



Dynatron™ Dyna-Plus™

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Technical Data Sheet

July, 2014

3M Part No.(s)	3M Part Descriptor(s)
324	3M™ Dynatron™ Dyna-Plus™ One gallon - 102 fl oz, 3.0L, 0.80 US gal.
326	3M™ Dynatron™ Dyna-Plus™ 5 gallon air dispenser pail - 3.75 gallons, 14.2L

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.

	Part A - Filler	Part B - Creme Hardener
Container	PN 324 - One gallon metal can PN 326 - Five gallon air dispenser metal pail	2.75 oz. plastic tube
Base	Polyester resin with styrene monomer	Benzoyl Peroxide
Density	8.25 - 8.75 lb/gal	10.0 lb/gal
Color	Gold	Red
Flash Point	88°F (31°C)	N/A
Viscosity @ 77°F (25°C) - Brookfield Viscometer	176,000 - 232,000 cps	70,000 - 150,000 cps

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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%

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

Lap Shear, Steel to Steel:	1,220 psi	ASTM D1002
Lap Shear, Aluminum to Aluminum:	1,100 psi	ASTM D1002
Tensile Strength:	1,190 psi	ASTM D638
Shore D hardness @ 24 hrs:	68	ASTM D2240
Flexural Strength:	1,880 psi	ASTM D790 Procedure A
Shrinkage:	0.69%	LTM 855.0084

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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.

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Precautionary Information

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

http://solutions.3m.com/wps/portal/3M/en_US/MSDS/Search/?gsaAction=msdsSRA&msdsLocate=en_US

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.

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For Additional Health and Safety Information



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