

SMOOTH COAT APPLICATION PROCESS

Standard Operating Procedure

SOP4P02-EN-1025



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 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.



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

Watch the video for this procedure and download additional resources at youtu.be/ymvNTenfC0g.

Check local VOC regulations to ensure compliance of all products in your area.
Always wear OSHA-required Personal Protection Equipment (PPE) to ensure your safety.

SEM Products
Rock Hill, SC 29730
Tech Support: 1-800-831-1122
Customer Care: 1-866-327-7829
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](https://www.P65Warnings.ca.gov).
This document contains general information only and should not be construed as creating any warranties, express or implied. Please contact your local SEM representative for additional information.
SEM and SEM XXX are registered trademarks of PPG Industries Ohio, Inc. The 4Plastic Logo is a trademark of Plasmonic. The Apple Logo and App Store are registered trademarks of Apple, Inc. The Google Play Logo is a trademark of Google, LLC.
©2025 PPG Industries, Inc. All rights reserved. 10/25

