

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** 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



PAINT

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



2K LOWER PANEL PROTECTION

STANDARD OPERATING PROCEDURE

1

PREP



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

2

SAND, CLEAN & PRIME



Sand with P180 – P220 grit. Re-clean with **SEM Solve** or **XXX Universal Surface Cleaner**. Wipe clean in one direction with clean, lint-free cloth.

- ⓘ “Back-taping” helps eliminate any heavy edges and provides smooth transition to other surfaces.
- ⚠ Prime bare metal with a direct-to-metal epoxy or 2K urethane primer. Allow primer to fully cure.

3

MIX



If tinting, mix 8 parts **Pro-Tex™ 2K Chip Guard** to 1 part solvent-based colorant. Mix 2 parts tinted mixture to 1 part **Pro-Tex 2K Chip Guard Catalyst**. Stir well.

- ⚠ Use only automotive solvent-based paint without any binders or reducers – color only. Do not use water based or lacquer based colorants.

4A

APPLY HEAVY TEXTURE

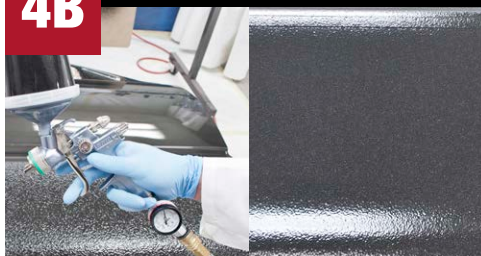


Using a **Premium Undercoat Gun & Plastic Schutz Bottle**

- Air Pressure:** 45 – 90 psi
- Distance:** 18" – 24"
- Coats:** 2
- Flash time:** 10 – 20 min
- Topcoat:** 30 min
- Dust free:** 60 – 90 min

4B

APPLY MEDIUM TEXTURE



Using a **Spray Gun**

- Fluid Tip:** 1.8 – 2.5
- Air Pressure:** 45 – 90 psi
- Distance:** 8" – 10"
- Coats:** 2
- Flash time:** 10 – 20 min
- Topcoat:** 30 min
- Dust Free:** 60 – 90 min

5

FINISH & CLEAN



Remove masking tape while final coat is still wet. Clean gun with **XXX Gun Cleaner** or **XXX Universal Gun Cleaner**.

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
77771	XXX Universal Surface Cleaner	Gallon
77774	XXX Universal Surface Cleaner	Quart



PRIME

Part	Product	Size
ML010	Metallock™ DTM High Build Primer Kit	1.25 Gallon
ML014	Metallock DTM High Build Primer	Quart
MLH16	Metallock DTM Hardener	Half Pint
50121	World Class™ DTM Primer	Gallon
50124	World Class DTM Primer	Quart
50134	World Class DTM Primer Activator	Cone Quart
50136	World Class DTM Primer Activator	Half Pint



APPLY

Part	Product	Size
40820	Pro-Tex™ 2K Chip Guard	3 Pint Kit

EQUIPMENT

Part	Product	Size
71109	Premium Undercoat Gun	1 Applicator
71004	Plastic Schutz Bottle	1 Bottle
77743	XXX Gun Cleaner	20 oz. Aerosol
77763	XXX Universal Gun Cleaner	20 oz. Aerosol

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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
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INNER PANEL CORROSION PROTECTION

STANDARD OPERATING PROCEDURE

1

THE 360° WAND



Rust Preventer is easily applied with a 360° spray pattern when using the **Premium Undercoat Gun & Spray Wand** or the **Aero Wand**.

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

2A

PREP & APPLY AEROSOL



Clean surface with **SEM Solve** or **XXX Universal Surface Cleaner** where applicable. Remove cap from **Rust Preventer**, attach straw or **Rust Preventer Aero Wand**. Apply 1 – 2 coats.

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

2B

PREP & APPLY QUART



Clean surface with **SEM Solve** or **XXX Universal Surface Cleaner** where applicable. Shake bottle of **Rust Preventer** for 1 minute. Spray 1 – 2 coats at 35 – 45 psi.

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

3

CLEAN WANDS



Clean **Aero Wand** by attaching the tip and wand to **XXX Gun Cleaner**.

Clean **Premium Undercoat Gun & Wand** with **XXX Gun Cleaner** and **XXX Universal Gun 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



APPLICATIONS

Part	Product	Size
39573	Rust Preventer	24 oz. Aerosol
39574	Rust Preventer	Quart



EQUIPMENT

Part	Product
71109	Premium Undercoat Gun
71110	Premium Undercoat Gun and Spray Wand
71111	Spray Wand
71120	Aero Wand



CLEAN-UP

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

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PANEL & RIVET BONDING (COSMETIC PANELS)

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

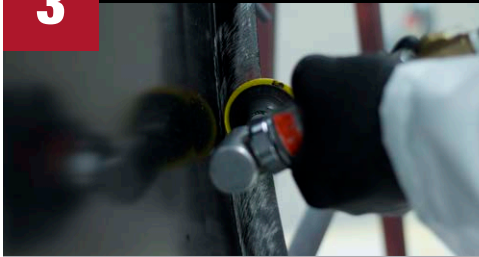
DRY FIT



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 grit grinding disc at low speed for 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 **Dual-Mix Weld-Bond Adhesive** 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.

ⓘ For maximum bond strength, 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
39537	Dual-Mix Weld-Bond Adhesive	7 oz. Cartridge
39747	Dual-Mix Multi-Purpose Panel Adhesive	7 oz. Cartridge

ⓘ CHECK LOCAL VOC REGULATIONS TO ENSURE COMPLIANCE OF ALL PRODUCTS IN YOUR AREA. ALWAYS WEAR OSHA REQUIRED (PPE) PERSONAL PROTECTION EQUIPMENT TO ENSURE YOUR SAFETY.



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