



Public

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3M™ Automix™ EZ Sand Flexible Parts Repair Kit

Data Sheet

3M Part No.(s)	3M Part Descriptor (s)
05895	3M™ Automix™ EZ Sand Flexible Parts Repair Kit (5 oz. tubes)

3M Fax on Demand Identification Number : 05895

Description

Two-part epoxy use to repair most plast parts, including bumper covers and other plastic body panels (not for SMC/fiberglass).

Features, Advantages, Benefits

Features	Epoxy base Easy to use 1:1 mix ratio
Advantages	Formulated for excellent featheredge No applicator gun required
Benefits	Easy sanding Strong repair with low cost of use

Typical Physical Properties

Container	Kit (5 oz. Tubes)
Base	Epoxy
Density lbs/Gallon (Appx.)	9.0/12.0 lbs/gal
Color	Gray/White
Flash Point - °F	Not Applicable
Viscosity (CPS) Brookfield Viscometer	
Solids Content (Appx.)	100%
Consistency	Paste
Solvent	None
Service Temperature - °F	-20 to 180 deg F
Propellant	N/A
Viscosity (Pressflow)	40-110 sec

Product Uses

Two-part epoxy used to repair most flexible and semi-rigid plastic parts, including bumper covers and other plastic body panels (not for SMC/fiberglass, use PN 05885 for those materials). For low surface energy plastics, 3M™ Automix™ Polyolefin Adhesion Promoter (PN 05907) is required.

Performance Properties

Work time:	5-7 min
Sand time:	15 min
Cure time:	4 hours

Handling and Application Information

Directions for Use

1. Clean the areas to be bonded with soap and water. Next, use 3M™ General Purpose Adhesive Cleaner (N. 08984, 08986 or 08987-Aerosol) or use 3M™ Super Fast Adhesive Cleaner (N. 08215) to remove any grease, wax and/or tar. Read manufacturer's hazard communication and follow manufacturer's recommended guidelines for safe handling of the above chemical products.

IMPORTANT: You must apply adhesion promoter after every sanding or grinding step until the plastic part is completely covered with either a coating or a color coat.

2. Featheredge paint around the repair with a grade 180 disc on a DA sander. Also sand the outer edges of the repair area to round off any "SHARP" edges.

3. Wipe with a clean, dry rag and blow off with compressed air. Apply 3M™ Automix™ Polyolefin Adhesion Promoter (N. 05907) following label directions.

4. Dispense equal portions of 3M™ EZ Sand Flexible Parts Repair (N. 05895 or N. 05896), parts A and B onto a clean, dry mixing board. Mix the material thoroughly, using a clean spreader to a uniform color.

5. Apply a thin coat of mixed filler material to the repair area making certain to completely "WET OUT" the surface.

6. Add additional mixed filler, building up the repair higher than the surrounding, undamaged area.

7. Allow the repair material to cure 15 minutes at 65 to 75°F.

NOTE: Cure time is dependent on temperature. (Cold-slower, Hot-faster).

8. Sand with a grade 180 abrasive followed by 240.

9. Wipe and blow off the surface with compressed air (DO NOT SOLVENT WIPE). Apply 3M™ Automix™ Polyolefin Adhesion Promoter (N. 05907) following label directions.

Applications

Two-part epoxy used to repair most flexible and semi-rigid plastic parts, including bumper covers and other plastic body panels (not for SMC/fiberglass, use PN 05885 for those materials). For low surface energy plastics, 3M™ Automix™ Polyolefin Adhesion Promoter (PN 05907) is required.

Storage and Handling

HANDLING

Do not eat, drink or smoke when using this product. Wash exposed areas thoroughly with soap and water. Keep out of the reach of children. Keep container closed when not in use. Avoid breathing of dust created by cutting, sanding, grinding or machining. For industrial or professional use only. Avoid eye contact with dust or airborne particles.

STORAGE

Store away from acids. Keep container tightly closed. Store away from oxidizing agents.

Precautionary Information

Refer to Product Label and Material Safety Data Sheet for Health and Safety Information before using this product . Always wear gloves, eye protection, appropriate respiratory protection, and work in a well-ventilated area.

Country

US

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.

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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 05895

Author: Brett D. Einerson/US-Corporate/3M/US

Modifiers: Brett D. Einerson/US-Corporate/3M/US

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