with P180 – P320 grit.

ⓘ Refer to **Plastic Refinishing SOP** for refinishing steps.

WATCH & LEARN



WATCH THE VIDEO AT:
semproducts.com/sop-plastic-repair





ABRASIVES

Part	Product	Size
SA25036	2" 36-grit Grinding Disc	2"
SA6080	6" Grip 80-grit	6" DA
SA6180	6" Grip 180-grit	6" DA

Other sizes and grits available at semproducts.com

PRODUCT LIST



PREP

Part	Product	Size
38391	Scuff & Clean	Gallon Pump
38398	Scuff & Clean	16 oz. Tube
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Square Quart
38351	Plastic & Leather Prep	Gallon
38353	Plastic & Leather Prep	16 oz. Aerosol
38354	Plastic & Leather Prep	Cone Quart
77721	XXX Adhesion Promotor	Gallon
77723	XXX Adhesion Promotor	16 oz. Aerosol
77724	XXX Adhesion Promotor	Cone Top Quart
77771	XXX Universal Surface Cleaner	Gallon
77774	XXX Universal Surface Cleaner	Quart



REINFORCE & FILL

Part	Product	Size
70007	Plastic Repair Contouring Tape	15' Roll
39767	Problem Plastic Repair Material	7 oz. Cartridge
39847	Multi-Plastic Repair Material	7 oz. Cartridge



SAND AND SKIM

Part	Product	Size
40572	Flexion Flexible Finishing Putty	16 oz. Tube

SEM Products
Rock Hill, SC 29730
Tech Support: 1-800-831-1122
Customer Care: 1-866-327-7829
semproducts.com

ⓘ CHECK LOCAL VOC REGULATIONS TO ENSURE COMPLIANCE OF ALL PRODUCTS IN YOUR AREA. ALWAYS WEAR OSHA REQUIRED (PPE) PERSONAL PROTECTION EQUIPMENT TO ENSURE YOUR SAFETY.