

SEM[®] 2K SEAM SEALING

STANDARD OPERATING PROCEDURE

1 PREP



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

2 SAND



Bare Metal Surfaces: Sand with P80 grit. Blow off and re-clean with **SEM Solve** or **XXX Universal Surface Cleaner**. Tack clean to remove lint and dust.

Primed Surfaces: Sand primed surfaces with P400 grit or a Maroon Scuff Pad. Blow off and re-clean with **SEM Solve** or **XXX Universal Surface Cleaner**. Tack clean to remove lint and dust.

3 APPLY SEAM SEALER



Apply **SEM 2K Seam Sealer**. Immediately smooth or tool **Seam Sealer** to match OEM texture.

① SEM 2K seam sealers can be applied direct-to-metal, over epoxy primer or 2K urethane primer.

① Always apply over a primer when filling drip rails.

⚠ Never apply over a self etching primer.

SELF LEVELING



Use **Self Leveling Seam Sealer** or **High-Build Self Leveling Seam Sealer** for applications where a flowable sealer is needed.

① Keep tip submerged to minimize air bubbles.

① A heat gun can be used immediately after application to remove any air bubbles that become entrapped. With a steady motion and low heat, sweep the heat gun across surface at a distance of 2" – 6".

SPECIALTY TIPS



Use **ORBIT**, **SHFT** and **Versa-Tips** to duplicate hard-to-match seam sealer beads.

ORBIT is used for duplicating "ripple beads"

SHFT is used for hem flanges

Versa-Tips can create 1/2"- 1 1/2" beads

① **Versa-Tips** can be cut to the desired bead width and are compatible with both standard and self leveling **SEM 2K Seam Sealer**

WATCH & LEARN APPLY



WATCH THE VIDEO AT:
semproducts.com/sop-2K-seam-sealer



ABRASIVES

Part	Product	Size
SA1080	Perf-Roll 80-grit	2.75"x 33.5'
SA4947	Maroon Scuff Pad	4.5" x 9"

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



APPLY

Part	Product	Size
39387	Self Leveling Seam Sealer	7 oz. Cartridge
39777	High-Build Self Leveling	7 oz. Cartridge
39377	Medium Bodied - Gray	7 oz. Cartridge
39477	Medium Bodied - Beige	7 oz. Cartridge
40177	Heavy Bodied - Gray	7 oz. Cartridge
40277	Heavy Bodied - Beige	7 oz. Cartridge
40377	Heavy Bodied - Black	7 oz. Cartridge
40477	Heavy Bodied - White	7 oz. Cartridge



EQUIPMENT

Part	Product	Size
29412	ORBIT Tip	6 Pack
29422	SHFT Tip	6 Pack
70070	VERSA-TIP	6 Pack

SEM Products

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