

# Standard Operating Procedures

Allied Products  
April 2026 Edition



**BUILT BETTER™**

# Table of Contents

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## **Body Repair**

Damage Repair.....	3
Steel Panel Replacement .....	4
Panel & Rivet Bonding .....	5
Panel & Weld Bonding .....	6

## **Protective Coatings**

Seam Sealer Removal .....	7
1K Seam Sealing .....	8
2K Seam Sealing.....	9
Inner Panel Corrosion Protection .....	10
Sprayable Sound Dampening.....	11
Undercoating.....	12
2K Lower Panel Protection.....	13
Truckbed Liner .....	14

## **Plastic Repair**

Plastic Repair (Adhesive).....	15
Plastic Tab Repair (Adhesive).....	16
Plastic Repair (4Plastic Plastic Welding).....	17

## **Masking**

Basic Masking.....	18
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## **Paint Repair**

Plastic Refinishing.....	19
E-Coat Panel Prep .....	20
Feather-Prime-Block.....	21
Feather-Prime-Block (Waterborne) .....	22
Blend Panel Sanding .....	23
OEM Refinishing System™.....	24
Refinishing Trim .....	25

## **Paint Shop**

Custom Fill™.....	26
VCS™ Disposable Cup System .....	27

## **Finishing & Detail**

Small Area Paint Correction.....	28
Large Area Paint Correction.....	29
Vehicle Detailing.....	30

## **Texture**

Texture Coat (4Plastic 2K).....	31
Smooth Coat (4Plastic 2K).....	32
Duplicating OE Textures (1K).....	33

Always wear required Personal Protection Equipment (PPE) as outlined on the SDS and product label to ensure safety.  
Check with VOC regulations to ensure compliance of all products in your area.

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# DAMAGE REPAIR

## STANDARD OPERATING PROCEDURE

### 1 PREP & SAND



Clean the surface with **SEM Solve** or **XXX Universal Surface Cleaner**.

Sand the repair area using 80-grit on a DA sander. Remove all paint 2-4" beyond the damaged area. Featheredge the paint with 180-grit on a DA sander.

Blow off with clean, dry air and re-clean with **SEM Solve** or **XXX Universal Surface Cleaner**.

### 2 MIX AND APPLY FILLER



Mix **Powder-Pro** with supplied hardener. Mix by using pressure and long strokes to keep from introducing air into the mixture. Apply mixed **Powder-Pro** onto the damage while keeping within sanded area. Allow to cure roughly 15 minutes before sanding.

**!** **Powder-Pro** can be rough-shaped at ~9 minutes at 70° F (21° C)

### 3 SAND FILLER

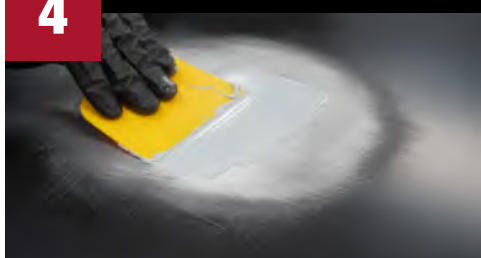


Sand filler with 80-120 grit sandpaper. Featheredge the repair with 180-grit sandpaper.

Inspect surface to verify if more filler is needed. if so, repeat steps 2-3.

Blow off to remove all sanding dust.

### 4 MIX AND APPLY GLAZE



Mix **Smooth Skim** finishing glaze with supplied hardener. Mix by using pressure and long strokes to keep from introducing air into the mixture. Apply mixed **Smooth Skim** onto the area while keeping within sanded area. Allow to cure roughly 15 minutes before sanding.

### 5 SAND GLAZE



Sand cured glaze with 180-grit sandpaper until the surface is level.

### 6 FINAL SAND



Final sand the area with 180-grit on a DA sander.

Blow off with clean, dry air to remove all dust.

Inspect the repair for any minor imperfections.

## 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



### ABRASIVES

Part	Product	Size
SA6080	6" Grip Multi-Hole 80-grit	6" DA
SA6180	6" Grip Multi-Hole 180-grit	6" DA
SA1120	2 3/4" Perforated Roll 120-grit	2 3/4" Roll
SA1080	2 3/4" Perforated Roll 80-grit	2 3/4" Roll
SA1180	2 3/4" Perforated Roll 180-grit	2 3/4" Roll



### FILLER

Part	Product	Size
40561	Powder-Pro Filler	Gallon
40592	Smooth Skim	24 oz. Tube

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



# STEEL PANEL REPLACEMENT

## STANDARD OPERATING PROCEDURE

### 1A SEALER REMOVAL METHOD #1



Remove seamer sealer using the **QLock Strip It Wheel**.

### 1B SEALER REMOVAL METHOD #2



Remove seamer sealer using the **Course Grit File Belt** attached to a file belt sander.

### 2A PART REMOVAL METHOD #1



Remove spot welds with spot weld cutter. Remove rivets by drilling or grinding. Remove damaged panel and straighten bent flanges with a hammer and dolly.

### 2B PART REMOVAL METHOD #2



Remove spot welds with **60 or 80-grit File Belt**.

### 3 PANEL CUTTING



Cut panel at OEM recommended area using a **Cut Off Wheel**.

### 4 EDGE STRAIGHTENING



Remove damaged panel and straighten bent flanges with a hammer and dolly.

### 5 PREP AND GRIND



Clean surfaces with **SEM Solve** or **XXX Universal Surface Cleaner**. Wipe clean in one direction with a clean, lint-free towel. Grind mating flanges with a 36-80 grit grinding disc at low speed for aggressive grind mark. Remove any adhesive or protective coatings.

### 6 WELD THROUGH PRIMER



Apply **Zincweld** weld through primer per OEM recommendations on flanges that do not use adhesives.

## 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



### ABRASIVES

Part	Product	Size
SA40020	QLock Strip It Wheel	4"
SA120CG	Course Grit File Belt	1/2" x 18"
SA380CG	Course Grit File Belt	3/8" x 13"
SA1060	60-grit File Belt	1/2" x 18"
SA1080	80-grit File Belt	1/2" x 18"
SA3060	60-grit File Belt	3/8" x 13"
SA3080	80-grit File Belt	3/8" x 13"
SA30004	.04" Cut-Off Wheel	3"
SA40004	.04" Cut-Off Wheel	4"
SA25036	36 grit QLock Grinding Disc	2"
SA25050	50 grit QLock Grinding Disc	2"
SA25080	80 grit QLock Grinding Disc	2"

Other sizes available on [semproducts.com](http://semproducts.com)



### WELD THROUGH PRIMER

Part	Product	Size
40773	Zincweld	16 oz. Aerosol

### SEM Products

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 Tech Support: 1-800-831-1122  
 Customer Care: 1-866-327-7829  
[semproducts.com](http://semproducts.com)



# PANEL & RIVET BONDING

## STANDARD OPERATING PROCEDURE

1

### REMOVE PART



Remove spot welds with spot weld cutter. Remove rivets by drilling or grinding. Remove damaged panel and straighten bent flanges with a hammer and dolly.

2

### DRY FIT



Dry fit all panels to ensure proper alignment. Drill holes for replacement rivets or mark locations of self-piercing rivets.

3

### PREP AND GRIND



Clean with **SEM Solve** or **XXX Universal Surface Cleaner**

Grind mating flanges with a 36-80 grit grinding disc, per product TDS, at low speed for an aggressive grind mark. Remove any adhesive or protective coatings.

ⓘ If rivet bonding, manufacturers may recommend leaving OEM e-coat on the surface of the new panel. If so, scuff with a red scuff pad.

4

### APPLY ADHESIVE



Apply 3/8" – 1/2" bead of **Dual-Mix™ Multi-Purpose Panel Adhesive** or **Structural Impact Resistant Adhesive** per OEM recommendation to both surfaces. Use enough material to completely fill the joint when parts are clamped. Tool with a spreader or acid brush. Cover all exposed bare metal.

ⓘ For smaller parts use **Dual-Mix™ Door Skin & SMC Adhesive**

5

### (OPTION 1) PANEL BONDING



Clamp panel into place. Do not over clamp. Wipe away excess material.

ⓘ Surfaces must be mated during adhesive's working time.

### (OPTION 2) RIVET BONDING



Clamp panel in place. Install rivets per manufacturer's recommendations during adhesive's working time. Remove clamps after rivets have been installed. Wipe away excess material.

## PRODUCT LIST



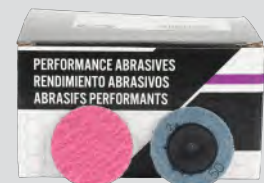
### PREP

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



### ADHESIVE

Part	Product	Size
39337	Dual-Mix Door Skin & SMC Adhesive	7 oz. Cartridge
39747	Dual-Mix Multi-Purpose Panel Adhesive	7 oz. Cartridge
39757	Dual-Mix Structural Impact Resistant Adhesive	7 oz. Cartridge



### ABRASIVES

Part	Product	Size
SA25036	36 grit QLock Grinding Disc	2" Disc
SA25050	50 grit QLock Grinding Disc	2" Disc
SA25080	80 grit QLock Grinding Disc	2" Disc

Other sizes available on [semproducts.com](http://semproducts.com)

### SEM Products

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# PANEL & WELD BONDING

## STANDARD OPERATING PROCEDURE

1

### REMOVE PART



Remove spot welds with spot weld cutter. Remove rivets by drilling or grinding. Remove damaged panel and straighten bent flanges with a hammer and dolly.

2

### DRY FIT



Dry fit all panels to ensure proper alignment. Drill holes for replacement rivets or mark locations of self-piercing rivets.

3

### PREP AND GRIND



Clean with **SEM Solve** or **XXX Universal Surface Cleaner**

Grind mating flanges with a 36-80 grit grinding disc at low speed for aggressive grind mark. Remove any adhesive or protective coatings.

4

### APPLY ADHESIVE



Apply 3/8" – 1/2" bead of **Dual-Mix™ Multi-Purpose Panel Adhesive** or **Structural Impact Resistant Adhesive** per OEM recommendation to both surfaces. Use enough material to completely fill the joint when parts are clamped. Tool with a spreader or acid brush. Cover all exposed bare metal.

ⓘ For smaller parts use **Dual-Mix™ Door Skin & SMC Adhesive**

5

### (OPTION 1) PANEL BONDING



Clamp panel into place. Do not over clamp. Wipe away excess material.

ⓘ Surfaces must be mated during adhesive's working time.

### (OPTION 2) WELD BONDING



Clamp panel in place. Weld panel by using Squeeze Type Resistance Spot Welding (STRSW) or traditional MIG welding per the manufacturer's recommendations during adhesive's working time. Remove clamps after welds have been completed. Wipe away excess material.

ⓘ No gaps are required for weld bonding through epoxy adhesives. Always follow OEM's instructions for guidelines.

## PRODUCT LIST



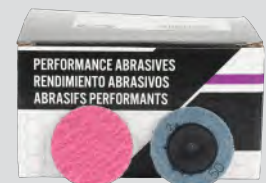
### PREP

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



### ADHESIVE

Part	Product	Size
39337	Dual-Mix Door Skin & SMC Adhesive	7 oz. Cartridge
39747	Dual-Mix Multi-Purpose Panel Adhesive	7 oz. Cartridge
39757	Dual-Mix Structural Impact Resistant Adhesive	7 oz. Cartridge



### ABRASIVES

Part	Product	Size
SA25036	36 grit QLock Grinding Disc	2" Disc
SA25050	50 grit QLock Grinding Disc	2" Disc
SA25080	80 grit QLock Grinding Disc	2" Disc

Other sizes available on [semproducts.com](http://semproducts.com)

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# SEM<sup>®</sup> SEAM SEALER REMOVAL

## STANDARD OPERATING PROCEDURE

### 1 PREP



Clean with **SEM Solve** or **XXX Universal Surface Cleaner**.

Wipe clean in one direction with a clean, lint-free towel.

### 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

### 2 METHOD #1



Remove seam sealer using the **QLock Strip It Wheel**.



### 3 METHOD #2



Remove seam sealer using the **Course Grit File Belt** attached to file belt sander.

### ABRASIVES

Part	Product	Size
SA40020	QLock Strip It Wheel	4"
SA120CG	Course Grit File Belt	1/2" x 18"
SA380CG	Course Grit File Belt	3/8" x 13"

LEARN MORE AT  
[www.semproducts.com](http://www.semproducts.com)

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

#### EQUIPMENT

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

**SEM Products**  
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 Tech Support: 1-800-831-1122  
 Customer Care: 1-866-327-7829  
[semproducts.com](http://semproducts.com)

# SEM<sup>®</sup> 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

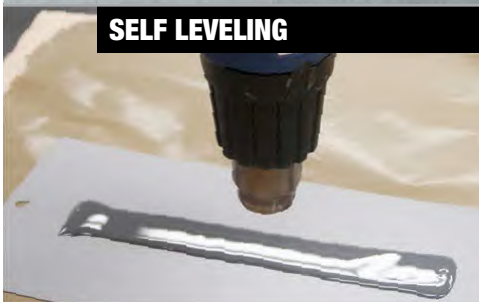


Apply **SEM 2K Seam Sealer**. Immediately smooth or tool **Seam Sealer** to match OEM texture.

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**



### 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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 semproducts.com

### WATCH & LEARN APPLY



WATCH THE VIDEO AT:  
[semproducts.com/sop-2K-seam-sealer](http://semproducts.com/sop-2K-seam-sealer)

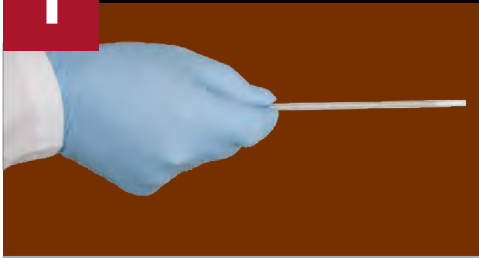


# INNER PANEL CORROSION PROTECTION

## STANDARD OPERATING PROCEDURE

1

### THE Rigid 360° Applicator



**Rust Preventer Cavity Wax** is easily applied with a 360° spray pattern when using the **Rigid 360° Applicator**.

⚠ Do not spray without tip being inserted into inner panel access point.

2

### PREP & APPLY



Clean accessible surfaces with **SEM Solve** or **XXX Universal Surface Cleaner**.

Remove cap from **Rust Preventer Cavity Wax** and attach straw or **Rigid 360° Applicator**.

Apply 1-2 coats

ⓘ Change angle and depth of the tip inside panel to ensure coverage.

### Pro Tip



Mark the end of the **Rigid 360° Applicator** with masking tape to keep from spraying outside the panel.

3

### CLEAN APPLICATOR



Clean **Rigid 360° Applicator** by attaching the tip and Applicator to **XXX Universal Gun Cleaner**.

ⓘ Spray into enclosed container or clean cloth until applicator is clean. Wipe off residual remnants from outside of tube

### 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



### APPLICATIONS

Part	Product	Size
39573	Rust Preventer Cavity Wax	24 oz. Aerosol



### EQUIPMENT

Part	Product	Size
71360	Rigid 360° Applicator	Kit



### CLEAN-UP

Part	Product	Size
77743	XXX Gun Cleaner	20 oz. Aerosol
77763	XXX Universal Gun Cleaner	

LEARN MORE ABOUT RUST PREVENTER CAVITY WAX AT [semproducts.com/product/rust-preventer-cavity-wax](http://semproducts.com/product/rust-preventer-cavity-wax)

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



# SPRAYABLE SOUND DAMPENING

## STANDARD OPERATING PROCEDURE

### 1 PREP



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

### 2 SAND



Sand primer with P180 grit. Sand bare metal with P80 grit. Blow off and tack clean. Re-clean with **SEM Solve** or **XXX Universal Surface Cleaner**. Wipe clean in one direction with clean, lint-free cloth.

### 3 SET UP EQUIPMENT



Place **Dual-Mix™ Sound & Seal Sprayable Coating** into **Universal Pneumatic Applicator**. Equalize cartridge until sides dispense equally. Attach **Quick Spray System** to applicator and cartridge.

⚠ Do not cut static mixer tip.

### 4 APPLY

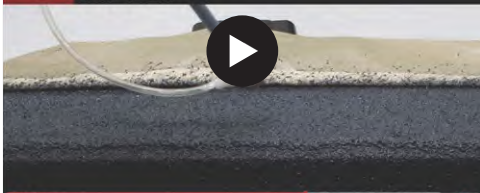


Apply to necessary areas, duplicating existing texture in one coat.

⚠ Do not apply over self etching primer.

ⓘ To achieve various textures, modify the air pressure, spray distance and spray tip.

### WATCH & LEARN



WATCH THE VIDEO AT:  
[semproducts.com/sop-sound-dampening](http://semproducts.com/sop-sound-dampening)

### PRODUCT LIST



#### PREP

Part	Product	Size
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Square Quart
40401	XXX Universal Surface Cleaner	Gallon
40404	XXX Universal Surface Cleaner	Quart



#### APPLY

Part	Product	Size
40977	Dual-Mix Sound & Seal Sprayable Coating	7 oz. Cartridge



#### EQUIPMENT

Part	Product
70039	Universal Pneumatic Applicator
70100	Quick Spray System Starter Kit



#### ABRASIVES

Part	Product	Size
SA1080	Perf-Roll Grip 80-grit	2.75" x 33.5'
SA1180	Perf-Roll Grip 180-grit	2.775" x 33.5'

### ADDITIONAL 2K SOUND DAMPENING PRODUCTS



#### DUAL-MIX CARTRIDGES

Part	Product	Size
39357	Flexible Urethane Foam	7 oz. Cartridge
39977	Panel Vibration Control Material	7 oz. Cartridge
39997	Rigid Urethane Foam Cartridge	7 oz. Cartridge

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

# SEM<sup>®</sup> UNDERCOATING

## STANDARD OPERATING PROCEDURE

1

### PREP



Clean area to be sprayed with soap and water. Allow to fully dry.

For grease or oil, clean with **SEM Solve** or **XXX Universal Surface Cleaner**.

### 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

2

### SCALE REMOVAL



Remove any loose scale with **QLock Strip it Wheel**.

Blow off with clean, dry air.



#### ABRASIVES

Part	Product	Size
SA40020	QLock Strip It Wheel	4"

3

### UNDERCOAT



Apply **Rubberized Undercoating** or **Undercoating**.

Distance: 6-12"  
Coats: 2-3 medium wet  
Flash: 5-10 minutes



#### UNDERCOATS

Part	Product	Size
39523	Rubberized Undercoating	24 oz. Aerosol
40523	Low VOC Rubberized Undercoating	24 oz. Aerosol
39463	Undercoating	24 oz. Aerosol
40463	Low VOC Undercoating	24 oz. Aerosol

LEARN MORE ABOUT UNDERCOATING AT  
[www.semproducts.com](http://www.semproducts.com)

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Customer Care: 1-866-327-7829  
[semproducts.com](http://semproducts.com)



# 2K LOWER PANEL PROTECTION

## 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, CLEAN & PRIME



Sand with 180-220 grit sandpaper.

Prime any bare metal and aluminum areas as per manufacturer's instructions.

Sand e-coat with a **Maroon Scuff Pad**.

Sand primer with 180-220 grit sandpaper.

Blow off and tack clean before application.

3

### IDENTIFY TEXTURE



Use the photo on the back of box to choose the appropriate texture.

Scan the QR code to download the product TDS for detailed instructions on how to duplicate the texture

4

### MIX



Add activator to bottle of **2K Urethane Chip Guard**. Shake bottle for two minutes before applying.

**2K Urethane Chip Guard** can also be tinted with solvent-based toners by adding 1 oz. of tint to the bottle.

ⓘ Tinting is not required

5

### APPLY TEXTURE



Attach mixed bottle to **2K Urethane Chip Guard Applicator** or pour into spray gun called out in instructions for duplicating texture.

Follow instructions for correct air pressure and distance.

ⓘ

6

### FINISH & CLEAN



Remove masking tape while final coat is still wet. Clean gun with **XXX Universal Gun Cleaner** or solvent complaint with VOC regulations in your area.

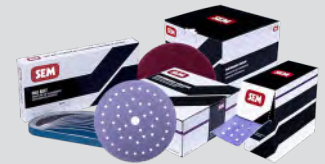
Visit our website for more information:  
[www.semproducts.com](http://www.semproducts.com)

### 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



### SAND, CLEAN & PRIME

Part	Product	Size
SA6180	6" Grip Multi-hole 180-grit	6" DA
SA6220	6" Grip Multi-hole 220-grit	6" DA
SA4947	4.5" x 9" Maroon Scuff Pad	4.5" x 9"



### MIX

Part	Product	Size
52000	2K Urethane Chip Guard	Kit



### APPLY, FINISH & CLEAN

Part	Product	Size
71103	2K Urethane Chip Guard Applicator	Each
77763	XXX Universal Gun Cleaner	20 oz. Aerosol

SEM Products  
Rock Hill, SC 29730  
Tech Support: 1-800-831-1122  
Customer Care: 1-866-327-7829  
[semproducts.com](http://semproducts.com)

# SEM<sup>®</sup> TRUCKBED LINERS

## STANDARD OPERATING PROCEDURE

### 1 PREP



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

### 2 SAND & PRIME



Remove all rust. Sand inside of bed with P180 – P220 grit or a bed brush. Truckbed liners may be sprayed over OEM finishes.

⚠ Prime bare metal with direct-to-metal epoxy or 2K urethane primer. Allow primer to fully cure. Sand primer with P180 – P220 grit or a bed brush.

Blow off dust and tack clean. Mask off areas that are not to be sprayed.

### 3 APPLY



ⓘ Refer to the **Technical Data Sheet** for mixing instructions.

Spray 2 – 3 light coats. Allow proper flash time between coats. The first coat should not achieve full coverage and subsequent coats should be applied in the same manner. Remove masking tape immediately after applying final coat.



WATCH THE VIDEO AT:  
[semproducts.com/sop-truckbed-liner](http://semproducts.com/sop-truckbed-liner)

### WATCH & LEARN



### PRODUCT LIST



#### GLADIATOR™ XC

Part	Product	Size
56650	Gladiator XC Kit - Black	Gallon Kit
56670	Gladiator XC Kit - Tintable	Gallon Kit

Available in other sizes



#### ROCK-IT XC™

Part	Product	Size
46650	Rock-It XC Kit - Black	Gallon Kit
46670	Rock-It XC Kit - Tintable	Gallon Kit

Available in other sizes

### 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

#### ABRASIVES

Part	Product	Size
SA6180	6" Grip 180-grit	6" DA
SA6220	6" Grip 220-grit	6" DA



# SEM<sup>®</sup> PLASTIC REPAIR

## STANDARD OPERATING PROCEDURE

### 1 PREP



Clean front and back with **Scuff & Clean** and damp, gray scuff pad. Rinse with water and dry or wipe with a clean, damp cloth until removed. Clean front and back with **SEM Solve**, **Plastic & Leather Prep** or **XXX Universal Surface Cleaner**. Wipe clean in one direction with dry, lint-free cloth.

### 2 SAND & DISH



On front side, sand repair area with P80 grit. Dish out damage with P36 grit disc at a low RPM. On back side, grind repair area with P36 grit disc at a low RPM. Blow off surfaces.

- ① Paint does not need to be stripped from the repair if it has good adhesion. Do not grind too fast and cause plastic to melt. (Optional) Apply
- ① **XXX Adhesion Promoter** to all prepped surfaces.

### 3 REINFORCE & FILL BACK



Mask front side of repair to prevent repair material from flowing through. Apply **Plastic Repair Contouring Tape** (mesh only) to back side. Apply **Dual-Mix™ Multi-Plastic Repair Material** or **Dual-Mix Problem Plastic Repair Material** and cover mesh tape. Spread material firmly. Allow to set.

### 4 REINFORCE & FILL FRONT



Remove tape from front. Fill front with **Dual-Mix Multi-Plastic Repair Material** or **Dual-Mix Problem Plastic Repair Material**. Spread material firmly and build up higher than panel to allow for sanding. Allow to set before sanding.

### 5 SAND & SKIM



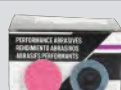
Sand with P80 grit. Finish with P180 grit. If needed, use a skim coat of **Flexion Flexible Finishing Putty**, then sand with P180 – P320 grit.

- ① Refer to **Plastic Refinishing SOP** for refinishing steps.

### WATCH & LEARN



WATCH THE VIDEO AT:  
[semproducts.com/sop-plastic-repair](http://semproducts.com/sop-plastic-repair)



### ABRASIVES

Part	Product	Size
SA25036	2" 36-grit Grinding Disc	2"
SA6080	6" Grip 80-grit	6" DA
SA6180	6" Grip 180-grit	6" DA

Other sizes and grits available at [semproducts.com](http://semproducts.com)

### PRODUCT LIST



### PREP

Part	Product	Size
38391	Scuff & Clean	Gallon Pump
38398	Scuff & Clean	16 oz. Tube
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Square Quart
38351	Plastic & Leather Prep	Gallon
38353	Plastic & Leather Prep	16 oz. Aerosol
38354	Plastic & Leather Prep	Cone Quart
77721	XXX Adhesion Promotor	Gallon
77723	XXX Adhesion Promotor	16 oz. Aerosol
77724	XXX Adhesion Promotor	Cone Top Quart
77771	XXX Universal Surface Cleaner	Gallon
77774	XXX Universal Surface Cleaner	Quart



### REINFORCE & FILL

Part	Product	Size
70007	Plastic Repair Contouring Tape	15' Roll
39767	Problem Plastic Repair Material	7 oz. Cartridge
39847	Multi-Plastic Repair Material	7 oz. Cartridge



### SAND AND SKIM

Part	Product	Size
40572	Flexion Flexible Finishing Putty	16 oz. Tube

SEM Products  
 Rock Hill, SC 29730  
 Tech Support: 1-800-831-1122  
 Customer Care: 1-866-327-7829  
[semproducts.com](http://semproducts.com)

# SEM<sup>®</sup> PLASTIC TAB REPAIR

## STANDARD OPERATING PROCEDURE

### 1 PREP



Clean front and back with **Scuff & Clean** and damp, gray scuff pad. Rinse with water and dry with clean, lint-free cloth. Clean front and back with **SEM Solve**, **Plastic & Leather Prep** or **XXX Universal Surface Cleaner**. Wipe clean in one direction with dry, lint-free cloth.

### 2 GRIND & ADHESION PROMOTER



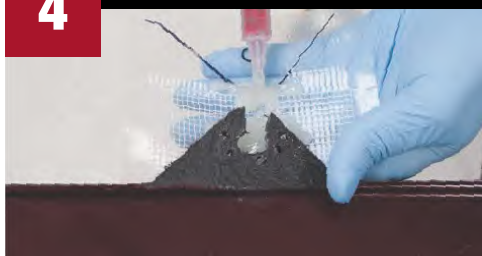
Grind repair on both sides at low RPM or by hand with P36 grit disc. Drill 1/8" holes in repair area to help "lock in" the repair material. Blow off surface.  
 ⚠ Do not grind too fast and cause plastic to melt.  
 ⓘ For TPO, EPDM, PP and similar plastics, apply **Adhesion Promoter** as per instructions.

### 3 CREATE TEMPLATE (OPTIONAL)



Cut enough **Plastic Repair Contouring Tape** to fold around both sides of the tab. Use permanent marker to trace a good tab for a template.

### 4 APPLY QUICK SET



Apply **Dual-Mix™ Quick Set Adhesive** to the mesh side of tape. While wet, fold the tape around broken tab and press firmly to smooth. After cool down, remove **Plastic Repair Contouring Tape** release film.

### 5 FINISH



Grind the tab back to its original shape and size. Re-drill the bolt hole.

### WATCH & LEARN



WATCH THE VIDEO AT:  
[semproducts.com/sop-plastic-tab-repair](http://semproducts.com/sop-plastic-tab-repair)



### ABRASIVES

Part	Product	Size
SA25036	2" 36-grit Grinding Disc	2"
SA35036	3" 36-grit Grinding Disc	3"

### PRODUCT LIST



### PREP

Part	Product	Size
38391	Scuff & Clean	Gallon Pump
38398	Scuff & Clean	16 oz. Tube
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Square Quart
38351	Plastic & Leather Prep	Gallon
38353	Plastic & Leather Prep	16 oz. Aerosol
38354	Plastic & Leather Prep	Cone Top Quart
77771	XXX Universal Surface Cleaner	Gallon
77774	XXX Universal Surface Cleaner	Quart
39861	Plastic Adhesion Promoter	Gallon
39863	Plastic Adhesion Promoter	20 oz. Aerosol
39864	Plastic Adhesion Promoter	Cone Top Quart
77721	XXX Adhesion Promoter	Gallon
77723	XXX Adhesion Promoter	16 oz. Aerosol
77724	XXX Adhesion Promoter	Cone Top Quart



### APPLICATION

Part	Product	Size
70007	Plastic Repair Contouring Tape	15' Roll
40202	Quick Set 20	1.7 oz. Cartridge
40207	Quick Set 20	7 oz. Cartridge
40502	Quick Set 50	1.7 oz. Cartridge
40507	Quick Set 50	7 oz. Cartridge
40517	Quick Set 50 - Clear	7 oz. Cartridge
41807	Quick Set 180	7 oz. Cartridge

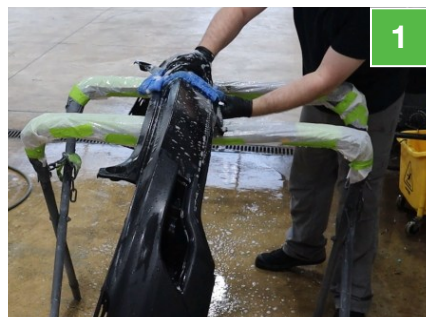
### SEM Products

Rock Hill, SC 29730  
 Tech Support: 1-800-831-1122  
 Customer Care: 1-866-327-7829  
[semproducts.com](http://semproducts.com)

# FUSE-WELDING PROCESS

## Standard Operating Procedure

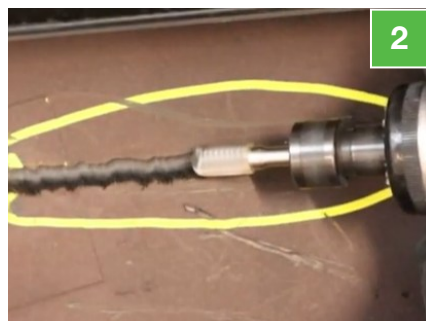
SOP4P03-EN-1125



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)

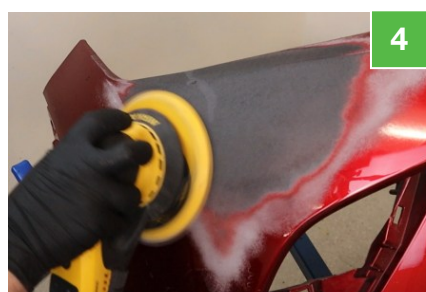
- Channel the tear 1/2 the depth of the plastic using the Burr Grinder.
- Use Weld Support Tape to reinforce the opposite side while completing the repair.
- Fuse weld the split. Select the appropriate heat setting on the welder, 1100-1200°F (600-650°C) for a 5 mm welding nozzle.
- The welding strip 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.

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

### 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)

**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)  
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# BASIC MASKING

## 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 EDGE MASKING



Mask edges and trim molding with 3/4" **Auto Refinishing Masking Tape**.

**Fine edge masking**  
Mask all fine edges with **Blue Fine Line Tape** prior to applying **Auto Refinishing Masking Tape**.

### 3 OVERSPRAY PROTECTION



Protect rest of vehicle by applying plastic sheeting.

Protect repair perimeter with masking paper.

**i** All surfaces must be completely dry before applying plastic sheeting

### 4 REMOVAL



Remove tape at a 90° angle to the vehicle's surface after painting.

### 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



#### Edge Masking

Part	Product	Size
SM0018	3/4" Masking Tape	3/4" Roll
SM0024	1" Masking Tape	1" Roll
SM0036	1.5" Masking Tape	1.5" Roll
SM0048	2" Masking Tape	2" Roll
SM0072	3" Masking Tape	3" Roll
SM0009	.12" Blue Fine Line Masking Tape	Roll
SM0010	.24" Blue Fine Line Masking Tape	Roll
SM0011	.47" Blue Fine Line Masking Tape	Roll



#### Overspray Protection

Part	Product	Size
SM01635	16' Plastic Sheeting	16' x 350'
SM02025	20' Plastic Sheeting	20' x 250'

#### SEM Products

Rock Hill, SC 29730 Tech Support:  
1-800-831-1122 Customer Care:  
1-866-327-7829 [semproducts.com](http://semproducts.com)

# SEM<sup>®</sup> PLASTIC REFINISHING

## STANDARD OPERATING PROCEDURE

### 1 PREP & PRIME



ⓘ If damage is present, refer to **Plastic Repair SOP** first.

Clean with **Scuff & Clean** and a damp, **Gray Scuff Pad**. Rinse with water and dry with clean, lint-free cloth. Clean with **SEM Solve**, **Plastic & Leather Prep** or **XXX Universal Surface Cleaner**. Wipe clean in one direction with clean, lint-free cloth. Prime as per manufacture instructions.

### 2 GUIDE COAT & SAND



Apply **Guide Coat Black** or **Premium Powder Guide Coat** to dried primer. Sand with 320 – 400 grit. Finish sanding with 600 grit.

### 3 ADD TEXTURE IF NEEDED



Apply **Texture Coating** or **Chip Guard** as per instructions.

### 4 PAINT



Apply **Bumper Coater™**, **Factory Pack™** or other automotive paint per instructions.

### PRODUCT LIST



#### GUIDE COAT

Part	Product	Size
38203	Guide Coat Black	16 oz. Aerosol
38253	Premium Powder Guide Coat	16 oz. Aerosol



#### TEXTURE

Part	Product	Size
39853	Texture Coating	20 oz. Aerosol
39793	Heavy Texture Chip Guard	20 oz. Aerosol
39803	Clear Chip Guard	20 oz. Aerosol
39813	Satin Black Chip Guard	20 oz. Aerosol



#### ABRASIVES

Part	Product	Size
SA4948	Gray Scuff Pad	4.5" x 9"
SA6320	6" Grip 320-grit	6" DA
SA6400	6" Grip 400-grit	6" DA
SA6600	6" Grip 600-grit	6" DA



#### PAINT

Part	Product	Size
39xxx	Bumper Coater	
19xxx	Factory Pack	

#### SEM Products

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 Tech Support: 1-800-831-1122  
 Customer Care: 1-866-327-7829  
 semproducts.com



#### PREP

Part	Product	Size
38391	Scuff & Clean	Gallon Pump
38398	Scuff & Clean	16 oz. Tube
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Square Quart
38351	Plastic & Leather Prep	Gallon
38353	Plastic & Leather Prep	16 oz. Aerosol
38354	Plastic & Leather Prep	Cone Top Quart
77771	XXX Universal Surface Cleaner	Gallon
77774	XXX Universal Surface Cleaner	Quart



#### HIGH-BUILD PRIMER AEROSOLS

Part	Color	Size
42003	Black	20 oz. Aerosol
42013	Gray	20 oz. Aerosol
42023	Beige	20 oz. Aerosol
42033	Rose	20 oz. Aerosol
42043	White	20 oz. Aerosol

See back side for complete list of Primers.



# E-COAT PANEL PREP

## 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

### HAND SANDING



Sand edges and other hard to reach areas with 400-grit sheetroll sandpaper attached to a soft pad or by using a **Maroon Scuff Pad**.

# 3

### DA SANDING



Sand all other surfaces using 400-grit sandpaper on a DA sander.

# 4

### RE-CLEAN



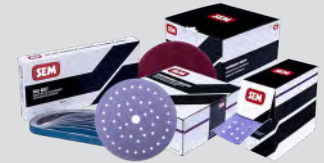
Blow off and re-clean using **SEM Solve** or **XXX Universal Surface Cleaner**. Wipe clean in one direction with dry, lint-free cloth.

### 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



### SANDING

Part	Product	Size
SA1400	Grip Perf-Roll 400-grit	2.75" Roll
SA22400	PSA Roll 400-grit	2.75" Roll
SA6400	6" Grip Multi-hole 400-grit	6" DA
SA4947	Maroon Scuff Pad	4.5" x 9"

### SEM Products

Rock Hill, SC 29730  
Tech Support: 1-800-831-1122  
Customer Care: 1-866-328-7829  
semproducts.com



# SEM<sup>®</sup> FEATHER-PRIME-BLOCK

## STANDARD OPERATING PROCEDURE

1

### FEATHEREDGE

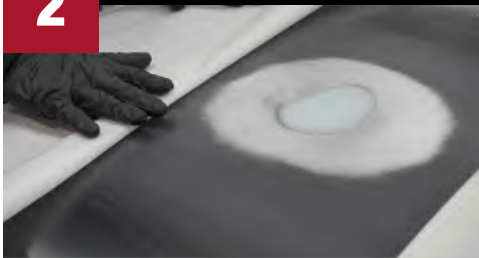


Featheredge the repair area with 180-grit, then 320-grit on a DA sander.

Blow off and clean with **SEM Solve** or **XXX Universal Surface Cleaner**.

2

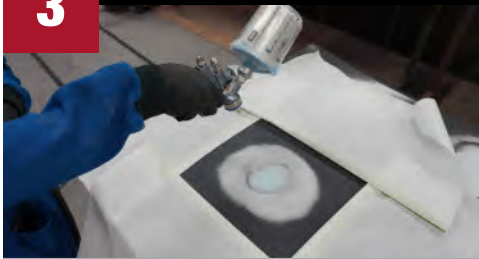
### MASK FOR PRIMER



Back-mask the repair area to be primed.

3

### APPLY PRIMER



Apply primer per manufacturer recommendations

4

### GUIDE COAT



Apply **Premium Powder Guide Coat** or **Guide Coat Black** onto the surface by spraying light mist coats.

Wipe of any overspray with a clean, dry cloth.

5

### BLOCK SAND



Block sand with 320-grit sheetroll sandpaper.

Visually inspect while sanding for high or low spots indicated by the guide coat.

Address high or low spots before proceeding.

6

### FINISH SAND & RE-CLEAN



Finish sand the area with 400-grit sandpaper on a DA with a soft interface pad.

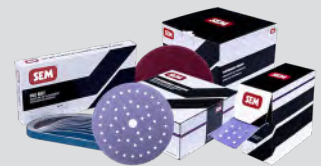
Blow off and clean the surface using **SEM Solve** or **XXX Universal Surface Cleaner**.

## 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



### ABRASIVES

Part	Product	Size
SA6400	6" Grip Multi-hole 400-grit	6" DA
SA1320	2.75" Perf-Roll 320-grit	2.75" Roll
SA6180	6" Grip Multi-hole 180-grit	6" DA
SA6320	6" Grip Multi-hole 320-grit	6" DA



### GUIDE COAT

Part	Product	Size
38253	Premium Powder Guide Coat	16 oz. Aerosol
38203	Guide Coat Black	16 oz. Aerosol

### SEM Products

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



# FEATHER-PRIME-BLOCK WATERBORNE

## STANDARD OPERATING PROCEDURE

**1**

### FEATHEREDGE

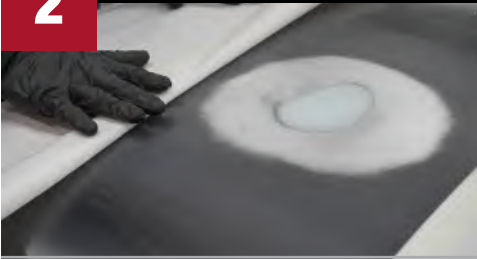


Featheredge the repair area with 180-grit, then 320-grit on a DA sander.

Blow off and clean with **SEM Solve** or **XXX Universal Surface Cleaner**.

**2**

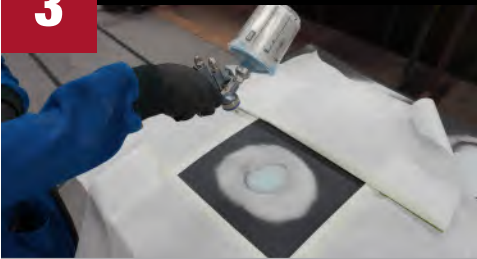
### MASK FOR PRIMER



Back-mask the repair area to be primed.

**3**

### APPLY PRIMER



Apply primer per manufacturer recommendations

**4**

### GUIDE COAT



Apply **Premium Powder Guide Coat** or **Guide Coat Black** onto the surface by spraying light mist coats. Wipe of any overspray with a clean, dry cloth.

**5**

### BLOCK SAND



Block sand with 320-grit sheetroll sandpaper.

Visually inspect while sanding for high or low spots indicated by the guide coat.

Address high or low spots before proceeding.

**6**

### FINISH SAND & RE-CLEAN



Finish sand the area with 600-800-grit sandpaper on a DA with a soft interface pad.

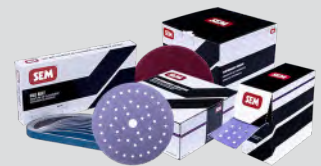
Blow off and clean the surface using **SEM Solve** or **XXX Universal Surface Cleaner**.

### PRODUCT LIST



### PREP

Part	Product	Size
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Square Quart
7771	XXX Universal Surface Cleaner	Gallon
7774	XXX Universal Surface Cleaner	Quart



### ABRASIVES

Part	Product	Size
SA6600	6" Grip Multi-hole 600-grit	6" DA
SA6800	6" Grip Multi-hole 800-grit	6" DA
SA1320	2.75" Perf-Roll 320-grit	2.75" Roll
SA6180	6" Grip Multi-hole 180-grit	6" DA
SA6320	6" Grip Multi-hole 320-grit	6" DA



### GUIDE COAT

Part	Product	Size
38253	Premium Powder Guide Coat	16 oz. Aerosol
38203	Guide Coat Black	16 oz. Aerosol

### SEM Products

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



# BLEND PANEL SANDING

## 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**

### EDGE SANDING



Sand edges and other hard to reach areas with 800-1000-grit sandpaper attached to a soft pad or a Gray Scuff Pad.

**3**

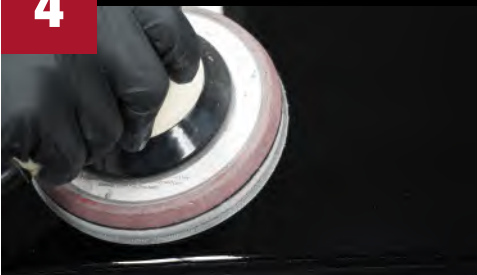
### COLOR BLEND SANDING



Sand color blend area with 800-grit sandpaper on a DA sander with a soft interface pad attached.

**4**

### ADJACENT PANEL SANDING



Sand all other adjacent panels with 1000-grit sandpaper on a DA sander with a soft interface pad attached.

**5**

### RE-CLEAN



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

### 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

### ABRASIVES

Part	Product	Size
SA6800	6" Grip Multi-hole 800-grit	6" DA
SA61000	6" Grip Multi-hole 1000-grit	6" DA
SA4948	Gray Scuff Pad	4.5" x 9"

### SEM Products

Rock Hill, SC 29730  
 Tech Support: 1-800-831-1122  
 Customer Care: 1-866-327-7829  
[semproducts.com](http://semproducts.com)

# SEM<sup>®</sup> OEM REFINISHING SYSTEM™

## STANDARD OPERATING PROCEDURE



### 1 PREP

Clean with **SEM Solve** or **XXX Universal Surface Cleaner**. Wipe clean in one direction with dry, lint-free cloth. Scuff with P400 grit or Maroon Scuff Pad. Blow off and wipe with tack rag if needed.



### 2 EZ COAT™

Choose appropriate **Ez Coat™** color. Apply 1 coat until hiding. Flash time achieved while moving across larger parts.

ⓘ Smaller parts may require 1 - 2 minutes to properly flash.



### 3 FACTORY PACK™

Choose appropriate **Factory Pack™** color. Apply 1 coat until hiding. Flash time achieved while moving across larger parts.

ⓘ Smaller parts may require 1 - 2 minutes to properly flash.



### 4 1K CLEAR

Choose **1K HS Clear (Matte, Semi-Gloss or Gloss)**. Apply 1 coat until covered. Allow 30 – 60 minutes before assembly or installation.



WATCH THE VIDEO AT:  
[semproducts.com/sop-ors](http://semproducts.com/sop-ors)



### ABRASIVES

Part	Product	Size
SA4947	Maroon Scuff Pad	4.5" x 9"
SA1320	Perf-Roll 400-grit	2.75" Roll

### 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



### EZ COAT

Part	Color	Size
62213	Black	16 oz. Aerosol
62223	Olive Green	16 oz. Aerosol
62233	Light Green	16 oz. Aerosol
62243	Gray	16 oz. Aerosol
62253	Tan	16 oz. Aerosol
62263	Olive Brown	16 oz. Aerosol
62273	White	16 oz. Aerosol
62283	Field Drab	16 oz. Aerosol
62293	Dark Green	16 oz. Aerosol



### FACTORY PACK

Part	Product	Size
19xxx	Factory Pack	16 oz. Aerosol



### 1K CLEAR

Part	Product	Size
40903	1K HS Gloss Clear	20 oz. Aerosol
40913	1K HS Semi-Gloss Clear	20 oz. Aerosol
40923	1K HS Matte Clear	20 oz. Aerosol

### SEM Products

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Customer Care: 1-866-327-7829  
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**REDUCE LABOR UP TO 85%**  
WHEN REFINISHING SUPPORT PARTS, CUT-INS & JAMBS

# SEM<sup>®</sup> REFINISHING TRIM STANDARD OPERATING PROCEDURE

## 1 METAL PREP



Clean with **SEM Solve** or **XXX Universal Surface Cleaner**. Wipe clean in one direction with dry, lint-free cloth. Sand with P400 grit or a Maroon Scuff Pad and blow off. Re-clean with **SEM Solve** or **XXX Universal Surface Cleaner**. Wipe clean in one direction with dry, lint-free cloth.

## PLASTIC PREP



Clean with **SEM Soap** and a damp, Gray Scuff Pad. Rinse with water and dry. Clean with **Plastic & Leather Prep** and a lint-free cloth.

⚠ Repeat above steps if water beads on surface.

ⓘ For TPO, EPDM, PP and similar plastic, apply **Sand Free** or **Adhesion Promoter** as per instructions.

## 2 AEROSOL APPLICATION



Apply **Trim Black**.

Coats: 2 medium

Flash time: 5 – 10 minutes between coats

Dry to touch in 1 hour, achieves full hardness in 24 – 48 hours.

## SPRAY GUN APPLICATION



Reduce 1:1 with urethane reducer. Apply **Trim Black**.

Air pressure: 20 – 25 psi with non-HVLP equipment  
8 – 10 PSI at the cap with HVLP

Fluid tip: 1.2 – 1.4 fluid tip size

Coats: 2 medium wet

Flash time: 5 – 10 minutes between coats

Dry to touch in 1 hour, achieves full hardness in 24 – 48 hours.

## WATCH & LEARN



WATCH THE VIDEO AT:  
[semproducts.com/sop-refinish-trim](http://semproducts.com/sop-refinish-trim)



## ABRASIVES

Part	Product	Size
SA6400	6" Grip 400-grit	6" DA
SA4947	Maroon Scuff Pad	4.5" x 9"
SA4948	Gray 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
39362	SEM Soap	Gallon Pump
38351	Plastic & Leather Prep	Gallon
38353	Plastic & Leather Prep	16 oz. Aerosol
38354	Plastic & Leather Prep	Cone Top Quart
38363	Sand Free Adhesion Promoter	16 oz. Aerosol
38364	Sand Free Adhesion Promoter	Cone Top Quart
39861	Plastic Adhesion Promoter	Gallon
39863	Plastic Adhesion Promoter	20 oz. Aerosol
39864	Plastic Adhesion Promoter	Cone Top Quart
77721	XXX Adhesion Promoter	Gallon
77723	XXX Adhesion Promoter	16 oz. Aerosol
77724	XXX Adhesion Promoter	Cone Top Quart

### APPLICATION

Part	Product	Size
39033	Trim Black Charcoal Metallic	16 oz. Aerosol
39063	Trim Black Gloss Black	16 oz. Aerosol
39068	Trim Black Gloss Black	Pint
39141	Trim Black	Gallon
39143	Trim Black	20 oz. Aerosol
39144	Trim Black	Quart
39141-LV	Low VOC Trim Black	Gallon
39144-LV	Low VOC Trim Black	Quart
49133	Trim Black Ultra - Matte	20 oz. Aerosol
49143	Trim Black Ultra - Satin	20 oz. Aerosol
49153	Trim Black Ultra - Gloss	20 oz. Aerosol

**SEM Products**  
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[semproducts.com](http://semproducts.com)

THE INDUSTRY STANDARD

# TRIM BLACK



# FILLING A CUSTOM FILL™ AEROSOL BLANK

## STANDARD OPERATING PROCEDURE

### 1 PREP



Remove disc from cap and insert over piston inside the fill machine. Place clear plastic cap into the **Fill Cylinder**. Press down and rotate cap until it drops into place.

⚠ Do not fill cap prior to inserting in **Fill Cylinder** and onto **Custom Fill Aerosol Blank**.

### 2 FILL THE CUP



Remove the tip from the aerosol. Press the cylinder/cap assembly on top of aerosol blank. Fill the clear plastic cap with paint to the fill line.

⚠ Solvent blanks can be filled with single stage urethane, enamel and lacquers as well as 2K primers, sealers and clear coats. The waterborne blank can be filled with most waterborne basecoats and top coats. Always check for compatibility prior to filling.

### 3 LOCK ASSEMBLY IN PLACE



Place assembly into machine. Hold cylinder and can assembly in place and tighten pedestal on bottom. Close door on **Custom Fill Machine**.

### 4 FILL THE AEROSOL



**FOR MANUAL MACHINE:** Rotate crank until it stops and then rotate in the opposite direction until it stops.  
**FOR PNEUMATIC MACHINE:** After closing the door, the machine will fill the aerosol. Wait until the machine is silent. Open the door and loosen pedestal to remove assembly from the machine.

### 5 REMOVE CAP & REPLACE TIP



Remove cylinder/cap assembly from machine. Twist gently to remove cylinder from can. Hold cylinder and press down on a hard surface to remove cap. Replace tip.

⚠ Purge valve by test spraying for a few seconds until spray is uniform.

ℹ Mark filled aerosol with coating type, color name

### WATCH & LEARN



WATCH THE VIDEO AT:  
[semproducts.com/sop-custom-fill](http://semproducts.com/sop-custom-fill)

### PRODUCT LIST



### CUSTOM FILL AEROSOL BLANKS

Part	Product	Size
61993	Custom Fill (Solvent)	16 oz. Aerosol
62003	Custom Fill Waterborne	16 oz. Aerosol
62013	Custom Fill + High Build	16 oz. Aerosol



### MACHINES

Part	Product
70701	Custom Fill Pneumatic Machine
70704	Wall Bracket
70706	Fill Cylinder
70801	Custom Fill Manual Machine

**SEM Products**  
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# VCS™ VERSATILE CUP SYSTEM

## STANDARD OPERATING PROCEDURE

SOPVCS  
0426

1

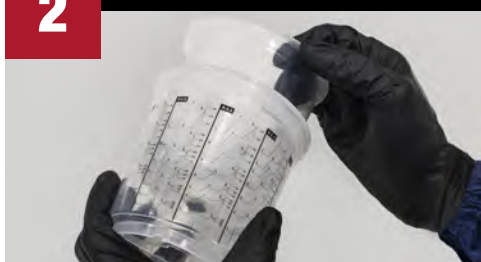
### INSTALL ADAPTER



Review crossover sheet to determine the correct adapter for your spray gun.  
Insert adapter into spray gun and tighten.

2

### INSTALL LINER



Insert liner into hard cup. Make sure to align vent tabs on liner with slots in bottom of hard cup.  
Turn liner clockwise to lock in place.  
Fill cup with desired material.

3

### ATTACH LID



Firmly press lid onto assembled cup and liner.  
Lock down all four lid tabs.

4

### ATTACH CUP TO SPRAY GUN



Press adapter onto assembled cup.  
Align locking tabs on adapter to corresponding tabs on lid.  
Turn clockwise until lid locks in place.

⚠ Locking only takes a quarter turn.

5

### OPEN/CLOSE RUBBER VENT



Open rubber vent in liner for most spray applications.  
For inverted spray applications, close vent and allow liner to collapse.

⚠ Don't forget to close vent for liquids storage or when inverting.



### WATCH & LEARN



Watch the training video and download additional literature at:  
[semproducts.com/vcs-video](http://semproducts.com/vcs-video)

## PRODUCT LIST



### ADAPTERS

Part	Product	Quantity
92501	Adapter 1	10 per case
92510	Adapter 10	10 per case
92511	Adapter 11	10 per case
92512	Adapter 12	10 per case
92513	Adapter 13	10 per case
92520	Adapter 20	10 per case
92521	Adapter 21	10 per case
92530	Adapter 30	10 per case
92540	Adapter 40	10 per case
92550	Adapter 50	10 per case
92560	Adapter 60	10 per case

Review crossover sheet to determine the correct adapter for your spray gun.



### HARD CUPS

Part	Product	Quantity
92130	32 oz. Hard Cup w/ratios	20 per case
92132	32 oz. Blank Hard Cup	20 per case
92110	22 oz. Hard Cup w/ratios	20 per case
92112	22 oz. Blank Hard Cup	20 per case
92120	13 oz. Hard Cup w/ratios	20 per case
92122	13 oz. Blank Hard Cup	20 per case



### LINERS

Part	Product	Quantity
92200	32 oz. Liner	200 per case
92210	22 oz. Liner	200 per case
92220	13 oz. Liner	200 per case



### LIDS

Part	Product	Quantity
92300	Lid with 125 Micron Filter & Cap	200 Lids & 100 Caps per case

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# SMALL AREA PAINT CORRECTION

## STANDARD OPERATING PROCEDURE

1

### DEFECT REMOVAL



Remove paint defects using 1500-2000 grit sandpaper on a 3" DA sander.

Wipe clean to visually inspect when defect is fully removed.

2

### SAND SCRATCH REFINEMENT



Further refine sand-scratches with 3000-grit foam pad and water on a 3" DA sander.

3

### COMPOUND



Compound the area using **Performance Cutting Compound** on a **3" Green Foam Pad**.

4

### POLISH



Polish the area using **Performance Finishing Polish** on a **3" Red Foam Finishing Pad**.

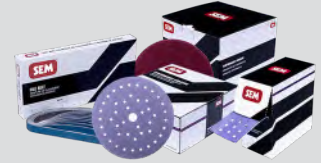
5

### FINAL INSPECTION



Wipe clean with **Ultra Microfiber Towel** and visually inspect to ensure defect has been removed and polished to a gloss.

### PRODUCT LIST



### ABRASIVES

Part	Product	Size
SA31500	3" Grip Multi-hole 1500-grit	3" DA
SA32000	3" Grip Multi-hole 2000-grit	3" DA
SA33000S	3" Grip Foam Pad	3" DA



### DETAIL

Part	Product	Size
SD30801	Performance Cutting Compound	Gallon
SD30832	Performance Cutting Compound	Quart
SD30901	Performance Finishing Polish	Gallon
SD30932	Performance Finishing Polish	Quart
SD30813	3" Green Foam Pad	3"
SD30913	3" Red Foam Finishing Pad	3"
SD30900	Ultra Microfiber Towel	Each

### SEM Products

Rock Hill, SC 29730  
 Tech Support: 1-800-831-1122  
 Customer Care: 1-866-327-7829  
[semproducts.com](http://semproducts.com)



# LARGE AREA PAINT CORRECTION

## STANDARD OPERATING PROCEDURE

1

### DEFECT REMOVAL



Remove paint defects using 1500-2000 grit sandpaper on a 6" DA sander.

Wipe clean to visually inspect when defect is fully removed.

2

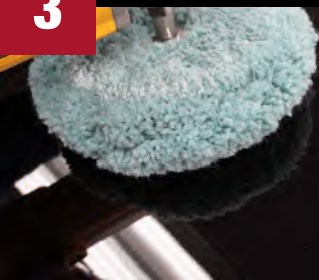
### SAND SCRATCH REFINEMENT



Further refine sand-scratches with 3000-grit foam pad and water on a 6" DA sander.

3

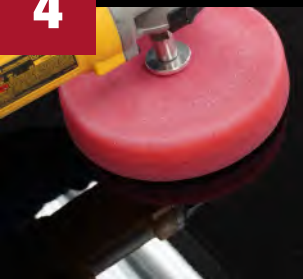
### COMPOUND



Compound the area using **Performance Cutting Compound** on a **Green Foam Pad**.

4

### POLISH



Polish the area using **Performance Finishing Polish** on a **Red Foam Finishing Pad**.

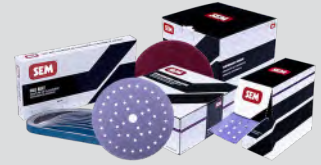
5

### FINAL INSPECTION



Wipe clean with **Ultra Microfiber Towel** and visually inspect to ensure defect has been removed and polished to a gloss.

### PRODUCT LIST



### ABRASIVES

Part	Product	Size
SA61500	6" Grip Multi-hole 1500-grit	6" DA
SA62000	6" Grip Multi-hole 2000-grit	6" DA
SA63000S	6" Grip Foam Pad	6" DA

### DETAIL

Part	Product	Size
SD30801	Performance Cutting Compound	Gallon
SD30832	Performance Cutting Compound	Quart
SD30901	Performance Finishing Polish	Gallon
SD30932	Performance Finishing Polish	Quart
SD30802	Green Wool Pad	Pad
SD30818	Green Foam Pad	Pad
SD30902	Red Foam Finishing Pad	Pad
SD30900	Ultra Microfiber Towel	Each

### SEM Products

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 Customer Care: 1-866-327-7829  
[semproducts.com](http://semproducts.com)



# VEHICLE DETAILING

## STANDARD OPERATING PROCEDURE

1

### CARPET



Apply **All Purpose Degreaser** with a 10:1 dilution ratio to any stains or heavily soiled areas on carpet and upholstery.

Spray a light mist coat on soiled areas, brush lightly and wipe clean with a clean towel. If needed on carpet or fabric, use a wet vacuum or extractor.

2

### WHEELS & ENGINE BAY



Apply **Wheel Cleaner** RTU for cleaning brake dust from wheels and tires.

Apply **All Purpose Degreaser** at a 4:1 dilution ratio for cleaning the engine bay, door jams, tires or any difficult to reach areas.

Next, scrub, pressure wash and rinse all areas where cleaner was applied. Rinse the entire vehicle to remove any loose residue.

3

### SOAK & WASH EXTERIOR



Use **All Purpose Degreaser** at a 4:1 dilution ratio to pre-soak any remaining heavily soiled or hard to reach areas.

Wash entire vehicle with **Premium Car Wash** at a 64:1 ratio, rinse entire vehicle. Dry the vehicle with a drying cloth or squeegee.

4

### TIRE DRESSING



Dress dry tires and trim with **Body Shop Safe Dressing** RTU.

Generously spray **Body Shop Safe Dressing** on tires, then allow to dry. If needed, remove overspray from rims or adjacent panels.

5

### INTERIOR & GLASS



Apply **All Purpose Degreaser** with at a 10:1 dilution ratio to interior vinyl or leather, wipe clean with clean towel.

Clean windows (interior and exterior) using **Premium Glass Cleaner** at a 10:1 ratio.

6

### FINAL DETAIL



Mist **Instant Detailer** onto exterior surfaces of the vehicle, then wipe clean with microfiber cloth.

**Instant Detailer** removes compound residue, dust or fingerprints and improves gloss.

Visit our website for more information:

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

### PRODUCT LIST



Part	Product	Size
SD30301	Performance All Purpose Degreaser	Gallon
SD30305	Performance All Purpose Degreaser	5 Gal.
SD30332	Performance All Purpose Degreaser	Empty Qt.
SD30101	Performance Wheel Cleaner	Gallon
SD30105	Performance Wheel Cleaner	5 Gal.
SD30132	Performance Wheel Cleaner	Empty Qt.
SD30501	Premium Car Wash	Gallon
SD30505	Premium Car Wash	5 Gal.
SD30201	Premium Body Shop Safe Dressing	Gallon
SD30205	Premium Body Shop Safe Dressing	5 Gal.
SD30601	Premium Glass Cleaner	Gallon
SD30605	Premium Glass Cleaner	5 Gal.
SD30701	Performance Instant Detailer	Gallon
SD30705	Performance Instant Detailer	5 Gal.
SD30732	Performance Instant Detailer	Empty Qt.
SD30000	Spigot for 5 Gal.	Each



Part	Product	Size
Call For Details		

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 Customer Care: 1-866-327-7829  
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# 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](https://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

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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# 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](https://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](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).

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.

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# DUPLICATING OEM TEXTURES

## STANDARD OPERATING PROCEDURE

1

### REPAIR DAMAGE



If extensive damage is present, refer to **Plastic Repair Standard Operating Procedure** first.

2

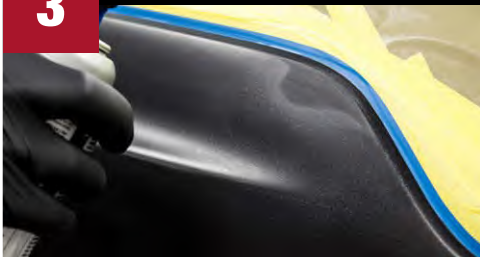
### CLEAN



Clean with **Scuff & Clean** and a damp, Gray Scuff Pad or a nylon bristle brush. Rinse with water and dry with clean, lint-free cloth. Clean with **SEM Solve**, **Plastic & Leather Prep** or **XXX Universal Surface Cleaner**. Wipe clean in one direction with clean, lint-free cloth.

3

### PREP



Sand any shallow scratches or scuffs until smooth. Blow off and wipe with a tack rag. Mask the area to be sprayed.

**FOR RAW PLASTIC:** Blow off and apply **XXX Adhesion Promoter** as per instructions.

**FOR PAINTED SURFACES:** Sand with a gray scuff pad.

4

### APPLY TEXTURE



Apply **Bumper Coater™** or **Trim Black** as a wet bed over the extended repair area. Apply **Texture Coating** in light mist coats 12" - 24" from surface.

- ① Apply additional coats in the same manner if needed to achieve OEM texture.
- ② Be sure to apply lightly enough so that raised textured spray does not flow together.

5

### SAND



Allow to completely dry before sanding. Sand flat surfaces with P320 – 800 grit and use a gray scuff pad on sharp edges and corners. Blow off and wipe with a tack rag.

6

### PAINT



Apply **Bumper Coater** or **Trim Black** as per instructions.



WATCH THE VIDEO AT:  
[semproducts.com/sop\\_duplicating\\_oem\\_textures](http://semproducts.com/sop_duplicating_oem_textures)

## PRODUCT LIST



### PREP

Part	Product	Size
38398	Scuff & Clean	16 oz. Tube
38373	SEM Solve	20 oz. Aerosol
38353	Plastic & Leather Prep	16 oz. Aerosol
77723	XXX Adhesion Promoter	16 oz. Aerosol



### TEXTURE & PAINT

Part	Product	Size
39853	Texture Coating	20 oz. Aerosol
39143	Trim Black	20 oz. Aerosol
49133	Trim Black Ultra-Matte	20 oz. Aerosol
49143	Trim Black Ultra-Satin	20 oz. Aerosol
49153	Trim Black Ultra-Gloss	20 oz. Aerosol



### ABRASIVES

Part	Product	Size
SA4948	Gray Scuff Pad	4.5" x 9"
SA6320	6" Grip 320-grit	6" DA
SA6800	6" Grip 800-grit	6" DA



BEFORE

AFTER

SEM Products  
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Customer Care: 1-866-327-7829  
[semproducts.com](http://semproducts.com)



**BUILT BETTER™**

**Technical Consultation Service**

Our Technical Staff is ready to assist you with any questions. You are invited to take advantage of our extensive experience, laboratory services and trained field service representatives. Call (800) 831-1122 for answers to your questions. Hours of operation are Monday through Thursday 8:00 am until 5:00 pm EST and on Friday 8:00 am until 4:30 pm EST.

The information supplied in this document is for guidance only and is secondary to the OEM repair guidelines. Instructions should not be construed as a warranty. All implied warranties are expressly disclaimed. All users of the materials are responsible for assuring that it is suitable for their needs, environment and use. All data subject to change as SEM deems appropriate.

Users should review the Safety Data Sheet (SDS) and product label for the material to determine possible health hazards, appropriate engineering controls and precautions to be observed in using the material. Copies of the SDS and product label are available upon request.

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