

Revised: June 2024

Effective: January 2019

Surface Preparation: No VOC Limit for National Rule (check local regulations)

CODE	DESCRIPTION	REMARKS	MIX RATIO			APPLIED VOC
VS1000	Axalta Surface Cleaning Solvent		Ready to Use			6.47 lbs./gal.
VS1100	Axalta Surface Cleaning Solvent		Ready to Use			0 lbs./gal.
VS1200	Axalta Anti-Static Degreaser		Ready to Use			3.7 lbs./gal.
VS1500	Axalta Plastic Cleaning Solvent		Ready to Use			6.5 lbs./gal.

Pretreatments VOC limit: 6.5 lbs./gal. (780 g/L)

CODE	DESCRIPTION	REMARKS	MIX RATIO	HARDENER	REDUCER	MAX APPLIED VOC (LE)
VS3000	Axalta Etch Primer		2:1	VS3001	-	5.4 lbs./gal.

Primer / Primer-Surfacers VOC Limit: 4.8 lbs./gal. (580 g/L) -- Other additives may be used, please consult Technical Data Sheet for usage requirements.

CODE	DESCRIPTION	REMARKS	MIX RATIO	HARDENER	REDUCER	MAX APPLIED VOC (LE)
431-22	DTM Grey Primer		4:1	445-10, 445-11, 445-12	-	4.8 lbs./gal.
431-40	Primer Surfacer		4:1:1	445-10, 445-11, 445-12	447-65, 447-75, 447-85	4.46 lbs./gal.
VS3200	Axalta DTM Epoxy Primer		2:1	VS3201	-	4.8 lbs./gal.

Adhesion Promoter VOC Limit: 4.5 lbs./gal. (540 g/L)

CODE	DESCRIPTION	REMARKS	MIX RATIO	HARDENER	REDUCER	MAX APPLIED VOC (LE)
VS2000	Axalta Plastic Adhesion Promoter		Ready to Spray	-	-	4.5 lbs./gal.

Primer-Sealer VOC Limit: 4.6 lbs./gal. (550 g/L) -- Other additives may be used, please consult Technical Data Sheet for usage requirements.

CODE	DESCRIPTION	REMARKS	MIX RATIO	HARDENER	REDUCER	MAX APPLIED VOC (LE)
431-9X	Urethane Sealer	431-90 /431-93 /431-97	4:1	445-10, 445-11, 445-12	-	4.6 lbs./gal.

Multi-Stage Topcoats VOC Limit: 5.0 lbs./gal. (600 g/L) Please consult Technical Data Sheet for compliant clearcoat recommendation along with any additional additives that may be used.

CODE	DESCRIPTION	REMARKS	MIX RATIO	HARDENER	REDUCER	MAX APPLIED VOC (LE)
NXN	NasonXL Basecoat		2:1	-	447-65, 447-75, 447-85	5.0 lbs./gal.
VS6001	Axalta 2K Transparent Color	See TDS	3:1: +10%	VS6002	447-65, 447-75, 447-85	5.0 lbs./gal.

Multi-Stage Topcoats VOC Limit: 5.0 lbs./gal. (600 g/L) Please consult Technical Data Sheet for compliant clearcoat recommendation along with any additional additives that may be used.

CODE	DESCRIPTION	REMARKS	MIX RATIO	HARDENER	REDUCER	MAX APPLIED VOC (LE)
438-22	Panel Clearcoat		3:1	445-10, 445-11, 445-12, 445-13	-	4.3 lbs./gal.
438-40	2K Overall Clearcoat		2:1	445-10, 445-11, 445-12, 445-13	-	4.2 lbs./gal.

Specialty Coatings VOC Limit: 7.0 lbs./gal. (840 g/L)

CODE	DESCRIPTION	REMARKS	MIX RATIO	HARDENER	REDUCER	MAX APPLIED VOC (LE)
442-56	National Rule Blending Additive		2:1	-	447-75, 447-85	7.0 lbs./gal.
VS6200	Axalta Matte Base Additive		See TDS	445-10, 445-11, 445-12, 445-13	-	3.23 lbs./gal.

Compliant Aerosol Coatings

CODE	DESCRIPTION	REMARKS	MIX RATIO	HARDENER	REDUCER	MAX APPLIED VOC (LE)
VS1150	Axalta Surface Cleaning Solvent Aerosol		Ready to Spray	-	-	6.2 lbs./gal.
VS3100	Axalta Etch Primer Aerosol		Ready to Spray	-	-	3.4 lbs./gal.