

SEM[®] 1K SEAM SEALING

STANDARD OPERATING PROCEDURE

1 PREP



Clean with **SEM Solve** or **XXX Universal Surface Cleaner**. Wipe clean in one direction with a dry, lint-free cloth.

2 SAND



Sand bare metal with P180 grit or use red scuff pad on OEM or e-coat finish. Blow off and re-clean with **SEM Solve** or **XXX Universal Surface Cleaner**. Tack clean. Mask off area to create clean lines.

3 APPLY



Apply **1K Seam Sealer** or **2-IN-1 Seam Sealer** using **1K Pneumatic Applicator** or a manual applicator. Finish with a gloved finger, acid brush, putty knife, or spreader. While product is wet, remove excess by wiping with a small amount of **SEM Solve**.

4 PAINTABLE IMMEDIATELY



Remove masking tape immediately after clean up. Paint immediately with **Factory Pack™** or most solvent-based coatings.

ⓘ Can be painted for up to 24 hours without scuffing. If in doubt, scuff with gray pad prior to painting.

i IMPORTANT INFORMATION

1K Seam Sealers are paintable immediately with most solvent-based coatings, however, always test for compatibility.

⚠ Do not apply **1K Seam Sealer** directly over acid-based self-etching primers or vice versa. Cracking and blistering may occur.



WATCH & LEARN



WATCH THE VIDEO AT:
semproducts.com/sop-1k-seam-sealer

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



1K SEAM SEALER

Part	Color	Size
29362	1K Seam Sealer - White	10.1 oz. Tube
29372	1K SEam Sealer - Gray	10.1 oz. Tube
29382	1K Seam Sealer - Beige	10.1 oz. Tube
29392	1K Seam Sealer - Black	10.1 oz. Tube
29462	2-IN-1 Seam Sealer - White	9.5 oz. Tube
29472	2-IN-1 Seam Sealer - Gray	9.5 oz. Tube
29482	2-IN-1 Seam Sealer - Beige	9.5 oz. Tube
29492	2-IN-1 Seam Sealer - Black	9.5 oz. Tube



ABRASIVES

Part	Product	Size
SA6180	6" Grip 180-grit DA	6" DA
SA4947	Maroon Scuff Pad	4.5" x 9"

For additional sizes, visit semproducts.com

EQUIPMENT

Part	Product	Size
29342	1K Pneumatic Applicator	1 Applicator
29352	1K Seam Sealer Nozzle	15 Pack

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