



# 4PLASTIC™

## Revolutionizing plastic repair.

BRO4P01-EN-0326

**4Plastic™ from SEM® is a leading-edge provider of specialized tools, materials and systems designed specifically for automotive plastic repairs.**

We engineer patented solutions that allow repair professionals to restore plastic vehicle components (such as bumpers, headlights, textured parts and tabs) to OEM-level strength and appearance.

4Plastic approach includes:

- Advanced welding and bonding techniques for plastic substrates.
- Texture-matching coatings and finishes that replicate factory surfaces.
- A commitment to sustainability, reducing waste and improving reparability of plastic parts rather than replacing them.

**Thanks to its expert-driven research and innovation, 4Plastic offers repair shops a complete ecosystem that boosts efficiency, lowers cost, supports sustainability and helps maintain or restore structural integrity of plastic components. It's not simply a product line – it's a forward-looking suite of solutions for modern collision repair.**



# TOOLS & EQUIPMENT

## AUTO SCRIBBLERS

Water-based paint marker designed for automotive applications:



- Non-toxic water-based ink
- Washable with water or alcohol after use and dry
- Weather resistant and easy to see
- Long lasting application tip

PART #	COLOR	SIZE
4P-30-011	Green	6 pc. Pack
4P-30-021	Red	6 pc. Pack
4P-30-031	Yellow	6 pc. Pack
4P-30-041	White	6 pc. Pack
4P-30-061	Pink	6 pc. Pack
4P-30-071	Blue	6 pc. Pack

## WELD SUPPORT TAPE

Used as a backer repair tape on plastic repairs:



- Perfectly suited to plastic welding applications
- Heavy-duty thickness for added support
- Enhanced holding strength adhesives
- Value priced 25m roll

PART #	PRODUCT	SIZE
4P-90-022	Weld Support Tape	Roll

## EASY WELD STRIPS

Weld strips for repairing most plastics:



- Automotive-grade
- Flexible and absorbent to stress and impact
- Easy to shape and blend into the original part
- Easy to file finish and sand
- Produces a very strong repair

PART #	PRODUCT	SIZE
4P-20-031	Easy Weld Strips - Black (10mm), 36/Pack	Pack

## EASY WELD TRI ROD STRIPS

Triangle-shaped weld strip for repairing most plastics:



- Perfect for repairing difficult angles
- Flexible and absorbent to stress and impact
- Easy to sand, shape and blend into the original part

PART #	PRODUCT	SIZE
4P-20-043	Easy Weld Tri Rod - Black (3.2mm), 36/Pack	Pack

## ABS STRIPS (8MM)

Weld strips for repairing ABS plastic



- Automotive-grade
- Easy to shape and blend into the original part
- Easy to file finish and sand
- Produces a very strong repair

PART #	PRODUCT	SIZE
4P-20-054	ABS Strips (8mm), 36/Pack	Pack

## PLASTIC BOND

Industrial-grade cyanoacrylate adhesive for fast repairs of minor imperfections:



- Fuses with plastic dust to fill minor imperfections
- Does not shrink
- Very fast drying
- Convenient 3-pack

PART #	PRODUCT	SIZE
4P-40-011	Plastic Bond - 3/Box	Box

## BUMPER PUSH TOOL

Multi-shaped tool for pushing out dents and refining bodylines in plastic bumpers:



- Designed to eliminate damage to parts during repairs
- Many grip points for maximum leverage
- Pushes out dents in plastic bumpers
- Refines bodylines

PART #	PRODUCT	SIZE
4P-60-011	Bumper Push Tool	Each

## TAB REPAIR JIG KIT

Assortment of the most popular Tab Repair Jigs:



- Includes one each of Mini-Straight and Mini-Curved Tab Repair Jigs
- Perfectly aligns surfaces prior to tab repair
- Easy to use
- Durable construction

PART #	PRODUCT	SIZE
4P-60-050	Tab Repair Jig Kit	Each

# TOOLS & EQUIPMENT

## FILE GRIPS

Attachable grips used with Plastic Shaving Files:

- Convenient hand-holds
- Ergonomically designed for comfort



PART #	PRODUCT	SIZE
4P-60-064	File grips	Pack

## UTILITY KNIFE

Used to trim the inside opening of the tab after repair.

- All-metal body construction
- Includes double-ended stainless blades
- Fits standard 2-notch, double-edge blades
- One-button blade change



PART #	PRODUCT	SIZE
4P-84-011	Utility Knife	Each

## UTILITY KNIFE BLADES

Replacement blades for Utility Knife:

- Manufactured from high-quality carbon steel
- Heat-treated edges for precision cutting
- Standard 2-notch, general purpose shape for use with most standard utility knives
- Packed in a plastic storage cartridge with 10 blades



PART #	PRODUCT	SIZE
4P-84-022	Utility Knife Blades	Pack

## PLASTIC SHAVING FILE FLAT

Shaves and contours plastic repair surfaces:

- Designed for shaving & use on automotive plastics
- Hardened and sandblasted clean for lasting sharpness
- 9 TPI design for best performance on plastic
- Sharply reduces consumption of sandpaper
- Decreases repair time



PART #	PRODUCT	SIZE
4P-50-011	Plastic Shaving File - Flat	Each

## PLASTIC SHAVING FILE HALF ROUND

Shaves and contours plastic repair surfaces:

- Designed for shaving & use on automotive plastics
- Hardened and sandblasted clean for lasting sharpness
- 9 TPI design for best performance on plastic
- Sharply reduces consumption of sandpaper
- Decreases repair time



PART #	PRODUCT	SIZE
4P-50-022	Plastic Shaving File - Half Round	Each

## BURR GRINDER MEDIUM

Used for channeling the face of a weld and for removing rough edges and substrate thickness for tab repairs:

- Perfect for channeling repairs
- Fast removal of excess product



PART #	PRODUCT	SIZE
4P-83-011	Burr Grinder - Medium	Each

## WELDING NOZZLE CURVED

32mm nozzle for common hot air welders:

- Focuses heat for plastic welding
- Fits most professional-grade hot air welders



PART #	PRODUCT	SIZE
4P-82-011	Welding Nozzle - Curved	Each

## PROFESSIONAL STARTER KIT

Complete starter kit for professional plastic repair using the proven 4Plastic process.

- Includes welding strips, tools, grinding discs, and accessories
- Suitable for structural repairs, tab reconstruction, and refinishing
- Designed for body shops, collision centers, and mobile professionals
- Ensures consistent, high-quality results in shop or on-site welders



PART #	PRODUCT	SIZE
4P-81-010	Plastic Repair Professional Starter Kit	Each
4P-81-021	Plastic Repair Professional Case only	Each

# LIQUID PRODUCTS

## PLASTIC PRIMER

Waterborne flexible primer for most flexible plastics:

- Fast covering, filling properties and fast dry time
- Outstanding adhesion
- Easy to sand and featheredge

### Suitable substrates:

- Properly prepped OEM finishes
- Fully cured and prepped refinish material
- Properly prepped raw plastic (olefin-based plastics require the use of adhesion promoter) and plastic repair materials
- Sanded skim coats and putties



PART #	COLOR	SIZE
4P-15-034	Black	Flat Top Quart

## ADHESION PROMOTER

It promotes adhesion to a variety of substrates including thermoplastics:

- Easy application
- Fast topcoat time
- Convenient aerosol



### Suitable substrates:

- Olefin-based plastics

PART #	COLOR	SIZE
4P-15-053	Clear	16 oz. Aerosol

## PLASTI-FINISH

2-part epoxy for minor imperfections on plastic bumpers Convenient job-size packaging:

- Fast cure time
- Works on most plastics
- Easy sanding and featheredge



### Suitable substrates:

- Properly prepped raw plastic and plastic repair materials
- Properly prepped OEM finishes

PART #	COLOR	SIZE
4P-15-112	Grey	1 oz. Cartridge

## TEXTURE COAT

It duplicates texture commonly found on automotive plastic bumper covers, lower valances, wheel lip moldings, rocker molding and various other parts:

- Texture and top coat in one product
- Excellent UV stability and durability
- Easy application and fast dry time
- 2.8 voc compliant

### Suitable substrates:

- Raw plastics
- Epoxy primer
- 2K urethane primer
- Plastic Primer



PART #	PRODUCT	COLOR	SIZE
4P-15-014	Texture Coat Black	Black	Flat Top Quart
4P-15-064	Texture Coat White Tint	White	Flat Top Quart
4P-15-046	Texture Coat Activator	Clear	Cone Top 1/2 Pint

## SMOOTH COAT

It matches smooth, satin black finishes on automotive plastic parts:

- Consistent, satin finish
- Mar resistant
- Resistant to chalking and fading
- 2.8 voc compliant
- Excellent UV stability and durability
- Easy to apply

### Suitable substrates:

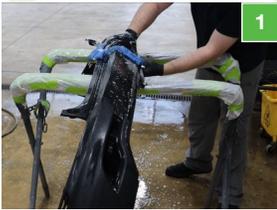
- Properly prepped, primed or painted surfaces

PART #	PRODUCT	COLOR	SIZE
4P-15-024	Smooth Coat Black	Black	Flat Top Quart
4P-15-074	Smooth Coat White Tint	White	Flat Top Quart
4P-15-086	Smooth Coat Activator	Clear	1/2 Pint
4P-15-096	Smooth Coat Reducer	Clear	1/2 Pint



# FUSE-WELDING PROCESS

## Standard Operating Procedure



1

### Prep the Part

- Wash both sides with soap and water (only use soap designed for automotive plastics).
- Rinse with clean water and blow dry.
- Sand the surface with 400 grit paper to remove all paint around the repair area. It is not necessary to remove all of the OE texture if present.



2

### Fuse Welding (inside first)

- Channel the tear 1/2 the depth of the plastic using the Burr Grinder.
- Use Weld Support Tape to reinforce the opposite side while completing the repair.
- Fuse weld the split. Select the appropriate heat setting on the welder, 1100-1200°F (600-650°C) for a 5 mm welding nozzle.
- The welding strip should be held at a 90 degree angle to the surface of the part. The welder should be held so the nozzle is at a 45 degree angle to the welding strip and the surface of the part. The nozzle should be approximately 1/2 an inch (1.5cm) away from where the welding strip and base plastic meet.
- Heat the base plastic and welding strip to approximately 325 to 350°F (162-177°C) for proper fusion. Apply downward pressure with your hand on the welding strip while directing heat at the point where the strip and base plastic meet. You should observe the welding strip and base plastic fusing together as you weld.
- Multiple welds may be necessary depending on the shape of the split. Always start welding before the channel begins. Cool the weld with compressed air.
- If the split goes to an edge, run a brace weld (T-weld) across the edge of the split.
- The brace weld should run along the edge of the split, perpendicular to the split. This will help prevent the split from cracking if the bumper is flexed or stressed.
- Repeat the process for the outside repair



3

### Filing the repair

- Use the Plastic Shaving File to ensure the repair area is level with the surface of the part.
- File in a linear motion. The file will only cut in one direction, the direction the teeth are facing. Be careful not to damage or distort the style lines of the bumper.



4

### Sand the Repair Area

- Remove the file marks with the 6 inch sander and 180 grit on a medium speed. Be careful not to damage or distort the style lines of the bumper.
- Use progressively finer grit paper to finish out the repair (180, 220, 320). Feather the paint around the repair area, making the transition from bare plastic to the existing paint as gradual as possible.



5

### Final Inspection

- Perform a thorough inspection of the repair area, and part as a whole, to ensure the quality of repair.
- Ensure the style lines are restored properly.
- Check again for any highs and lows or imperfections that may have been missed.

### Product List and Links

#### Step 1

Part	Product	Size
39398	Scuff & Clean	16 oz. Tube
77774	XXX Uni. Surface Cleaner	Qt.
SA6400	Velcro Grip Multi-Hole	6" DA

#### Step 2

Part	Product	Size
4P-83-011	Burr Grinder	Ea.
4P-20-031	Easy Weld Strips	
4P-20-043	Easy Weld Tri Rod	
4P-82-011	Welding Nozzle	
4P-60-050	Tab Repair Jig Kit	
4P-90-022	Weld Support Tape	Roll

#### Step 3

Part	Product	Size
4P-50-011	Plastic Shaving File - Flat	6 pc.
4P-50-022	Plastic Shaving File - Half Round	6 pc.

#### Step 4

Part	Product	Size
SA6180	Velcro Grip Multi-hole	6" DA
SA6220	Velcro Grip Multi-hole	6" DA
SA6320	Velcro Grip Multi-hole	6" DA

### Watch and learn



Watch the video for this procedure and download additional resources at [youtu.be/Ai7tPiwtr3g](https://youtu.be/Ai7tPiwtr3g)

# TEXTURE COAT APPLICATION PROCESS

## Standard Operating Procedure



### Preparation and cleaning

- Wash both sides with soap, water and a gray scuff pad, only using soap designed for automotive plastics.
- Rinse with clean water and dry.
- Blow dry any remaining water from the part with compressed air.



### Sand part and repair damage

- Sand the textured surface with SEM Performance Abrasives 400-Grit Sandpaper on a dual-action sander. For hard-to-reach areas, use a SEM Maroon Scuff Pad.
- For dents, splits and punctures in plastic substrate, repair the part before application of coatings. Scan the *Watch and learn* QR code below for more information.



### Clean part

- Clean with SEM Plastic & Leather Prep, SEM Solve, SEM XXX® Universal Cleaner or other approved plastic cleaner.
- Surface must be completely dry. Avoid saturating the panel with cleaner. Dry with a clean, lint-free towel.
- Use a bunched-up tack rag to lightly wipe the surface, removing any lint or dirt.



### Apply 4Plastic Adhesion Promoter

- Shake the can 2-3 minutes prior to application.
- Apply 1 medium-wet coat to the part.
- Spray at a distance of 6-8" (15-20 cm).
- Allow to fully flash at least 5 minutes before applying topcoats.
- If the topcoat time exceeds 24 hours, scuff, clean and re-apply.



### Apply 4Plastic Plastic Primer

- Remove the lid from the can and stir with a paint stick until the primer is mixed thoroughly.
- The plastic primer is ready to spray right out of the can. Do not reduce the primer.
- Allow 5-10 minutes of flash time between coats.
- The primer is ready for sanding when it changes from a shiny to a matte finish.
- The primer will air dry in 30-60 minutes or can be baked at 140° F (60° C) for 40 minutes.



### Choose correct color and texture

- Use the 4Plastic app to choose the correct color, texture and/or application matching.



### Mix 4Plastic Texture Coat products

- Remove lid from the black texture coat can and stir with a paint stick until product is thoroughly mixed.
- Black texture coat may be mixed with white tint to adjust the color. Mix prior to the addition of the activator.
- Mix 7 parts texture coat to 1 part texture coat activator.
- Mix well after activation.



### Apply texture coat

- Using a 1.4 tip, apply 2-3 light coats until coverage is achieved.
- Allow 5-10 minutes flash time between coats.
- A light "drop coat" can be applied to lower gloss and adjust texture.
- Variations in temperature, air pressure, spray distance and technique used will affect texture. Always spray test panel.

## Product List and Links

### Step 1

Part	Product	Size
39362	SEM® Soap	16 oz. Tube

### Step 2

Part	Product	Size
SA6400	SEM Performance Abrasives: 400 Grit	6"
SA6047	SEM Maroon Scuff Pad	4.5" x 9"

### Step 3

Part	Product	Size
38351	SEM Plastic & Leather Prep	16 oz. Aerosol
38371	SEM Solve	Gallon
77771	SEM XXX Universal Surface Cleaner	Gallon
77774	SEM XXX Universal Surface Cleaner	Quart

### Step 4

Part	Product	Size
4P-15-053	4Plastic Adhesion Promoter	16 oz. Aerosol

### Step 5

Part	Product	Size
4P-15-034	4Plastic Plastic Primer	Quart

### Step 6

Download the 4Plastic app



### Steps 7-8

Part	Product	Size
4P-15-014	4Plastic Texture Coat Black	Quart
4P-15-064	4Plastic Texture Coat White Tint	Quart
4P-15-046	4Plastic Texture Coat Activator	Half Pint



### Watch and learn

Watch the video for this procedure and download additional resources at [youtu.be/ZkfxJO\\_O4xo](https://youtu.be/ZkfxJO_O4xo).

# SMOOTH COAT APPLICATION PROCESS

## Standard Operating Procedure



### 1 Preparation and cleaning

- Wash both sides with soap, water and a gray scuff pad, only using soap designed for automotive plastics.
- Rinse with clean water and dry.
- Blow dry any remaining water from the part with compressed air.



### 2 Sand part and repair damage

- Sand the textured surface with SEM Performance Abrasives 400-Grit Sandpaper on a dual-action sander. For hard-to-reach areas, use a SEM Maroon Scuff Pad.
- For dents, splits and punctures in plastic substrate, repair the part before application of coatings. Scan the *Watch and learn* QR code below for more information.



### 3 Clean part

- Clean with SEM Plastic & Leather Prep, SEM Solve, SEM XXX® Universal Cleaner or other approved plastic cleaner.
- Surface must be completely dry. Avoid saturating the panel with cleaner. Dry with a clean, lint-free towel.
- Use a bunched-up tack rag to lightly wipe the surface, removing any lint or dirt.



### 4 Apply 4Plastic Adhesion Promoter

- Shake the can 2-3 minutes prior to application.
- Apply 1 medium-wet coat to the part.
- Spray at a distance of 6-8" (15-20 cm).
- Allow to fully flash at least 5 minutes before applying topcoats.
- If the topcoat time exceeds 24 hours, scuff, clean and re-apply.



### 5 Apply 4Plastic Plastic Primer

- Remove the lid from the can and stir with a paint stick until the primer is mixed thoroughly.
- The plastic primer is ready to spray right out of the can. Do not reduce the primer.
- Allow 5-10 minutes of flash time between coats.
- The primer is ready for sanding when it changes from a shiny to a matte finish.
- The primer will air dry in 30-60 minutes or can be baked at 140° F (60° C) for 40 minutes.



### 6 Choose correct color and texture

- Use the 4Plastic app to choose the correct color, texture and/or application matching.



### 7 Mix 4Plastic Smooth Coat products

- Remove lid from the black smooth coat and stir with a paint stick until product is thoroughly mixed.
- Black smooth coat may be mixed with white tint to adjust the color. Mix prior to addition of thinner and activator.
- Mix 4 parts smooth coat to 1 part activator and 1 part reducer.
- Mix well after activation.



### 8 Apply smooth coat

- Using a 1.4 tip, apply 2 medium wet coats until coverage is achieved.
- Allow 5-10 minutes flash time between coats.
- Variations in temperature, air pressure, spray distance and technique used may affect gloss. Always spray a test panel prior to application.

## Product List and Links

### Step 1

Part	Product	Size
39362	SEM® Soap	16 oz. Tube

### Step 2

Part	Product	Size
SA6400	SEM Performance Abrasives: 400 Grit	6"
SA6047	SEM Maroon Scuff Pad	4.5" x 9"

### Step 3

Part	Product	Size
38351	SEM Plastic & Leather Prep	16 oz. Aerosol
38371	SEM Solve	Gallon
77771	SEM XXX Universal Surface Cleaner	Gallon
77774	SEM XXX Universal Surface Cleaner	Quart

### Step 4

Part	Product	Size
4P-15-053	4Plastic Adhesion Promoter	16 oz. Aerosol

### Step 5

Part	Product	Size
4P-15-034	4Plastic Plastic Primer	Quart

### Step 6

Download the 4Plastic app



### Steps 7-8

Part	Product	Size
4P-15-024	4Plastic Smooth Coat Black	Quart
4P-15-074	4Plastic Smooth Coat White Tint	Quart
4P-15-086	4Plastic Smooth Coat Activator	Half Pint
4P-15-096	4Plastic Smooth Coat Reducer	Half Pint



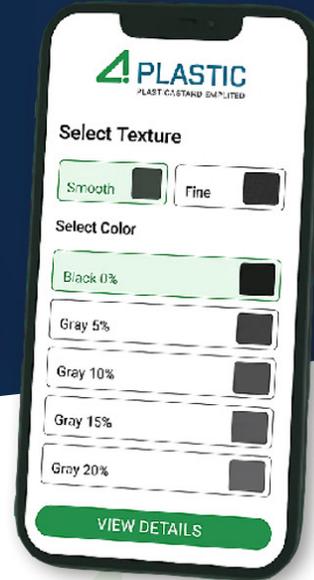
### Watch and learn

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# Perfect Texture Repair – Anywhere, Anytime.

Explore our OEM-grade texture solutions  
and get step-by-step repair guidance  
right from the 4Plastic App.

Download the App



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

[semproducts.com](http://semproducts.com)

**WARNING:** Certain products listed may contain chemicals known to the State of California to cause cancer and/or reproductive harm. For more information go to [P65Warnings.ca.gov](http://P65Warnings.ca.gov).

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