



Document Library
Technical Data Sheet 05888

Public

Rev:1

Effective: 11/30/2005

Status: Active

3M™ Automix™ EZ Fix Flexible Patch

Data Sheet

3M Part No.(s) **3M Part Descriptor (s)**
05888 3M™ Automix™ EZ Fix Flexible Patch

3M Fax on Demand Identification Number : 05888

Description

3M™ Automix™ EZ Fix Flexible Patch: 4" x 8" TPO plastic backing laminated with 3M™ acrylic foam tape.

Features, Advantages, Benefits

Features	Strong, flexible, easy to apply.
Advantages	Produces a clean appearance on back side repair. No cure time needed prior to applying cosmetic filler to front side of repair.
Benefits	Ease of application, no mixing or spreading of adhesive. Saves time during repair process.

Typical Physical Properties

Container	6 patches per billing unit (box)	Packaged with 06396 adhesion promoter.
Base	TPO plastic and acrylic foam tape.	
Density lbs/Gallon (Appx.)	N/A	
Color	black	
Flash Point - °F	N/A	
Viscosity (CPS) Brookfield Viscometer	N/A	
Solids Content (Appx.)	100%	
Consistency	Flexible plastic	
Solvent	N/A	
Service Temperature - °F	-20 to 180 F	
Propellant	N/A	

Product Uses

The 3M™ Automix™ EZ Fix Flexible Patch is used in conjunction with 06396 adhesion promoter to reinforce the inside of a "two sided" plastic repair: (damage that penetrates through the plastic material) The outside of the repair is performed using traditional cosmetic flexible plastic repair procedures.

Performance Properties

05888 will exhibit similar characteristics to TPO type bumper plastics; it is flexible yet strong, and uses acrylic foam tape technology (06396 foam tape adhesion promoter must be used) to adhere to the plastic

and reinforce plastic that has been cracked, torn, or perforated during a collision.

Handling and Application Information

Directions for Use

1. This procedure is for tears, punctures, holes and other damage that require front and backside reinforced repairs. The repair procedure uses the new, patent-pending 3M bumper patch.
2. Clean the panel thoroughly on both sides with soap and water first, then followed by 3M General Purpose Adhesive Cleaner (PN 08984, 08986 or 08987)*.
 - On the back side of the bumper, it is critical that all paint overspray be removed in the area where the patch will be placed. This paint overspray has a weak bond to the bumper plastic and can lift off easily if not removed.
3. This step is only if you are repairing a crack that has reached to the edge of the bumper plastic: Before proceeding with the repair, grind a v-notch at the edge of the crack as in the diagram at right. This will keep the crack from propagating later in the procedure.
4. Wipe the back side of the bumper where the patch will be placed with 3M Automotive Adhesion Promoter (06396). Allow this to dry for 5 minutes.
5. Cut to size, remove the release liner, and apply the new 3M bumper patch to the backside of the bumper. Press in place firmly, as pressure will increase the bond strength. If the full-size patch is too small for the damage you are repairing, this is not an appropriate repair to make with the patch.
6. On the front side, use a grade 50 Roloc disc to dish out the crack or bevel the sides of the hole.
 - It is okay to dish into the bumper patch tape, but take care not to grind all the way through the patch itself. Also take care not to abrade areas on the front side of the bumper that will not be covered by repair adhesive in a later step.
7. Switch to a grade 80 DA disc and continue to dish out the repair on the front side, insuring that there are no sharp edges that will cause the repair to be visible once completed. Finish the dishing out and blending into the undamaged area with grade 180 DA paper (see diagram at right).
8. Blow off the repair piece using clean, un-oiled compressed air.
9. Spray the front side repair area with 3M Automix Polyolefin Adhesion Promoter (05907) and allow to dry for 5 minutes.
10. Apply 3M EZ Sand Flexible Parts Repair (PN 05887) in thin layers to the front side of the repair piece, building it up until it is slightly higher than the surrounding area. Allow 15 minutes to continue.
11. Check to be sure the material is ready for sanding, and use a grade 80 DA disc to bring the repair material almost level with the surrounding area. Switch to grade 180 to blend the repair material flush with the panel, and finish with grade 320.
12. Reapply 3M Automix Polyolefin Adhesion Promoter (05907). Prime and paint per paint manufacturer recommendations.

* If 'Directions for Use' reference P.N.'s 08984, 08986, or 08987, please read. Federal and local air quality regulations may regulate or prohibit the use of surface preparation and cleanup solvents based on VOC content. Consult your local and Federal air quality regulations for information. When using solvents, use in a well ventilated area. Extinguish all sources of ignition in the work area and observe precautionary measures for handling these materials. Refer to product label and MSDS for P.N. 8984, 8986, or 8987 for detailed precautionary information.

Applications

Repairing of automotive plastic bumper fascias, wheel flares, splash shields, and other cosmetic plastic parts that are flexible or semi-flexible.

Storage and Handling

Store at room temperature. Rotate stock on a "first-in, first-out" basis. When stored at the recommended conditions in original, unopened containers, this product has a shelf life of 12 months.

Precautionary Information

Refer to Product Label and Material Safety Data Sheet for Health and Safety Information before using this product .

Country

This document is public . It may be distributed .

Warranty and Limited Remedy

This product will be free from defects in material and workmanship at the time of shipment. 3M MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE. User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's application. If this product is defective, your exclusive remedy and 3M's and seller's sole obligation shall be, at 3M's option, to replace the product or refund the purchase price.

LIMITATION OF LIABILITY : 3M and seller will not be liable for any loss or damage arising from this 3M product, whether direct , indirect , special, incidental or consequential , regardless of the legal theory asserted , including warranty , contract , negligence or strict liability .

For Additional Health and Safety Information

3M Automotive Aftermarket Division

3M Center, Building 223-6N-01

Saint Paul, MN 55144-1000

1-877-666-2277 (1-877-MMM-CARS)

Material Safety Data Sheets and Technical Data Sheets are also available by calling Fax on Demand 1-800-305-0419.

Help Line 1-800-621-5455 (US) 1-650-596-4407 (International).

3M Fax on Demand /MSDS Identification Number 05888

Author: Dennis R. Keicher/US-Corporate/3M/US

Modifiers: Dennis R. Keicher/US-Corporate/3M/US

This is the last page