

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.

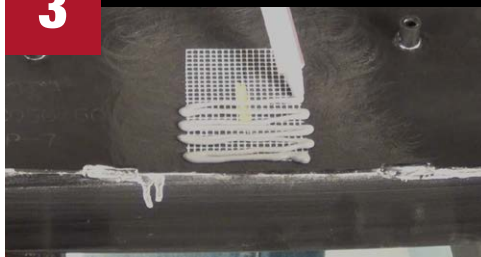
2 SAND & DISH



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.

- 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.
- ① (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.

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



WATCH & LEARN

REINFORCE & FILL BACK



WATCH THE VIDEO AT:
semproducts.com/sop-plastic-repair

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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SOPPLRP_0717



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.