



# DUAL-MIX™

PRODUCT INFORMATION AND STANDARD OPERATING PROCEDURES

- ADHESIVES
- PLASTIC REPAIR
- SEALERS
- SOUND DAMPENING



ORBiT™ seam sealer tip.  
See pages 12, 13, 14.



Reduce repair times, steps  
and waste with the new  
SHFT™ seam sealer tip.  
See pages 12, 13, 14.



PARTS & LABOR  
**WARRANTY**  
FOR LIFE

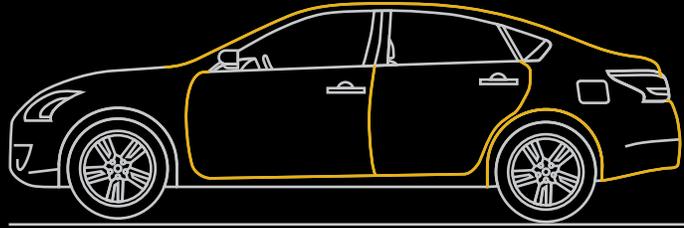
\*Visit [semproducts.com/warranty](http://semproducts.com/warranty) for complete *Dual-Mix* warranty information.



OEM TESTED.  
OEM TRUSTED.  
**OEM RECOMMENDED.**  
**FOREVER WARRANTIED.\***

Urethanes, acrylics and epoxies for large and small applications.

- Roof Skins
- Door Skins
- Applique Panels
- Quarter Panels



39757 (7 OZ.)

## Structural Impact Resistant Adhesive (SIRA)

For bonding structural & non-structural components where specified by the vehicle manufacturer.

- Exceptional impact & peel strength
- Excellent corrosion resistance
- Spacer beads for consistent bond line thickness
- Rivet & weld bonding compatible



**Working Time:** 1 Hr  
**Set Time:** 8 Hr  
**Heat Set Time:** 15 Min  
**Cure Time:** 48 Hr  
**Heat Cure Time:** 30 Min  
**Resin Base:** Epoxy  
 Additional heat options available on the **Technical Data Sheet**

39747 (7 OZ.)

## Multi-Purpose Panel Adhesive

For panel bonding of steel, aluminum, SMC & fiberglass.

- Exceptional impact & peel strength
- Excellent corrosion resistance
- Spacer beads for consistent bond line thickness
- Non-sag formula
- Compatible with MIG or STRSW welding



**Working Time:** 90 Min  
**Set Time:** 4 Hr  
**Cure Time:** 24 Hr  
**Heat Cure Time:** 1 Hr  
**Resin Base:** Epoxy

39337 (7 OZ.)

## Door Skin & SMC Adhesive

For quickly bonding any combination of steel, aluminum, fiberglass & SMC.

- Excellent corrosion protection
- Bonds multiple substrates
- Non-sag formula



**Working Time:** 30 Min  
**Set Time:** 2 Hr  
**Cure Time:** 24 Hr  
**Heat Cure Time:** 1 Hr  
**Resin Base:** Epoxy

39537 (7 OZ.)

## Weld-Bond Adhesive

Formulated to bond metal surfaces without the use of primer.

- Spacer beads for consistent bond line thickness
- Excellent environmental resistance



**Working Time:** 1 Hr  
**Set Time:** 3 Hr  
**Cure Time:** 24 Hr  
**Heat Cure Time:** 1 Hr  
**Resin Base:** Acrylic

39897 (7 OZ.)

## Patch Panel Adhesive

For quickly bonding metal panels without the use of primer.

- Non-sag formula
- Quick cure time



**Working Time:** 10 Min  
**Set Time:** 20 Min  
**Cure Time:** 30 Min  
**Heat Cure Time:** 15 Min  
**Resin Base:** Acrylic

40202 (1.7 OZ.)

40207 (7 OZ.)

### Quick Set 20

A very fast, opaque, urethane adhesive designed for bumper tab repair & bonding most small plastic, steel & aluminum parts.

- High strength & sandable
- Bonds multiple substrates
- Non-sag formula
- Very fast setting



**Working Time:** 15 Sec  
**Set Time:** 20 Sec  
**Cure Time:** 15 Min  
**Resin Base:** Urethane

40502 (1.7 OZ.)

40507 – Black (7 OZ.)

**NEW!** 40517 – Clear (7 OZ.)

### Quick Set 50

General purpose, urethane adhesive with a 50 second set time for bonding most plastic, steel, aluminum, SMC & fiberglass parts.

- High strength & sandable
- Bonds multiple substrates
- Non-sag formula
- Fast setting



**Working Time:** 45 Sec  
**Set Time:** 50 Sec  
**Cure Time:** 15 Min  
**Resin Base:** Urethane

41807 (7 OZ.)

### Quick Set 180

General purpose, black, urethane adhesive with a three minute working time designed for repairing & bonding most small to medium plastic, steel, aluminum, glass, SMC & fiberglass parts.

- High strength & sandable
- Bonds most substrates
- Non-sag formula
- Extended 3 minute working time

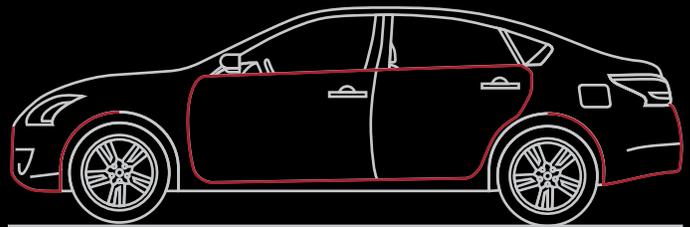


**Working Time:** 3 Min  
**Set Time:** 30 Min  
**Cure Time:** 24 Hr  
**Resin Base:** Urethane

## PLASTIC REPAIR

For repairing flexible, semi-rigid & rigid plastics with ease.

- Bumper Covers
- Interior Plastics
- Molded Body Panels



39847 (7 OZ.)

### Multi-Plastic Repair Material

Epoxy for fast repairs on virtually all plastic bumper covers.

- No adhesion promoter necessary
- Exceptional sanding & feather edge
- Remains flexible
- Does not shrink or pinhole
- Excellent leveling & sag resistance



**Working Time:** 7 Min  
**Sand Time Air Dry:** 15 Min  
**Cure Time:** 1 Hr

39767 (7 OZ.)

### Problem Plastic Repair Material

Epoxy based filler for repairing olefin-based plastics & similar rigid & semi-rigid substrates.

- No adhesion promoter necessary
- Excellent sanding & feather edge
- Does not shrink or pinhole



**Working Time:** 5 Min  
**Sand Time Air Dry:** 15 Min  
**Cure Time:** 1 Hr

**NEW!** 40887 (7 OZ.)

## Rigid Plastic Repair Material

Fiber-enriched epoxy used for bonding & cosmetic repair of carbon fiber, SMC, Metton®, fiberglass & other rigid plastics.

\*Metton is a registered trademark of Metton America, Inc.

- One product for bonding & repair
- Outstanding sanding & feather edge
- Heat set options available
- Fiber-enriched formula helps control swelling & halos

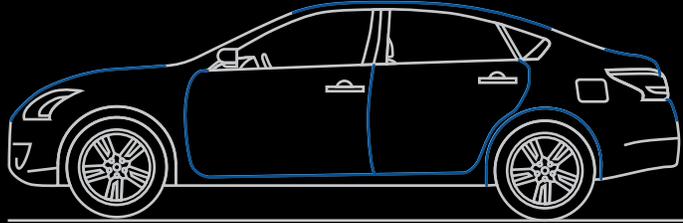


**Working Time:**  
35 Min at 70°F (21°C)  
**Set Time:**  
3 Hrs at 70°F (21°C)  
**Sand Time air dry:**  
3 Hrs at 70°F (21°C)  
**Resin Base:** Epoxy  
Additional heat options available on the **Technical Data Sheet**

## SEALERS

Flexible sealers that restore OEM appearance while preventing corrosion.

- Roof Skins
- Door Skins
- Strut Towers
- Floor Pans
- Fender Wells
- Body Pans / Trunk Areas



39377 – Gray (7 OZ.)  
39477 – Beige (7 OZ.)  
**Seam Sealer**

Medium viscosity, epoxy sealer for use on interior or exterior seams, joints & voids.

! Now includes **NEW SHFT™** tip, for duplicating OE hem flange beads on doors, hoods & deck lids. See page 12.

- **Direct to metal capable**
- **Paintable immediately\***
- Will not shrink, harden or crack
- Non-sag formula duplicates OEM sealers
- Optimized viscosity for softened or rolled edges
- Fast cure increases production
- Sprayable for additional versatility



**Working Time:** 10 Min  
**Set Time:** 15 Min  
**Top Coat Time:** 0 Min  
**Cure Time:** 1 Hr

\* Paintable immediately with most solvent-based paint systems.

**NEW!** 40177 – Gray (7 OZ.)  
**NEW!** 40277 – Beige (7 OZ.)  
40377 – Black (7 OZ.)  
40477 – White (7 OZ.)  
**Heavy Bodied Seam Sealer**

## Heavy Bodied Seam Sealer

High viscosity, epoxy for use on interior or exterior seams, joints & voids.

- **Direct to metal capable**
- **Paintable immediately\***
- Fast cure increases production
- Sprayable for additional versatility
- Correct color minimizes post-inspection liability
- Non-sag formula holds tooling marks
- Remains flexible without shrinking or cracking
- Now includes **NEW ORBIT™** tip, for duplicating OE ripple beads



**Working Time:** 10 Min  
**Set Time:** 15 Min  
**Top Coat Time:** 0 Min  
**Cure Time:** 1 Hr

\* Paintable immediately with most solvent-based paint systems.

## NOW IN 4 OEM COLORS



39387 (7 OZ.)  
**Self Leveling Seam Sealer**

Epoxy sealer for drip rails, roof seams & trunk seams.

- **Direct to metal capable on non-flexing roof skins**
- Paintable in 15 minutes
- Excellent self leveling properties
- Flows into crevice
- Will not shrink, harden or crack
- Permanently flexible



**Working Time:** 10 Min  
**Set Time:** 15 Min  
**Top Coat Time:** 15 Min  
**Cure Time:** 1 Hr

39777 (7 OZ.)

## High-Build Self Leveling Seam Sealer

Controlled flow epoxy ideal for use on roof seams, drip rails & trunk seams.

- Direct to metal capable on non-flexing roof skins
- Paintable in 15 minutes
- Will not shrink, harden or crack
- Permanently flexible

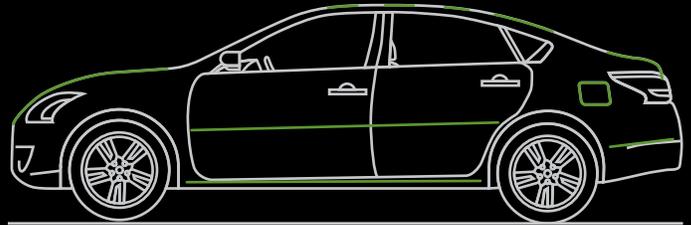


**Working Time:** 10 Min  
**Set Time:** 15 Min  
**Top Coat Time:** 15 Min  
**Cure Time:** 1 Hr

## SOUND DAMPENING

Reduces noise and vibrations and matches OEM textures.

- Roof Bows
- Hoods
- Door Intrusion Beams
- Rocker Panels / Floor Pans
- Quarter Panels
- Body Pans / Trunk Areas
- Deck Lids
- Filler Necks



39977 (7 OZ.)

## Panel Vibration Control Material

Epoxy/urethane blend for reducing noise & vibration on roof skins & intrusion beams.

- Excellent sag resistance
- Reduces noise & vibration
- Protects against corrosion
- Exceptional flexibility



**Working Time:** 1 Hr  
**Set Time:** 1 Hr  
**Cure Time:** 1 Hr

39357 (7 OZ.)

## Flexible Urethane Foam

Black foam that duplicates OEM foams used for sound deadening.

- Excellent sound dampening qualities
- Stops panel flutter
- 10x volume expansion
- Does not require moisture to cure
- Bonds to most substrates



**Working Time:** 15 Sec  
**Set Time:** 2 Min  
**Top Coat Time:** 15 Min

39997 (7 OZ.)

## Rigid Urethane Foam

Urethane expanding foam for filling pillars, posts & box sections.

- Meets UL 94HB flammability tests
- Restores crash parts to OEM condition
- 20x volume expansion
- Reinforces weak panels
- Fast cure



**Working Time:** 45 Sec  
**Set Time:** 5 Min  
**Top Coat Time:** 15 Min

40977 (7 OZ.)

## Sound & Seal Sprayable Coating

A unique sprayable epoxy/urethane blend for replacing OEM coatings under rocker panels, in trunks, on floor sections & frame rails.

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



**Working Time:** 10 Min  
**Set Time:** 15 Min  
**Top Coat Time:** 30 Min  
**Cure Time:** 1 Hr

# PLASTIC REPAIR

## STANDARD OPERATING PROCEDURE

### 1 PREP



Clean front and back with **Scuff & Clean** and 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.

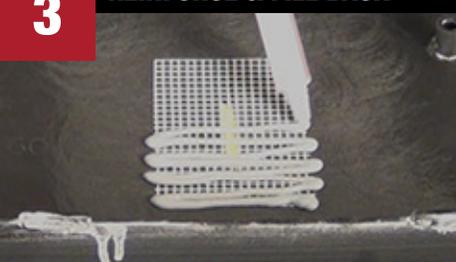
### 2 SAND & GROOVE



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. Re-clean if necessary.

- ⓘ 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.

### 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 Standard Operating Procedure** for refinishing steps.

### WATCH & LEARN

Watch the SOP video and download additional literature at: [semproducts.com/plasticrepair](http://semproducts.com/plasticrepair)



### PRODUCT LIST



#### PREP

Part	Product	Size
38351	Plastic & Leather Prep	Gallon
38353	Plastic & Leather Prep	16 oz. Aerosol
38354	Plastic & Leather Prep	Quart
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Quart
38391	Scuff & Clean	Gallon Pump
38398	Scuff & Clean	16 oz. Tube
77721	XXX Adhesion Promoter	Gallon
77723	XXX Adhesion Promoter	16 oz. Aerosol
77724	XXX Adhesion Promoter	Cone Quart
77771	XXX Universal Surface Cleaner	Gallon
77774	XXX Universal Surface Cleaner	Quart



#### REINFORCE AND FILL

Part	Product	Size
39767	Dual-Mix Problem Plastic Repair Material	7 oz. Cartridge
39847	Dual-Mix Multi-Plastic Repair Material	7 oz. Cartridge
70007	Plastic Repair Contouring Tape	15' Roll



#### SAND AND SKIM

Part	Product	Size
40489	Bumper Bite Flexible Glaze	14 fl. oz. Pouch

ⓘ 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.

# PLASTIC REFINISHING

## STANDARD OPERATING PROCEDURE

1

### PREP & PRIME



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

Clean with **Scuff & Clean** and a 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™** flexible coating or **FACTORY PACK™** basecoat as per instructions.



### WATCH & LEARN

PLASTIC REFINISHING  
STANDARD OPERATING PROCEDURE



Watch the SOP video and download additional literature at:  
[semproducts.com/plasticrefinishing](http://semproducts.com/plasticrefinishing)

### PRODUCT LIST



#### PAINT

Part	Product	Size
39101	<i>Bumper Coater</i> flexible coating - Black	Gallon
39104	<i>Bumper Coater</i> flexible coating - Black	Quart
39101-LV	<i>Bumper Coater</i> flexible coating - Low VOC Flexible Black	Gallon
39104-LV	<i>Bumper Coater</i> flexible coating - Low VOC Flexible Black	Quart
	<i>Bumper Coater</i> flexible coating - 17 Colors**	16 oz. Aerosol
	<i>Factory Pack</i> basecoat - 40 Colors**	16 oz. Aerosol

\*\*Visit [semproducts.com](http://semproducts.com) for all *Bumper Coater* flexible coatings and *Factory Pack* colors

### PRODUCT LIST



#### PREP

Part	Product	Size
38351	Plastic & Leather Prep	Gallon
38353	Plastic & Leather Prep	16 oz. Aerosol
38354	Plastic & Leather Prep	Quart
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Quart
38391	Scuff & Clean	Gallon Pump
38398	Scuff & Clean	16 oz. Tube
77771	XXX Universal Surface Cleaner	Gallon
77774	XXX Universal Surface Cleaner	Quart



#### GUIDE COAT

Part	Product	Size
38203	Guide Coat Black	16 oz. Aerosol
38253	Premium Powder Guide Coat	16 oz. Aerosol



#### TEXTURE

Part	Product	Size
39793	Heavy Texture Chip Guard	20 oz. Aerosol
39803	Clear Chip Guard	20 oz. Aerosol
39804	Clear Chip Guard	Cone Quart
39813	Satin Black Chip Guard	20 oz. Aerosol
39814	Satin Black Chip Guard	Quart
39853	Texture Coating	20 oz. Aerosol
39854	Texture Coating	Quart
52000	<b>NEW!</b> 2K Urethane Chip Guard	Kit

**i** 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.

# PANEL, RIVET & WELD BONDING

## STANDARD OPERATING PROCEDURE

### 1 REMOVE PART



⚠ Always follow OEM repair procedures and the instructions included with the cartridge.

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 or mark locations for:

- Replacement rivets
- Self-piercing rivets
- Squeeze Type Resistant Spot Weld (STRSW)

### 3 PREP & GRIND



Clean with **SEM Solve** or **XXX Universal Surface Cleaner**. Grind mating flanges with a P36 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, follow OEM procedures for abrading surface.

### 4 APPLY ADHESIVE



Apply 3/8" – 1/2" diameter 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**.
- ⓘ Use **Dual-Mix Structural Impact Resistant Adhesive** for structural components when recommended.

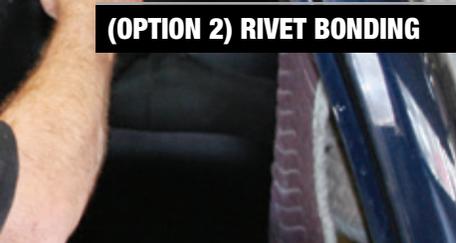
### 5 (OPTION 1) PANEL BONDING



Clamp panel in 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. Do not over clamp. Install rivets or STRSW per manufacturer's recommendations during adhesive's working time. Remove clamps after rivets or spot welds have been installed on panels fully supported by these methods. Wipe away excess material.

### PRODUCT LIST



#### PREP

Part	Product	Size
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	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
39757	Dual-Mix Structural Impact Resistant Adhesive	7 oz. Cartridge



### WATCH & LEARN

PANEL & RIVET BONDING  
(COSMETIC PANELS)  
STANDARD OPERATING PROCEDURE



Watch the SOP video and download additional literature at: [semproducts.com/panelbonding](http://semproducts.com/panelbonding)

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# 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 tack clean to remove lint and dust. Re-clean with **SEM Solve** or **XXX Universal Surface Cleaner**.

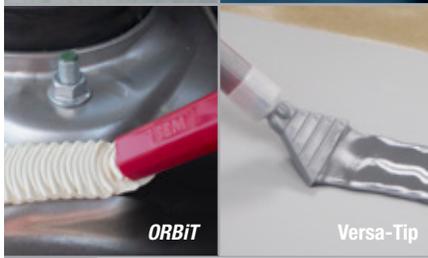
**PRIMED SURFACES:** Sand primed surfaces with P400 grit or a gray scuff pad. Blow off and tack clean to remove lint and dust. Re-clean with **SEM Solve** or **XXX Universal Surface Cleaner**.



**3** APPLY SEAM SEALER

Integral Nut Square Static Mixer

SHFT



ORBIT

Versa-Tip



SELF LEVELING

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.

**SHFT** tip duplicates OE hem flange seam sealer beads commonly found on doors, hoods and deck lids. Works with **SEM 1K** and **2K** seam sealer cartridges.

**ORBIT** tip duplicates OE seam sealer ripple beads. Works with **SEM 1K** and **2K** seam sealer cartridges.

**Versa-Tips** can be cut to the desired bead width and are compatible with standard and self leveling **SEM 2K** seam sealers.

Use **Dual-Mix Self Leveling Seam Sealer** or **Dual-Mix 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".



WATCH & LEARN

2K SEAM SEALING  
STANDARD OPERATING PROCEDURE



Watch the SOP video and download additional literature at:  
[semproducts.com/2kss](http://semproducts.com/2kss)

## PRODUCT LIST



### PREP

Part	Product	Size
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	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
39387	Dual-Mix Self Leveling Seam Sealer	7 oz. Cartridge
39477	Dual-Mix Seam Sealer - Beige	7 oz. Cartridge
39777	Dual-Mix High-Build Self Leveling Seam Sealer	7 oz. Cartridge
40177	<b>NEW!</b> Dual-Mix Heavy Bodied Seam Sealer - Gray	7 oz. Cartridge
40277	<b>NEW!</b> Dual-Mix Heavy Bodied Seam Sealer - Beige	7 oz. Cartridge
40377	Dual-Mix Heavy Bodied Seam Sealer - Black	7 oz. Cartridge
40477	Dual-Mix Heavy Bodied Seam Sealer - White	7 oz. Cartridge
70011	Integral Nut Square Static Mixer	6 Pack
70012	Integral Nut Square Static Mixer	50 Pack
70070	Versa-Tip	6 Pack
ORBIT	<b>NEW!</b> OE Ripple Bead Installation Tip	Not Sold Separately
SHFT	<b>NEW!</b> SEM Hem Flange Tip	Not Sold Separately

① 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.

# SPRAYABLE SOUND DAMPENING

## STANDARD OPERATING PROCEDURE

### 1 PREP



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

### 2 SAND



Sand primer with P180 grit. Sand bare metal with P80 grit. Blow off and tack clean. Re-clean with **SEM Solve** or **XXX Universal Surface Cleaner**. Wipe clean in one direction with clean, lint-free cloth.

### 3 SET UP EQUIPMENT



Place **Dual-Mix Sound & Seal Sprayable Coating** into **Universal Pneumatic Applicator**. Equalize cartridge until sides dispense equally. Attach **Quick Spray System** to cartridge.

⚠ Do not cut **Quick Spray System Static Mixer** tip.

### 4 APPLY



Apply to necessary areas, duplicating existing texture in one coat.

⚠ Do not apply over self etching primer.

ⓘ To achieve various textures, modify the air pressure, spray distance and spray tip.

### WATCH & LEARN



Watch the SOP video and download additional literature at:

[semproducts.com/sounddampening](http://semproducts.com/sounddampening)

### PRODUCT LIST



#### PREP

Part	Product	Size
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Quart
77771	XXX Universal Surface Cleaner	Gallon
77774	XXX Universal Surface Cleaner	Quart



#### APPLY

Part	Product	Size
40977	Dual-Mix Sound & Seal Sprayable Coating	7 oz. Cartridge



#### EQUIPMENT

Part	Product
70039	Universal Pneumatic Applicator
70100	Quick Spray System Starter Kit

### ADDITIONAL 2K SOUND DAMPENING PRODUCTS



#### DUAL-MIX CARTRIDGES

Part	Product	Size
39357	Dual-Mix Flexible Urethane Foam	7 oz. Cartridge
39977	Dual-Mix Panel Vibration Control Material	7 oz. Cartridge
39997	Dual-Mix Rigid Urethane Foam	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.

# PLASTIC TAB REPAIR

## STANDARD OPERATING PROCEDURE



### 1 PREP

Clean front and back with **Scuff & Clean** and 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

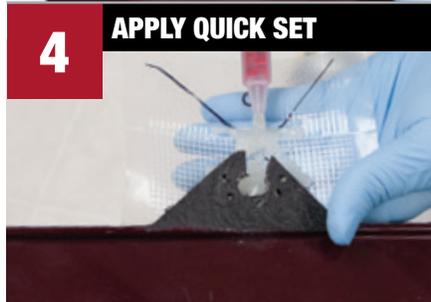
Grind repair on both sides at low RPM or by hand with P36 grit disc. Drill 1/8" holes in repair area to help "lock in" the repair material. Blow off surface.

- ⚠ Do not grind too fast and cause plastic to melt.
- ℹ For TPO, EPDM, PP and similar plastics, apply **Plastic Adhesion Promoter** or **XXX 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 torn or missing tab. 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.



### WATCH & LEARN

PLASTIC TAB REPAIR  
STANDARD OPERATING PROCEDURE



Watch the SOP video and download additional literature at:  
[semproducts.com/tabrepair](http://semproducts.com/tabrepair)

## PRODUCT LIST



### PREP

Part	Product	Size
38351	Plastic & Leather Prep	Gallon
38353	Plastic & Leather Prep	16 oz. Aerosol
38354	Plastic & Leather Prep	Quart
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Quart
38391	Scuff & Clean	Gallon Pump
38398	Scuff & Clean	16 oz. Tube
39861	Plastic Adhesion Promoter	Gallon
39863	Plastic Adhesion Promoter	20 oz. Aerosol
39864	Plastic Adhesion Promoter	Cone Quart
77721	XXX Adhesion Promoter	Gallon
77723	XXX Adhesion Promoter	16 oz. Aerosol
77724	XXX Adhesion Promoter	Cone Quart
77771	XXX Universal Surface Cleaner	Gallon
77774	XXX Universal Surface Cleaner	Quart



### APPLICATION

Part	Product	Size
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 - Black	1.7 oz. Cartridge
40507	Dual-Mix Quick Set 50 - Black	7 oz. Cartridge
40517	NEW! Dual-Mix Quick Set 50 - Clear	7 oz. Cartridge
41807	Dual-Mix Quick Set 180	7 oz. Cartridge
70007	Plastic Repair Contouring Tape	15' Roll

ℹ 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.

# QUICK SPRAY SYSTEM (FOR DUPLICATING OEM TEXTURES)

## 70100 Quick Spray System Starter Kit

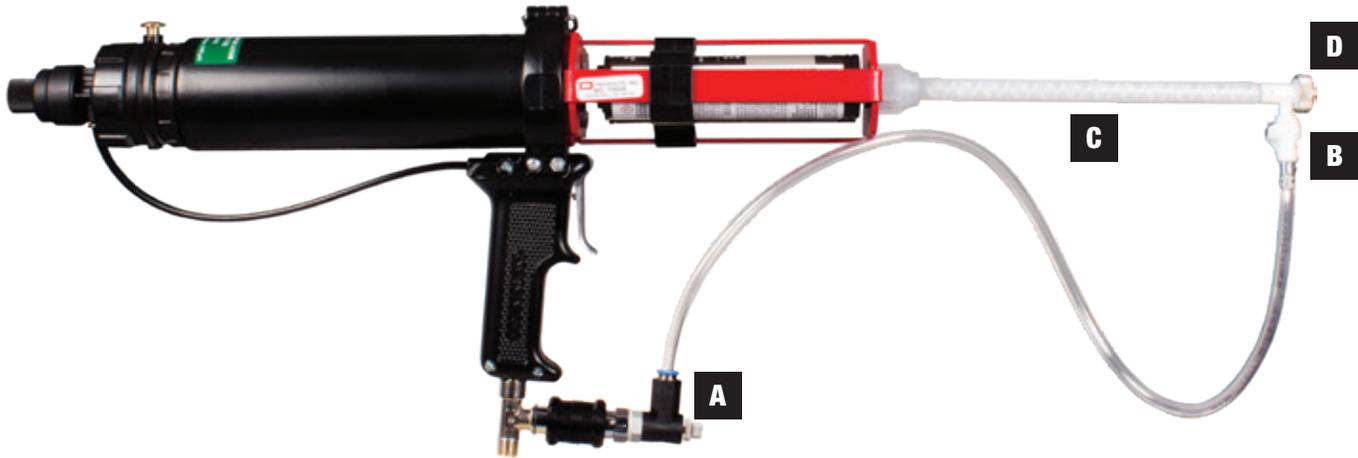
Everything you need to start spraying 2K sealers and sound dampening materials.

### NOTE

70039 Universal Pneumatic Applicator is not included in the Quick Spray System Starter Kit. Only use the Quick Spray System with specified SEM products.

### USE ONLY WITH

- 39377 *Dual-Mix* Seam Sealer - Gray
- 39477 *Dual-Mix* Seam Sealer - Beige
- 40177 *Dual-Mix* Heavy Bodied Seam Sealer - Gray
- 40277 *Dual-Mix* Heavy Bodied Seam Sealer - Beige
- 40377 *Dual-Mix* Heavy Bodied Seam Sealer - Black
- 40477 *Dual-Mix* Heavy Bodied Seam Sealer - White
- 40977 *Dual-Mix* Sound & Seal Sprayable Coating



**A**



70104  
**Adapter Assembly**  
Quantity: 1

**B**



70106  
**Air Baffle**  
Quantity: 5

**C**



70103  
**Static Mixers**  
Quantity: 6

**D**



70101  
**Round Air Assembly**  
Quantity: 1

70102  
**Flat Air Assembly**  
Quantity: 1

## 1.7 OZ. ACCESSORIES (40202 QUICK SET 20 & 40502 QUICK SET 50)

### 70019 1.7 oz. Manual Applicator

Convenient and compact for dispensing 1.7 oz. *Dual-Mix* cartridges.



### 70020 (6 PACK) 70021 (50 PACK) 1.7 oz. Turbo Static Mixers

Mixing tips for use with 1.7 oz. *Dual-Mix* cartridge products.



# 7 OZ. APPLICATORS & ACCESSORIES

71119  
**Universal Manual Applicator**

Applicator for dispensing 7 oz. two-component cartridges.

- Ensures proper mix ratio
- Ideal gear ratio for smooth dispersion
- Release button for precision



70011 (6 PACK)  
70012 (50 PACK)  
**Integral Nut Square Static Mixers**

Mixing tips for use with 7 oz. two-component cartridge products.



70103 (6 PACK)  
**Quick Spray System Static Mixers**

Extended mixing tips for use when spraying seam sealers and sound dampening materials.



70039  
**Universal Pneumatic Applicator**

Dispensing applicator for 7 oz. two-component cartridges.

- Decreases fatigue
- Increases efficiency
- Smooth, even dispensing
- Adjustable flow rate
- Use with **Quick Spray System**



70070 (6 PACK)  
**Versa-Tip**



Customizable tips, graduated and notched for easy trimming to duplicate .5", .75" 1", 1.25", and 1.5" flat ribbon beads out of 7 oz. two-component cartridges

**ORBiT tip**  
PATENT PENDING



**NEW**

Duplicates OE seam sealer ripple beads commonly found on strut towers, trunk pans and rear body pans of most vehicles. Works with **SEM** 1K and 2K seam sealers.



**ORBiT** tip and 2K adapter included with **Dual-Mix Heavy Bodied Seam Sealer** 40177, 40277, 40377 & 40477

**WATCH THE VIDEO TO FIND OUT HOW YOU CAN REPAIR BUMPERS FASTER WITH *DUAL-MIX* CARTRIDGES.**



[semproducts.com/repair-bumpers-2x-faster](http://semproducts.com/repair-bumpers-2x-faster)

**NEW**

**SHFT**  
**SEM Hem Flange Tip**



**SHFT** tip and 2K adapter will be included with **Dual-Mix Seam Sealer** 39377 & 39477



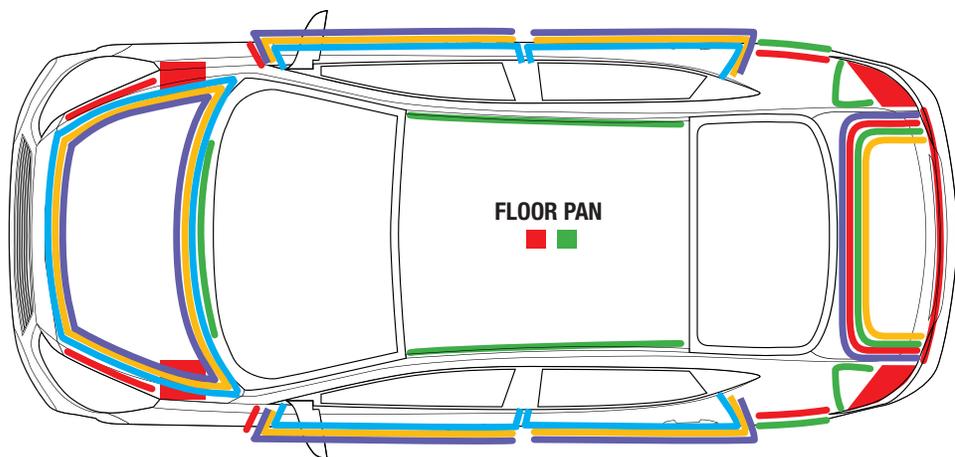
Duplicates OE hem flange seam sealer beads commonly found on doors, hoods and deck lids of most vehicles.

- Reduces seam sealing time up to 65%
  - No masking required
  - No spreading required
- Eliminates 100% of waste left on tape
- Works with **SEM** 1K & 2K seam sealer cartridges
- Distributes the bead evenly by guiding from the center of the seam





# EASILY DUPLICATE OEM SEAM SEALER BEADS



## COMMON APPLICATIONS KEY

- SHFT TIP
- ORBiT TIP
- EXTRUSION NOZZLE
- DOOR SKIN NOZZLE
- VERSA-TIP



### ■ SHFT | SEM Hem Flange Tip

Duplicates OE hem flange seam sealer beads commonly found on doors, hoods and deck lids of most vehicles. Works with 1K and 2K SEM seam sealer cartridges.

SHFT tip and 2K Adapter will be included with *Dual-Mix Seam Sealer* 39377 & 39477



### ■ ORBiT | OE Ripple Bead Installation Tip

Duplicates OE seam sealer ripple beads commonly found on strut towers, trunk pans and rear body pans in many newer vehicles. Works with 1K and 2K SEM seam sealer cartridges.

ORBiT tip and 2K Adapter included with *Dual-Mix Heavy Bodied Seam Sealer* 40177, 40277, 40377 & 40477



### ■ EXTRUSION NOZZLE | 29322

Specialty tip for creating various beads and offsets. Requires 2K Adapter for use with 2K cartridges.



### ■ DOOR SKIN NOZZLE | 29312

Specialty flanged tip that quickly duplicates the appearance of offset door skin seam sealer beads. Requires 2K Adapter for use with 2K cartridges.



### ■ VERSA-TIP | 70070

A customizable tip, graduated and notched for easy trimming to duplicate 0.5", 0.75", 1", 1.25" and 1.5" flat, ribbon beads out of 7 oz., 2K seam sealer cartridges.





# 2 NEW SEAM SEALER TIPS THAT PUSH PRODUCTION INTO HIGH GEAR



**ORBIT**  
OE Ripple Bead Installation Tip  
PATENT PENDING

See **ORBIT** tip in action at [semproducts.com/orbit](http://semproducts.com/orbit)

## Duplicating OEM ripple beads on strut towers, trunk pans and rear body pans just got a lot easier!

**ORBIT**, the OE Ripple Bead Installation Tip, duplicates the OE seam sealer ripple bead commonly found on strut towers, trunk pans and rear body pans of most newer vehicles.

- Patent-pending design
- No special technique required
- Easy to use
- Works with manual or pneumatic applicators
- Can help limit shop's post-inspection liability by matching seam sealer color and texture
- Optimized for use with **Dual-Mix Heavy Bodied Seam Sealer** over primed surfaces
- Works with **SEM 1K & 2K** seam sealer cartridges



**ORBIT** tip and **2K Adapter** included with **Dual-Mix Heavy Bodied Seam Sealer** 40177, 40277, 40377 & 40477



**SHFT**  
SEM HEM FLANGE TIP

## SAVE TIME. REDUCE WASTE.

Duplicates OE hem flange seam sealer beads commonly found on doors, hoods and deck lids.

- Reduces seam sealing time up to 65%
  - No masking required
  - No spreading required
- Eliminates 100% of waste left on tape
- Works with **SEM 1K & 2K** seam sealer cartridges
- Distributes the bead evenly by guiding from the center of the seam

NO SPECIAL  
TECHNIQUE  
REQUIRED



**SHFT** tip and **2K Adapter** will be included with **Dual-Mix Seam Sealer** 39377 & 39477



# DUAL-MIX™

TRUSTED FOR OVER

25  
YEARS



PARTS & LABOR  
**WARRANTY**  
FOR LIFE

## Dual-Mix Forever Warranty

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

When applicable, OEM repair procedures must be followed.



Learn more about  
*Dual-Mix* at:

[semproducts.com  
/dual-mix](http://semproducts.com/dual-mix)



## SEM School

LEARN AUTOMOTIVE REPAIR &  
REFINISHING TECHNIQUES

Stay ahead of the competition by learning about the latest automotive refinishing techniques at **SEM School**.

GET CERTIFIED BY **SEM** FOR I-CAR

LEARN MORE AT  
[semproducts.com/sem-school](http://semproducts.com/sem-school)

## In-Shop Training

AVAILABLE FOR  
QUALIFIED COLLISION CENTERS

We'd be happy to meet you for free at your shop. We can demo products, train and answer any questions. These sessions can be tailored to your needs and anyone is welcome to attend.

CONTACT YOUR LOCAL **SEM** REP  
FOR MORE INFORMATION  
ABOUT TRAINING OPPORTUNITIES



TECH SUPPORT 1-800-831-1122  
CUSTOMER CARE 1-866-327-7829



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