ALUMINUM REPAIR & REFINISHING

FEATURED PROCEDURES
- BONDING & RIVET BONDING
- INNER PANEL REFINISHING
- 2K SEAM SEALING
- SOUND DAMPENING
BONDING & RIVET BONDING

1. PREPARATION
   Remove spot welds with a 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 before applying adhesive to ensure proper alignment and clearance. While dry fitting the panel during rivet bonding process, drill holes for replacement rivets or mark the location of self-piercing rivets per manufacturer’s instructions.

3. CLEAN
   Clean surfaces to be bonded with SEM Solve or Zero VOC Surface Cleaner per directions.

4. GRIND
   Grind mating flanges with a 36 grit grinding disc at low speed to maintain grinding marks, removing any adhesive or protective coating, such as paint, e-coat or galvanized coating. Some manufacturers may recommend leaving the OEM e-coat on the surface of the new replacement panel if rivet bonding. If this is the case, omit grinding with 36 grit and instead, scuff with a red scuff pad.

5. RE-CLEAN
   Blow off and re-clean surfaces with SEM Solve or Zero VOC Surface Cleaner if necessary. Always use lint-free towels when cleaning surfaces to avoid particle contamination. Bonding surfaces should be clean, dry and free of debris.

6. EQUALIZE
   Equalize cartridge by dispensing product until both parts flow evenly. Install Static Mixer. Purge a small amount of material to ensure proper mix. Cut tip to desired size.

7. APPLICATION
   Apply a 3/8” – 1/2” bead of Multi-Purpose Panel Adhesive or Weld-Bond Adhesive to both bonding surfaces and tool with a spreader or acid brush, covering all exposed bare metal. Use enough material to completely fill the joint when parts are clamped.

8. BONDING
   Clamp panel into place. Wipe away excess material. To assure maximum bond strength, surfaces must be mated within the adhesive’s working time. Do not over clamp.

9. RIVET BONDING
   Clamp panel into place. Install rivets per manufacturer’s recommendations during adhesive’s working time. Clamps may be removed after rivets have been installed. Wipe away excess material.

Temperatures below 55°F (13°C) will slow the cure rate.

Temperatures above 85°F (29°C) will accelerate the cure rate.

To minimize cure time, heat to 120° – 140°F (49° – 60°C) for 1 hour.

INNER PANEL REFINISHING

1. CLEAN
   Clean surface with SEM Solve or Zero VOC Surface Cleaner.

2. SAND
   Sand with 320 grit sandpaper or scuff with a gray scuff pad.

3. RE-CLEAN
   Re-clean surface with SEM Solve or Zero VOC Surface Cleaner.

4. APPLY EZ COAT™
   Shake aerosol for a minimum of 1 minute. Apply 2 – 3 medium wet coats allowing 5 – 10 minutes flash time between coats. If using Factory Pack to topcoat, apply immediately after Ez Coat flashes. If using any other refinishing product, allow Ez Coat 30 minutes to dry.

5. APPLY FACTORY PACK™
   Use a clean tack rag to remove any dust. Shake aerosol for a minimum of 1 minute. Apply 2 – 3 medium coats of Factory Pack or until hiding is achieved. Allow 2 – 4 minutes flash time between coats. If using 1K HS Clear, apply immediately after Factory Pack flashes.

6. APPLY 1K HS CLEAR
   Use a clean tack rag to remove any dust. Shake aerosol for a minimum of 1 minute. Apply 2 full coats or 3 medium coats allowing 3 – 5 minutes flash time between coats. Allow 1 hour dry time after final coat before handling.

Because of its size, a radiator support will flash as you are finishing the part. For smaller parts, be sure to allow adequate flash time.
### 2K Seam Sealing

#### CLEAN
Clean joints and seams thoroughly with SEM Solve or Zero VOC Surface Cleaner.

#### SAND & RE-CLEAN
- **FOR BARE METAL**
  Sand bare metal with 80 grit sandpaper.
- **FOR PRIMED SURFACE**
  Sand primed surface with 400 grit sandpaper or gray scuff pad. Re-clean with SEM Solve or Zero VOC Surface Cleaner. Blow off and tack clean to remove lint and dust.

#### EQUALIZE
Equalize cartridge by dispensing product until both parts flow evenly. Install Static Mixer. Purge a small amount of material to ensure proper mix. Cut tip to desired size.

#### APPLY DTM OR TO PRIMER
All SEM standard two-component seam sealers can be applied direct-to-metal, over cured and sanded epoxy primer, or direct-to-metal 2K urethane primer. Never apply over a self etch primer. Always apply over a primer when filling all drip rails of vehicles.

- **FOR DRIP RAILS**
  Use High-Build Self Leveling Seam Sealer with a Versa-Tip for applications where a thicker viscosity is needed such as sloped/vertical surfaces. Dispense into the center of channel and allow product to flow. Keep tip submerged to minimize air bubbles.

- **AIR BUBBLE REMOVAL**
  Immediately after application, a heat gun can be used to remove any air bubbles that become entrapped. With a steady motion, sweep the heat gun across surface of Self Leveling Seam Sealer or High-Build Self Leveling Seam Sealer at a distance of 2” – 6”.

- **PAINTING**
  All SEM standard two-component seam sealers are paintable immediately with most solvent based paint systems.

### Sound Dampening

#### CLEAN
Clean surface thoroughly with SEM Solve or Zero VOC Surface Cleaner.

#### SAND & RE-CLEAN
- **FOR BARE METAL**
  Sand primed surface with 180 grit sandpaper or sand bare metal surface with 80 grit sandpaper.
- **FOR PRIMED SURFACE**
  Blow off and re-clean with SEM Solve or Zero VOC Surface Cleaner, then tack clean to remove lint and dust.

- **DO NOT APPLY** Sound & Seal Sprayable Coating directly over a self etching primer.

#### EQUALIZE
Place cartridge into the Universal Pneumatic Applicator and equalize cartridge until both sides dispense equally. Attach Quick Spray System Static Mixer to cartridge.

#### APPLY
Apply to necessary areas, duplicating existing texture. There is no need to apply in coats.

- **70101 ROUND AIR ASSEMBLY:**
  For spraying sound dampening pads and seams. Spraying at a distance of 1” allows the user to spray a consistent bead seen on shock towers and rear body pans.

- **70102 FLAT AIR ASSEMBLY:**
  Used to match rocker panels on Honda Civics and Accords. Sprays a directional pattern of about 3" in width. Turning the gun sideways allows for the creation of a built-up edge.
## PREP PRODUCTS

### SEM Solve
A virgin solvent blend to clean panels prior to repair or refinish.
- Removes wax, grease and solvent soluble contaminants
- Leaves no residue

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<tr>
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### Zero VOC Surface Cleaner
A water-based cleaner designed to eliminate surface contaminants prior to refinishing.
- Removes dirt, oil, grease and silicone
- VOC compliant everywhere
- Eliminates static for better blends
- Non-flammable
- Environmentally friendly

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## ADHESIVES

### Dual-Mix™ Multi-Purpose Panel Adhesive
A two-component epoxy for panel bonding steel, aluminum, SMC and fiberglass.
- Dual-Mix™ Forever Warranty
  - Superior impact and peel strength
  - Excellent corrosion resistance
  - Glass beads for consistent bond line thickness
  - Non-sag formula
  - 90 minute working time

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### Dual-Mix™ Weld-Bond Adhesive
A two-component, acrylic adhesive formulated to bond steel and aluminum surfaces without the use of an external primer.
- Dual-Mix™ Forever Warranty
  - Superior impact and peel strength
  - Glass beads for consistent bond line thickness
  - Excellent environmental resistance
  - 60 minute working time

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### Dual-Mix™ Door Skin & SMC Adhesive
A two-component epoxy that quickly bonds any combination of steel, aluminum, SMC and fiberglass.
- Dual-Mix™ Forever Warranty
  - Non-sag formulation
  - Excellent corrosion protection
  - Bonds multiple substrates
  - 30 minute working time

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### Dual-Mix™ Patch Panel Adhesive
A two-component, acrylic adhesive for quickly bonding metal panels without the use of an external primer.
- Dual-Mix™ Forever Warranty
  - Superior impact and peel strength
  - Non-sag formula
  - Excellent corrosion resistance
  - 10 minute working time

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### Dual-Mix™ Non-Sag Fast Set Adhesive
A two-component epoxy based adhesive for fast bonds on most surfaces.
- Dual-Mix™ Forever Warranty
  - Superior adhesion
  - Bonds multiple substrates
  - 3 minute working time

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### Dual-Mix™ Quick Set 20
A fast, two-component, opaque, urethane adhesive designed for bumper tab repair and bonding most small plastic, steel and aluminum parts.
- Dual-Mix™ Forever Warranty
  - For bonding most small to medium plastic, metal and aluminum parts
  - High strength and sandable
  - Non-sag formula

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<tr>
<td>41807</td>
<td>Quick Set 180</td>
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### Dual-Mix™ Quick Set 50
A fast, two-component, black, urethane adhesive designed for automotive plastic repair and bonding most small plastic, steel and aluminum parts.
- 50 SECOND WORKING TIME

### Dual-Mix™ Quick Set 180
A two-component, general purpose, black, urethane adhesive with a three minute working time designed for repair and bonding of most small to medium plastic, steel, aluminum, glass, SMC and fiberglass parts.
- 3 MINUTE WORKING TIME

NEW
### Insta-Bond 2K Kit
This kit contains an acrylic adhesive and accelerator for instant bonding of small parts.

- Holds torn plastic together during repair
- Provides high strength bonds
- Also for use on vinyl, metal and glass
- Accelerator creates instant bond

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<tr>
<td>39322</td>
<td>Insta-Bond Accelerator</td>
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### Mini-Max™ General Purpose Adhesive
A two-component, epoxy based adhesive for fast bonds on most surfaces.

- Hold torn plastic together during repair
- Provides high strength bonds
- Also for use on vinyl, metal and glass
- Accelerator creates instant bond

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<td>68442</td>
<td>Clear Fast Set Adhesive</td>
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### Sound Dampening

#### Dual-Mix™ Flexible Urethane Foam
A two-component, black foam that duplicates OEM foams used for sound dampening.

- Dual-Mix™ Forever Warranty
- Excellent sound dampening qualities
- Stops panel flutter
- 10x volume expansion
- Resists shrinking
- Working time of 15 seconds

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#### Dual-Mix™ Rigid Urethane Foam
A two-component, urethane, expanding foam for filling pillars, posts, and box sections.

- Dual-Mix™ Forever Warranty
- Meets UL 94HB flammability tests
- Restores crash parts to OEM condition
- Superior expansion
- Working time 45 seconds

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#### Dual-Mix™ Panel Vibration Control Material
A two-component, epoxy/urethane blend for reducing noise and vibration on roof skins and intrusion beams.

- Dual-Mix™ Forever Warranty
- Excellent sag resistance
- Reduces noise and vibration
- Protects against corrosion
- Superior flexibility
- Working time of 1 hour

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### Seam Sealing

#### Dual-Mix™ Seam Sealer
A two-component, epoxy sealer for sealing of interior or exterior seams, joints and voids.

- Dual-Mix™ Forever Warranty
- Direct to metal
- Paintable Immediately
- Will not shrink, harden or crack
- Non-sag formula duplicates OEM sealers
- Fast cure increases production
- Sprayable for additional versatility

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#### Dual-Mix™ Self Leveling Seam Sealer
A two-component, low viscosity epoxy for use on drip rails, roof and trunk seams.

- Dual-Mix™ Forever Warranty
- Direct to metal on non-flexing roof skins
- Paintable in 15 minutes
- Will not shrink, harden or crack
- Permanently flexible

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#### Dual-Mix™ High-Build Self Leveling Seam Sealer
A two-component, high viscosity epoxy ideal for use on roof seams, drip rails and trunk seams.

- Dual-Mix™ Forever Warranty
- Direct to metal on non-flexing roof skins
- Paintable in 15 minutes
- Will not shrink, harden or crack
- Permanently flexible

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#### Dual-Mix™ Sound & Seal Sprayable Coating
A unique, sprayable, epoxy/urethane blend for replacing OEM coatings under rocker panels, in trunks, and on floor sections and frame rails.

- Dual-Mix™ Forever Warranty
- Will not shrink, harden or crack
- Retains flexibility
- Excellent adhesion to properly prepped surfaces
- Paintable in 30 minutes

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**PRIMERS**

**World Class™ DTM Primer**
A VOC compliant, two-component epoxy that provides bare metal adhesion and filling in one product.
- 2.1 VOC compliant
- 4:1 Mix
- Outstanding adhesion on steel, aluminum and fiberglass
- Excellent corrosion control
- Builds quickly, sands easily
- Excellent color holdout

**World Class™ Acrylic Primer Surfacer**
A VOC compliant coating for quick and easy priming of spots or complete panels.
- 2.1 VOC compliant
- 1:1 Mix with urethane reducer
- Excellent filling properties
- Sands quickly

**World Class™ HS Urethane Primer**
A premium, high build, two-component, urethane primer formulated for use on automotive substrates.
- 4.2 VOC compliant
- 4:1 Mix
- Outstanding adhesion
- Excellent filling properties
- Sands quickly
- Excellent color holdout
- Available in gallons and quarts

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**FILLERS & GLAZES**

**Carbo Fill+™**
An enriched filler with exceptional qualities for repairing SMC, FRP, HPA and PPO/PA, aluminum and metal.
- Carbon fiber for added strength
- Prevents swelling
- Resists staining and shrinkage
- Helps eliminate halo effect
- Easy to sand
- Excellent corrosion control

**Metal Bite™**
A two-component, polyester finishing glaze that quickly fills sand scratches and other minor imperfections.
- Fast drying to a tack-free finish
- Seals the repair area and prevents staining
- Exceptional sanding and feather edge
- Outstanding adhesion
- Use on aluminum, steel, SMC and fiberglass

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**2K Seam Sealer**
Two-component epoxy sealers for use on interior or exterior seams, joints and voids.
- Direct to metal
- Paintable immediately
- Excellent adhesion to bare metal or primed surfaces
- Will not shrink, harden or crack
- Non-sag formula duplicates OEM sealers
- Sprayable for additional versatility

**1K Seam Sealer**
Versatile single-component, MSP sealer for interior or exterior seams, joints and voids.
- Direct to metal
- Paintable immediately
- Non-sag formula
- Remains flexible without shrinking or cracking
- Color matches many OEM sealers

**1K Sprayable Seam Sealer**
High performance, MSP seam sealers for duplicating OEM sprayed seams and sound dampening pads.
- Direct to metal
- Paintable immediately
- Excellent adhesion
- Remains flexible
- No shrinking or cracking
- Working time of 20 minutes
- Color variety to match OEM sealers

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**2K Seam Sealer**
Two-component epoxy sealers for use on interior or exterior seams, joints and voids.
- Direct to metal
- Paintable immediately
- Non-sag formula
- Remains flexible without shrinking or cracking
- Color matches many OEM sealers

**1K Seam Sealer**
Versatile single-component, MSP sealer for interior or exterior seams, joints and voids.
- Direct to metal
- Paintable immediately
- Non-sag formula
- Remains flexible without shrinking or cracking
- Color matches many OEM sealers

---

**World Class™ DTM Primer**
A VOC compliant, two-component epoxy that provides bare metal adhesion and filling in one product.
- 2.1 VOC compliant
- 4:1 Mix
- Outstanding adhesion on steel, aluminum and fiberglass
- Excellent corrosion control
- Builds quickly, sands easily
- Excellent color holdout

**World Class™ Acrylic Primer Surfacer**
A VOC compliant coating for quick and easy priming of spots or complete panels.
- 2.1 VOC compliant
- 1:1 Mix with urethane reducer
- Excellent filling properties
- Sands quickly

**World Class™ HS Urethane Primer**
A premium, high build, two-component, urethane primer formulated for use on automotive substrates.
- 4.2 VOC compliant
- 4:1 Mix
- Outstanding adhesion
- Excellent filling properties
- Sands quickly
- Excellent color holdout
- Available in gallons and quarts

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**Part Color**

- 29462 White
- 29472 Gray
- 29482 Beige
- 29492 Black

**Part Color**

- 29362 White
- 29372 Gray
- 29382 Beige
- 29392 Black

**Part Product**

- 39477 Beige Seam Sealer
- 40377 Heavy Bodied Black Seam Sealer
- 40477 Heavy Bodied White Seam Sealer

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**Part Size**

- 40542 16 oz. Tube
- 39592 24 oz. Tube
**Factory Pack**
A unique, time-saving line of basecoat colors for use on jambs, cut-ins, small accessories, and touch ups.
- Lower material cost
- Reduces booth bottlenecks
- Increases production
- Superior adhesion, flexibility and hiding
- Compliant everywhere
- Aerosol matched to OEM standards
- Should be clear coated

**Trim Black**
Acrylic coatings formulated to restore the OEM finish on automotive trim components. For use on plastic, steel, aluminum, stainless steel and chrome.
- Excellent adhesion and durability
- No primer required
- Matches OEM appearance
- Retains flexibility
- Great coverage
- Professional results

**Multimax**
A multi-purpose enamel for exterior or interior use on steel, wood, fiberglass and aluminum.
- Outstanding coverage
- Excellent filling properties
- Durable, fast drying finish
- Great adhesion
- Professional finish

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**Metalock™**
A two-component epoxy primer for use on metal, aluminum, SMC and fiberglass.
- Superior adhesion
- Outstanding corrosion protection
- Exceptional filling properties
- High build formula
- Sealer mixing option
- Easy to sand

**Undercoating & Low VOC Undercoating**
For corrosion protection, chip resistance and sound damping on automotive frames, wheel wells and undercarriage areas.
- Asphalt based aerosol coatings
- Uniform final appearance
- Excellent adhesion
- Economical

**Rubberized Undercoating & Low VOC Rubberized Undercoating**
Premium, paintable, textured coatings for sound dampening, chip resistance and corrosion protection.
- Asphalt free
- Uniform final appearance
- Paintable without bleed through
- Fast-drying
- Aerosols include straw for tight spots

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**Ez Coat™**
A unique, direct-to-metal coating that matches factory primers and e-coat colors.
- Duplicates factory appearance
- Direct-to-metal
- Quick curing and hiding
- Available in 7 popular OEM colors
- Paintable with most automotive base coats
- Excellent corrosion control

**Self Etching Primer**
A first step coating that provides excellent adhesion to bare substrates.
- Excellent adhesion to steel, aluminum and stainless steel
- Quick drying
- Black, gray and green colors available
- Comes in gallons, quarts and aerosols
- Bulk products VOC compliant

**High Build Primer Surfacer**
An elastomeric coating for priming automotive steel, aluminum, urethane and plastics.
- Provides superior adhesion
- Excellent filling properties
- Works on flexible or rigid substrates
- Easy to sand
- Topcoat with most refinish material

**Undercoating**
- Asphalt based aerosol coatings
- Uniform final appearance
- Excellent adhesion
- Economical

**Rubberized Undercoating**
Premium, paintable, textured coatings for sound dampening, chip resistance and corrosion protection.
- Asphalt free
- Uniform final appearance
- Paintable without bleed through
- Fast-drying
- Aerosols include straw for tight spots

---

**Trim Black**
Acrylic coatings formulated to restore the OEM finish on automotive trim components. For use on plastic, steel, aluminum, stainless steel and chrome.
- Excellent adhesion and durability
- No primer required
- Matches OEM appearance
- Retains flexibility
- Great coverage
- Professional results

**Multimax™**
A multi-purpose enamel for exterior or interior use on steel, wood, fiberglass and aluminum.
- Outstanding coverage
- Excellent filling properties
- Durable, fast drying finish
- Great adhesion
- Professional finish

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**Ez Coat™**
A unique, direct-to-metal coating that matches factory primers and e-coat colors.
- Duplicates factory appearance
- Direct-to-metal
- Quick curing and hiding
- Available in 7 popular OEM colors
- Paintable with most automotive base coats
- Excellent corrosion control

**Self Etching Primer**
A first step coating that provides excellent adhesion to bare substrates.
- Excellent adhesion to steel, aluminum and stainless steel
- Quick drying
- Black, gray and green colors available
- Comes in gallons, quarts and aerosols
- Bulk products VOC compliant

**High Build Primer Surfacer**
An elastomeric coating for priming automotive steel, aluminum, urethane and plastics.
- Provides superior adhesion
- Excellent filling properties
- Works on flexible or rigid substrates
- Easy to sand
- Topcoat with most refinish material

**Undercoating**
- Asphalt based aerosol coatings
- Uniform final appearance
- Excellent adhesion
- Economical

**Rubberized Undercoating**
Premium, paintable, textured coatings for sound dampening, chip resistance and corrosion protection.
- Asphalt free
- Uniform final appearance
- Paintable without bleed through
- Fast-drying
- Aerosols include straw for tight spots
Dual-Mix™ Forever Warranty

We know our products work great. And to prove it, our Dual-Mix cartridges come with a lifetime warranty.

When used according to directions, SEM Products GUARANTEES to the purchaser that all Dual-Mix products will perform to specifications forever. This warranty covers reasonable costs for labor, loss of use of the vehicle, parts and materials only and excludes consequential or incidental damages.