

# SEM<sup>®</sup> 2K SEAM SEALING

## STANDARD OPERATING PROCEDURE

### 1 PREP



Clean with **SEM Solve** or **XXX Universal Surface Cleaner**. Wipe clean in one direction with dry, lint-free cloth.

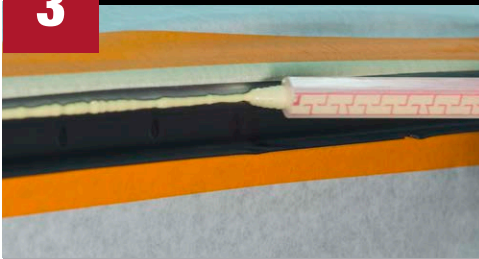
### 2 SAND



**Bare Metal Surfaces:** Sand with P80 grit. Blow off and re-clean with **SEM Solve** or **XXX Universal Surface Cleaner**. Tack clean to remove lint and dust.

**Primed Surfaces:** Sand primed surfaces with P400 grit or a gray scuff pad. Blow off and re-clean with **SEM Solve** or **XXX Universal Surface Cleaner**. Tack clean to remove lint and dust.

### 3 APPLY SEAM SEALER



Apply **SEM 2K Seam Sealer**. Immediately smooth or tool **Seam Sealer** to match OEM texture.

- ① SEM 2K seam sealers can be applied direct-to-metal, over epoxy primer or 2K urethane primer.
- ① Always apply over a primer when filling drip rails.
- ⚠ Never apply over a self etching primer.

### SELF LEVELING



Use **Self Leveling Seam Sealer** or **High-Build Self Leveling Seam Sealer** for applications where a flowable sealer is needed.

- ① Keep tip submerged to minimize air bubbles.
- ① A heat gun can be used immediately after application to remove any air bubbles that become entrapped. With a steady motion and low heat, sweep the heat gun across surface at a distance of 2" – 6".

### VERSA-TIP



Use a **Versa-Tip** for applications where a wider bead is needed.

- ① **Versa-Tips** can be cut to the desired bead width and are compatible with both standard and self leveling **SEM 2K Seam Sealer**

### WATCH & LEARN

### APPLY



WATCH THE VIDEO AT:  
[semproducts.com/sop-2K-seam-sealer](http://semproducts.com/sop-2K-seam-sealer)

## 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



### APPLY

Part	Product	Size
39377	Dual-Mix™ Seam Sealer (Gray)	7 oz. Cartridge
39477	Dual-Mix Beige Seam Sealer	7 oz. Cartridge
40377	Dual-Mix Heavy Bodied Black Seam Sealer	7 oz. Cartridge
40477	Dual-Mix Heavy Bodied White Seam Sealer	7 oz. Cartridge
39387	Dual-Mix Self Leveling Seam Sealer (Gray)	7 oz. Cartridge
39777	Dual-Mix High-Build Self Leveling Seam Sealer (Gray)	7 oz. Cartridge
70070	Versa-Tip	6 Pack

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