



Effective: 04/05/2017

# Technical Data Sheet

Supersedes: 01/11/2005

## Automotive Aftermarket Division

### 3M 05888 Instant Plastic Repair Patch 3M 06396 Patch Adhesion Promoter (Wipes)

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#### 1) Part Numbers

05888 Box of 3 Patches with 6 sachets of  
06396 (Part of 05888 or separately to be obtained in packs of 25)

#### 2) Description and end uses

3M Instant Plastic Repair Patch is a 200mm x 100mm thermoplastic patch, backing laminated with 3M high performance acrylic foam tape.

3M Instant Plastic Repair Patch is used to easily repair damaged plastic parts, whereas the repair requires backside reinforcement (i.e. holes or cracks).

Used in conjunction with 06396 Patch Adhesion Promoter, it offers an immediate adhesion on most plastics, allowing a fast and easy reinforcement of the back of the repair. The repair of the front can follow directly without wait, using the 3M plastic repair materials.

3M Instant Plastic Repair Patch is complementary to the range of 3M plastic repair materials and fillers.

#### 3) Physical Properties

3M 05888 Instant Plastic Repair Patch

<b>Base</b>	TPO plastic backing laminated on high performance acrylic foam tape
<b>Consistency</b>	Flexible plastic
<b>Color</b>	Black
<b>Solids content (typical)</b>	100 %
<b>Temperature resistance</b>	-10°C to +85°C
<b>Temperature of application</b>	+15°C to +35°C
<b>Storage conditions</b>	+5°C to +35°C.
<b>Shelf life</b>	No shelf life

## 3M 06396 Patch Adhesion Promoter

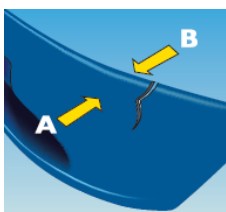
<b>Base</b>	Wet wipe, promoter itself is a colourless liquid, solvent based
<b>Temperature of application</b>	+15°C to +35°C
<b>Storage conditions</b>	+5°C to +35°C.
<b>Shelf life</b>	36 months from date of manufacture (see sachet)

- Ready to use repair system: easy application, no product mixing and spreading.
- High Performance acrylic foam tape: immediate and durable adhesion on most plastics when used in conjunction with 3M 06396 Patch Adhesion Promoter.
- Strong and flexible TPO plastic backing: easy to apply even on curved shapes and in corners. Can be heated to help shaping.
- No cure time after application: saves time in the repair process, 3M plastic repair material or filler can be applied on the front side of the repair immediately after patch application.
- Thin patch with black surface: produces a clean and nice appearance of the repair. Will not interfere with other parts of the repair area.

## 4) Directions for Use

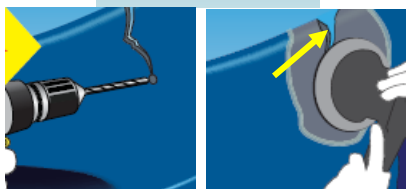
This procedure is for repair of tears, cracks, holes and all other damages requiring front and backside reinforced repairs on automotive plastic parts like bumpers.

Following example is for a crack repair.



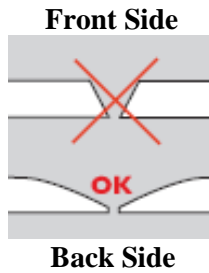
### 1. Clean part

- Remove part from the vehicle.
- Clean front (A) and backside (B) with high pressure washer or water and soap.
- Allow to dry.



### 2. Prepare repair area

- Drill a 4 to 6 mm hole at the end of the crack to release stress and prevent from further crack extension.
- If crack reach the edge of the part, grind a V-notch at the edge of the crack (see arrow) to avoid crack propagation later in the process.
- Sand front side (P80 - P180) to remove all paint around the repair area.



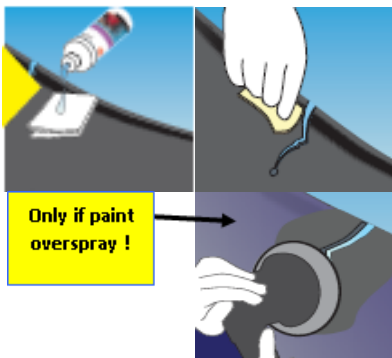
### 3. Prepare crack area

- Dish out the front side of the crack area to maximize bonding surface and achieve optimum repair resistance.
- Avoid heating and melting the plastic during sanding. Remove traces of melted plastic with a knife or thinner sanding.
- Avoid making sharp edges (see drawing) that may cause the repair to remain visible after painting.
- Blow off the repair area using clean, non-oiled compressed air.

### 4. Inside preparation – Adhesion promoter application

- Clean both side with 3M 22779 VHB Surface Cleaner or 3M 08984 cleaner.
- Wipe the repair area on the back of the part where the patch will be placed with 3M 06396 Patch Adhesion Promoter.
- Allow to dry for 5 minutes.

**Caution:** in case there is some paint overspray in the back side, it is critical to remove it (P320 sanding or clean with S'Brite + 08984) before applying the adhesion promoter and the patch. Not removing paint overspray creates a weak link that may reduce patch adhesion.



### 5. Patch Application

- Cut patch to size with scissors or a knife keeping 2 to 3cm around the crack or the hole.
- Remove the red liner.
- Apply to the repair area. Press firmly to get immediate adhesion.
- Excess of Patch on the edge can be cut with a knife.

Back side repair is completed.

### 6. Front side repair

- Finalize the repair on the front side as per the usual methods with 3M plastic repair material.
- For edge finishing, 3M 05888 Patch can be sanded when sanding the filler to achieve perfect appearance.
- Prime and paint as per your paint supplier recommendations.



## 5) Storage

Store in its original box between 5 C – 35 C in a dry area.

The patch has no shelf life, the adhesion promoter is has a shelf life of 36 months after manufacture in the original sealed sachet.



## 6) Safety

Read full instructions and material safety data sheet before use.

IMPORTANT: This product (06396) contains hazardous materials and therefore appropriate personal protective equipment should always be used. Please refer to the label and consult the material safety data sheet for full handling instructions and personal protection information. These are available via your stockist. The supplier disclaims any liability where the user does not wear the recommended personal protective equipment.

**3M 05888 Instant Plastic Repair Patch and 3M 06396 Patch Adhesion Promoter (Wipes) are designed FOR PROFESSIONAL INDUSTRIAL USE ONLY.**

## 7) Disclaimer

All statements, technical information and recommendations are based on tests we believe to be reliable but the accuracy or completeness thereof is not guaranteed. Please ensure before using our product that it is suitable for your intended use. All questions of reliability relating to this product are governed by the Terms of Sale subject, where applicable, to the prevailing law.

For Additional Health and Safety Information

### Denmark

3M a/s  
Automotive Aftermarket  
Hannemanns Allé 53  
2300 København S  
Tel: 43 48 01 00  
[3mkundeservicedk@mmm.com](mailto:3mkundeservicedk@mmm.com)  
[www.3MAuto.dk](http://www.3MAuto.dk)

### Finland

Suomen 3M Oy  
Automotive Aftermarket  
Keilaranta 6  
02150 Espoo  
Tel: 09 5252 1  
[tilaukset@mmm.com](mailto:tilaukset@mmm.com)  
[www.3M.fi/autotuotteet](http://www.3M.fi/autotuotteet)

### Norway

3M Norge AS  
Automotive Aftermarket  
Kanalveien 2  
2004 Lillestrøm  
Telefon: 06384  
[www.3m.no/auto](http://www.3m.no/auto)  
[kundeservice@mmm.com](mailto:kundeservice@mmm.com)

### Sweden

3M Svenska AB  
Automotive Aftermarket  
Bileftermarknad  
19189 Sollentuna  
Tel. 08-922100  
[kundeservice@mmm.com](mailto:kundeservice@mmm.com)  
[3M.se/bileftermarknad](http://3M.se/bileftermarknad)