



PLASTIC REFINISHING

STANDARD OPERATING PROCEDURE

1

PREP & PRIME



ⓘ If damage is present, refer to **Plastic Repair Standard Operating Procedure** 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 instructions.

2

GUIDE COAT & SAND



Apply **Guide Coat Black** or **Premium Powder Guide Coat** to dried primer. Sand with P320 – P400 grit. Finish sanding with P600 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
39854	Texture Coating	Quart
39793	Heavy Texture Chip Guard	20 oz. Aerosol
39803	Clear Chip Guard	20 oz. Aerosol
39804	Clear Chip Guard	Cone Top Quart
39813	Satin Black Chip Guard	20 oz. Aerosol
39814	Satin Black Chip Guard	Quart



PAINT

Part	Product	Size
39101	Bumper Coater - Black	Gallon
39104	Bumper Coater - Black	Quart
39101-LV	Low VOC Bumper Coater Black	Gallon
39104-LV	Low VOC Bumper Coater Black	Quart
	Bumper Coater - 17 Colors	16 oz. Aerosol
	Factory Pack - 40 Colors	16 oz. Aerosol

See back side for available **Bumper Coater** and **Factory Pack** aerosol colors.

PREP



Part	Color	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.

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PLASTIC REFINISHING

STANDARD OPERATING PROCEDURE | PRODUCT LIST CONTINUED

PRODUCT LIST



FLEXIBLE PRIMER SURFACER

Part	Size
39131	Gallon
39133	16 oz. Aerosol
39134	Quart



WATERBORNE FLEXIBLE PRIMER SURFACER

Part	Size
39221	Gallon



HIGH-BUILD PRIMER SURFACER

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



WORLD CLASS™ WATERBORNE FLEXIBLE PRIMER

Part	Size
50184	Quart



WORLD CLASS™ 4.2 VOC HS URETHANE PRIMER

Part	Product	Size
50151	HS Urethane Primer	Gallon
50154	HS Urethane Primer	Quart
50444	4.2 VOC Air Dry Activator	Cone Top Quart
50446	4.2 VOC Air Dry Activator	Half Pint
50454	4.2 VOC Fast Activator	Cone Top Quart
50456	4.2 VOC Fast Activator	Half Pint
50464	4.2 VOC Medium Activator	Cone Top Quart
50466	4.2 VOC Medium Activator	Half Pint
50474	4.2 VOC Slow Activator	Cone Top Quart
50476	4.2 VOC Slow Activator	Half Pint



BUMPER COATER™ AEROSOLS

Part	Color
39023	Med. Driftwood Metallic
39073	Gloss Silver
39083	Gloss Black
39103	Flexible Black
39153	Charcoal
39163	Med. Smoke
39173	Dk. Smoke
39183	Med. Gray
39193	Dk. Gray
39253	Med. Titanium Metallic
39263	Dk. Titanium Metallic
39273	Charcoal Metallic
39283	Lt. Titanium Metallic
39293	Honda Black
39413	Med. Platinum Metallic
39423	Med. Quartz Metallic
39583	Lt. Charcoal



FACTORY PACK™

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



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.

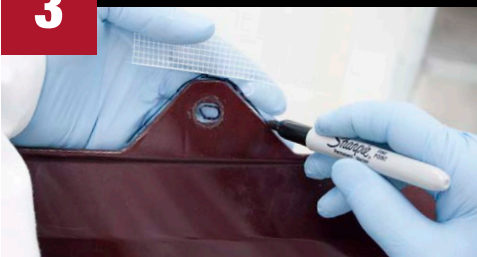
2 GRIND & ADHESION PROMOTER



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.

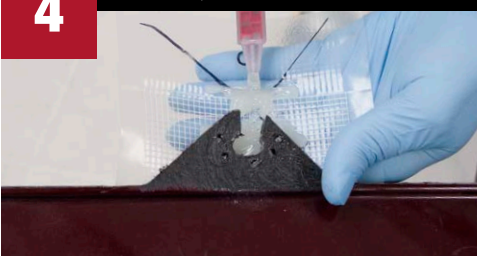
- ⚠ Do not grind too fast and cause plastic to melt.
- ⓘ For TPO, EPDM, PP and similar plastics, apply **Adhesion Promoter** as per instructions.

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.

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	Dual-Mix Quick Set 20	1.7 oz. Cartridge
40207	Dual-Mix Quick Set 20	7 oz. Cartridge
40502	Dual-Mix Quick Set 50	1.7 oz. Cartridge
40507	Dual-Mix Quick Set 50	7 oz. Cartridge
41807	Dual-Mix Quick Set 180	7 oz. Cartridge

SEM[®] 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.

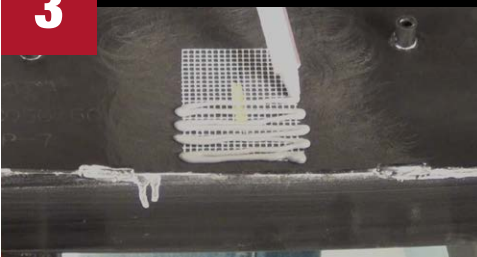
2 SAND & DISH



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™ 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™ 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