



Technical Data sheet.

Permacron® Putty 2025

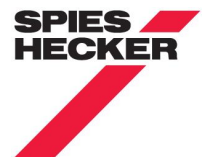
Standard 2K polyester putty for the Base System

Permacron® Putty 2025 is a universal polyester putty for refinish applications.

- Suitable for all common substrates.
- Allows for simple application.
- Offers good IR drying.
- Is easy to sand.
- Can be used as filler and as fine putty.

For professional use only!

Spies Hecker simply closer.



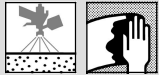
An Axalta Coating Systems Brand

Permacron® Putty 2025

Product preparation - application STANDARD



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Bare steel sanded and cleaned
Galvanised steel or aluminium, sanded and cleaned
Old or original paintwork well sanded and cleaned
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned
Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned
Fully cured 2K Surfacer or 2K Epoxy Primer-Surfacer sanded and cleaned



Putty	Hardener
Weight	Weight
100	2
2025	0909 0940 SLOW BPO BLUE BPO RED



Pot life at 20°C: 3 min - 5 min



Apply smooth film immediately after mixing, avoiding air entrapment.



	Raderal Hardener / BPO Hardener
20 °C	15 min - 30 min



Guideline for short wave IR equipment
Half power: 2 - 3 min



Coarse sand P80 - P120
Final sand P180 - P240



Raderal Spray Polyester 3508 (except on galvanised steel)
Primer
Primer-surfacer
Surfacer
If a fine Putty is required, apply this same product again.

VOC compliant

2004/42/IIB(b)(250) 150: The EU limit value for this product (product category: IIB(b)) in ready to use form is maximum 250 g/l of VOC. The VOC content of this product in ready to use form is maximum 150 g/l.

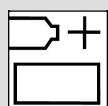
Permacron® Putty 2025

Products

Permacron® Putty 2025

BPO HARDENER PASTE BLUE
 BPO HARDENER PASTE RED
 RADERAL HARDENER 0909 RED
 Raderal® Hardener 0940 slow

Product mix



The choice of Hardener and Reducer should be made according to application temperature and size of repair.

0909 Red / BPO Red Standard hardener for dedicated Raderal Polyester Putties at temperatures of 15-25°C.

0940 Blue / BPO Blue Slow Hardener recommended for dedicated Raderal Polyester Putties. Mainly used at higher application temperature.



Clean after use with a suitable solventbased cleaning thinner.

Remarks

- Do not add more hardener than recommended to avoid bleeding and spot marking.
- Do not apply over 1K primer, etch primer or thermoplastic acrylic finishes.
- Do not wet sand.
- Reaction temperature should be at least +5°C.

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

All other products referred to in the refinish build up are from our product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our product range, unless explicitly indicated otherwise.

For professional use only! The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.