Dynatron™ Dyna-Plus™
324 • 326

Technical Data Sheet
July, 2014

<table>
<thead>
<tr>
<th>3M Part No.(s)</th>
<th>3M Part Descriptor(s)</th>
</tr>
</thead>
<tbody>
<tr>
<td>324</td>
<td>3M™ Dynatron™ Dyna-Plus™ One gallon - 102 fl oz, 3.0L, 0.80 US gal.</td>
</tr>
<tr>
<td>326</td>
<td>3M™ Dynatron™ Dyna-Plus™ 5 gallon air dispenser pail - 3.75 gallons, 14.2L</td>
</tr>
</tbody>
</table>

Product Description
3M™ Dyna-Plus™ is a gold color, stain free, tack free, premium lightweight filler that offers excellent adhesion to steel, galvanized steel, aluminum, E-Coat, sheet molded compound (SMC) and fiberglass materials. The slightly thicker formula makes 3M™ Dyna-Plus™ the perfect choice for vertical applications. 3M™ Dyna-Plus™ is formulated for use under base coat/clear coat systems and is compatible with water borne paint systems.

Features
• Stain/Tack free resin
• Adhesion promoted
• Vacuum processed

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.

<table>
<thead>
<tr>
<th></th>
<th>Part A - Filler</th>
<th>Part B - Creme Hardener</th>
</tr>
</thead>
<tbody>
<tr>
<td>Container</td>
<td>PN 324 - One gallon metal can</td>
<td>2.75 oz. plastic tube</td>
</tr>
<tr>
<td></td>
<td>PN 326 - Five gallon air dispenser metal pail</td>
<td></td>
</tr>
<tr>
<td>Base</td>
<td>Polyester resin with styrene monomer</td>
<td>Benzoyl Peroxide</td>
</tr>
<tr>
<td>Density</td>
<td>8.25 - 8.75 lb/gal</td>
<td>10.0 lb/gal</td>
</tr>
<tr>
<td>Color</td>
<td>Gold</td>
<td>Red</td>
</tr>
<tr>
<td>Flash Point</td>
<td>88°F (31°C)</td>
<td>N/A</td>
</tr>
<tr>
<td>Viscosity @ 77°F (25°C) - Brookfield Viscometer</td>
<td>176,000 - 232,000 cps</td>
<td>70,000 - 150,000 cps</td>
</tr>
</tbody>
</table>
### Product Uses
Two component materials used to fill dents, gouges, and other cosmetic imperfections in galvanized steel, steel, aluminum, sheet molded compound (SMC), and fiberglass panels.

### Typical Performance Properties
The following times have been determined with ambient air temperature and substrate temperature @ 77°F (25°C) and are considered typical values.

**SHAPE SAND TIME:**
8 to 12 minutes when mixed with 2% hardener by weight @ 77°F (25°C)

**FINISH SAND TIME:**
20 minutes when mixed with 2% hardener by weight @ 77°F (25°C)

**RECOMMENDED APPLICATION TEMPERATURE:**
Above 45°F (7°C)

**SERVICE TEMPERATURE:**
Min. -20°F (-29°C)  Max. 180°F (82°C)

**MINIMUM HARDENER:**
1.5%

**MAXIMUM HARDENER:**
2.75%

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<table>
<thead>
<tr>
<th>Test Description</th>
<th>Value</th>
<th>Standard</th>
</tr>
</thead>
<tbody>
<tr>
<td>Lap Shear, Steel to Steel:</td>
<td>1,220 psi</td>
<td>ASTM D1002</td>
</tr>
<tr>
<td>Lap Shear, Aluminum to Aluminum:</td>
<td>1,100 psi</td>
<td>ASTM D1002</td>
</tr>
<tr>
<td>Tensile Strength:</td>
<td>1,190 psi</td>
<td>ASTM D638</td>
</tr>
<tr>
<td>Shore D hardness @ 24 hrs:</td>
<td>68</td>
<td>ASTM D2240</td>
</tr>
<tr>
<td>Flexural Strength:</td>
<td>1,880 psi</td>
<td>ASTM D790 Procedure A</td>
</tr>
<tr>
<td>Shrinkage:</td>
<td>0.69%</td>
<td>LTM 855.0084</td>
</tr>
</tbody>
</table>
**3M™ Dynatron™ Dyna-Plus™**

**Directions for Use**

Clean the repair area using soap and water followed by a wax & grease remover/surface cleaner. Sand the surface as needed with grade P40 to P80 3M™ abrasive.

**Note:** If grinding is required use a grade 50 3M™ grinding disc, blow off the sanding dust with clean dry air. If repairing galvanized steel, e-coat, primed/painted surfaces or aluminum, sand with grade 80 3M™ abrasive to remove the paint/primer. Blow off with clean dry compressed air and re-clean the surface using a clean paper or cloth towel and a wax & grease remover/surface cleaner.

1. Apply the required amount of body filler to a clean mixing surface. (Do not use discarded cardboard as a mixing surface as contamination may occur.) The correct hardener to filler ratio = 3 inch diameter circle 1/2 inch thick of filler to a 3 inch strip of cream hardener.

2. Mix the body filler and cream hardener thoroughly, to a uniform color. Gel time/setting time is approximately 3-5 minutes @ 75°F (22°C) using 2% hardener as prescribed. Spread the filler on the mixing board, being sure to break any air bubbles that were introduced during mixing.

3. Apply a thin layer using firm pressure to ensure maximum adhesion being sure to “wet out" the surface completely. Apply additional filler in layers, building up the damaged area higher than the surrounding surface. Maximum filler thickness should not exceed 1/4 inch. Allow curing time of 20 minutes.

4. Sand the filler to the proper contour with 3M™ abrasives, using the following recommended grade sequence: P40, P80, P180. **Note:** If more filler is needed blow off with clean dry compressed air and follow steps 2 through 5.

5. Wait approximately 45 minutes before applying primer and paint, always follow your paint company’s recommended procedures.

**Applications**

Repair of cosmetic surface imperfections in properly prepared auto body, industrial, and architectural substrates.

**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 16 months from the date of manufacture. Store in a dry area at 65-80°F (18-27°C) for optimal shelf life.
### Precautionary Information
Refer to Product Label and Material Safety Data Sheet for Health and Safety Information before using this product. See link below:

### 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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