



## 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.



	0909 / 0940 / BPO
<b>20 °C</b>	15 min - 30 min



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



Coarse sand P80 - P120  
Final sand P180 - P240



Radical 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/II(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.

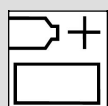
# Permacron® Putty 2025

## 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 Spies Hecker 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 Spies Hecker product range, unless explicitly indicated otherwise.

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