



STEEL PANEL REPLACEMENT

STANDARD OPERATING PROCEDURE

1A**SEALER REMOVAL METHOD #1**

Remove seam sealer using the **QLock Strip It Wheel**.

1B**SEALER REMOVAL METHOD #2**

Remove seam sealer using the **Course Grit File Belt** attached to a file belt sander.

2A**PART REMOVAL METHOD #1**

Remove spot welds with spot weld cutter. Remove rivets by drilling or grinding. Remove damaged panel and straighten bent flanges with a hammer and dolly.

2B**PART REMOVAL METHOD #2**

Remove spot welds with **60 or 80-grit File Belt**.

3**PANEL CUTTING**

Cut panel at OEM recommended area using a **Cut Off Wheel**.

4**EDGE STRAIGHTENING**

Remove damaged panel and straighten bent flanges with a hammer and dolly.

5**PREP AND GRIND**

Clean surfaces with **SEM Solve** or **XXX Universal Surface Cleaner**. Wipe clean in one direction with a clean, lint-free towel.
Grind mating flanges with a 36-80 grit grinding disc at low speed for aggressive grind mark. Remove any adhesive or protective coatings.

6**WELD THROUGH PRIMER**

Apply **Zincweld** weld through primer per OEM recommendations on flanges that do not use adhesives.

PRODUCT LIST**PREP**

Part	Product	Size
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Square Quart
77771	XXX Universal Surface Cleaner	Gallon
77774	XXX Universal Surface Cleaner	Quart

**ABRASIVES**

Part	Product	Size
SA40020	QLock Strip It Wheel	4"
SA120CG	Course Grit File Belt	1/2" x 18"
SA380CG	Course Grit File Belt	3/8" x 13"
SA1060	60-grit File Belt	1/2" x 18"
SA1080	80-grit File Belt	1/2" x 18"
SA3060	60-grit File Belt	3/8" x 13"
SA3080	80-grit File Belt	3/8" x 13"
SA30004	.04" Cut-Off Wheel	3"
SA40004	.04" Cut-Off Wheel	4"
SA25036	36 grit QLock Grinding Disc	2"
SA25050	50 grit QLock Grinding Disc	2"
SA25080	80 grit QLock Grinding Disc	2"

Other sizes available on semproducts.com

**WELD THROUGH PRIMER**

Part	Product	Size
40773	Zincweld	16 oz. Aerosol

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.