



EZ Sand Flexible Parts Repair

05887

Technical Data

September, 2011

Product Description

3M™ EZ Sand Flexible Parts Repair is a flexible two part epoxy material designed for use in the repair of flexible and semi-rigid plastic parts. This formula provides flexibility with excellent sanding qualities and is compatible with many common plastics, for best results use in conjunction with **3M™ Polyolefin Adhesion Promoter (PN 05907)**.

Features

- Flexible two part epoxy technology
- 200 ml Dual-Syringe Cartridge System
- Paintable

Typical Physical Properties

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Container	200 ml dual-syringe cartridge system
Base	Epoxy
Density lbs/Gallon (Appx.)	10.3 / 12.5
Color	White / Gray
Solids Content (Appx.)	100%
Consistency	Paste
Service Temperature - °F	-20° to 180°F

Product Uses

Primarily designed for cosmetic repair such as scratches, gouges, and deformations of automotive exterior flexible and semi-rigid plastic parts, including bumper covers and other decorative parts. This product may also be used for commercial and industrial applications on similar types of plastic.

Use with the following applicators: PN 08571 (manual), PN 08117 (manual), and PN 09930 (pneumatic).

3M™ Static Mixing Nozzle: PN 08193 (6/bag), PN 08194 (50/box).

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05887

Typical Performance Properties

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

The following times have been determined with ambient air temperature and substrate temperature @ 70°F and are considered typical values.

WORK TIME:

5 minutes

MIX NOZZLE DWELL TIME:

7.5 minutes

SAND TIME:

15 minutes

CURE TIME

24 hours

PAINT TIME:

30 minutes

Lap Shear, TPO	472 PSI	ASTM D1002 / 2" per minute
Lap Shear, PP	417 PSI	ASTM D1002 / 2" per minute
Lap Shear, TEO	330 PSI	ASTM D1002 / 2" per minute

Overlap shear test method: Over lap shear test for adhesion determined in accordance with ASTM D1002. Sample dimensions 1" x 4" x .0111" with an overlap area of 1/2" x 1". Plastics cleaned with 3M™ General Purpose Adhesive Cleaner PN 08984 and DA sanded with P80 abrasive. Thermopolyolefin and Polypropylene plastics coated with 3M™ Polyolefin Adhesion Promoter PN 05907.

Directions for Use

SURFACE PREPARATION:

1. Wash surface with soap and water to remove water soluble contaminants. Follow the soap and water wash with an appropriate 3M VOC compliant product for removal of surface contaminants. Reference the 3M Automotive Aftermarket Catalog for a suitable VOC compliant product.
2. Sand the surface with a grade P180 abrasive.
3. Remove dust from surface using clean, un-oiled compressed air and a clean, dry rag.
4. **Apply 3M™ Polyolefin Adhesion Promoter (PN 05907) following label directions.**

PRODUCT PREPARATION:

1. Insert cartridge into applicator gun.
2. Remove retaining collar and plug from end of cartridge. Discard plug, save retaining collar.
3. Extrude a small amount of product until both parts A and B dispense equally. **NOTE:** If you choose not to use a mixing nozzle, extrude the amount of filler required, and mix by hand to a uniform color.
4. Attach 3M™ Mixing Nozzle (PN 08193) to cartridge and lock in place with retaining collar.
5. Dispense a small amount of material and discard.

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05887

Directions for Use (continued)

GENERAL REPAIR PROCESS:

1. Apply a thin coat of mixed material to the repair area using a clean plastic spreader, making certain to completely wet out the surface. Immediately add additional mixed material, building up the repair higher than the surrounding, undamaged area.
2. Allow material to cure 15 minutes.
3. Sand with a grade P180 abrasive followed by grade P240 and/or P320.
4. Remove dust from surface using clean, un-oiled compressed air and a clean, dry rag. **NOTE: DO NOT SOLVENT WIPE.**
5. **Apply 3M™ Polyolefin Adhesion Promoter (PN 05907) following label directions.**

APPLICATION WARNINGS:

Once the initial cleaning steps are completed, do not solvent wipe the repair area again.

CLEAN-UP:

Unmixed material may be cleaned from most surfaces with an appropriate 3M VOC compliant product for removal of surface contaminants. Reference the 3M Automotive Aftermarket Catalog for a suitable VOC compliant product.

Applications

3M™ EZ Sand Flexible Parts Repair may be used as a cosmetic filling and finishing material for the repair of gouges, scratches or deformations of flexible and semi rigid plastic parts. 3M™ EZ Sand Flexible Parts Repair may also be used in conjunction with 3M™ Reinforcing Tape (PN 04904) to repair cracks and holes in flexible and semi rigid plastic parts, for best results use with **3M™ Polyolefin Adhesion Promoter (PN 05907)**.

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

When stored at the recommended conditions in original, unopened containers, this product has a shelf life of 24 months from the date of manufacture. Store in a dry area at 72°F for optimal shelf life. Store away from acids and other oxidizing agents.

After use, leave mix nozzle in place to seal the cartridge.

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05887

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.

Technical Information

The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

Product Use

Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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For Additional Health and Safety Information



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