

# SEM<sup>®</sup> 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** 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.



### 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	White	10.1 oz. Tube
29372	Gray	10.1 oz. Tube
29382	Beige	10.1 oz. Tube
29392	Black	10.1 oz. Tube



#### EQUIPMENT

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



Product	Size
Factory Pack - 40 Colors	16 oz. Aerosol

See back side for available **Factory Pack** colors.

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# 1K SEAM SEALER

STANDARD OPERATING PROCEDURE | PRODUCT LIST CONTINUED

## PRODUCT LIST



### FACTORY PACK™

16 OZ AEROSOLS

Part	Color
19013	Ford TS Silver Frost
19023	Ford YZ White
19033	Ford CX Dk Shadow Grey
19043	Ford G2 Redfire Pearl
19053	Ford FL Torreador Red Metallic
19063	Ford G3 Pueblo Gold
19073	Ford E4 Vermillion
19083	Ford DX Dk Blue Pearl
19093	Ford YN Silver Metallic
19103	Ford UA Black
19133	Honda B537M Atomic Blue
19143	Honda B92P Black Pearl
19163	Honda NH700M Alabaster Silver
19173	Honda YR538M Desert Mist Metallic
19183	Honda B536P Royal Blue Pearl
19193	Honda NH737M Polished Gray Metallic
19203	Honda R81 Milano Red
19213	Honda R525P Tango Red
19223	Honda NH578 Taffeta White
19233	Honda YR573M Mocha Metallic
19253	Toyota 1C0 Millenium Silver
19263	Toyota 1C8 Lunar Mist Metallic
19273	Toyota 1E3 Phantom Gray
19283	Toyota 040 Super White
19293	Toyota 202 Black
19303	Toyota 1D4 Titanium
19313	Toyota 4Q2 Desert Sand Pearl
19323	Toyota 056 Natural White
19353	Toyota 3R3 Red Pearl
19363	Toyota 1G3 Magnetic Gray Pearl
19373	GM WA8554 White
19393	GM WA9260 Victory Red
19403	GM WA8624 Olympic White
19423	GM WA8555 Black
19433	GM WA994L Lt Tarnished Silver
19443	GM WA519F Galaxy Silver Metallic
19453	GM WA929L Cashmere
19463	GM WA722J Dk Blue Metallic
19473	GM WA382E Pewter Metallic
19483	GM WA316N Gold Mist Metallic

# 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.

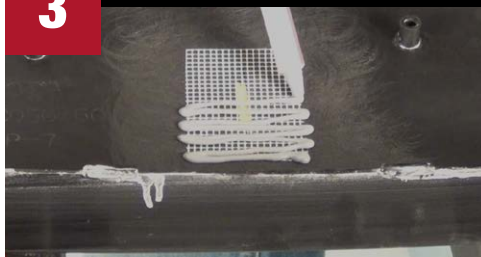
### 2 SAND & DISH



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.

- ⓘ 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 **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<sup>™</sup> 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 **Bumper Bite<sup>™</sup> Flexible Glaze**, then sand with P180 – P320 grit.

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

## 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 Promoter	Gallon
77723	XXX Adhesion Promoter	16 oz. Aerosol
77724	XXX Adhesion Promoter	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	Dual-Mix Problem Plastic Repair Material	7 oz. Cartridge
39847	Dual-Mix Multi-Plastic Repair Material	7 oz. Cartridge



### SAND AND SKIM

Part	Product	Size
40482	Bumper Bite Flexible Glaze	16 oz. Tube

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