

TEXTURE COAT APPLICATION PROCESS

Standard Operating Procedure

SOP4P01-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 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.

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

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