

Spies Hecker® VOC Compliance Chart



Butte County AQMD Rule 235 Group 2- Effective 07/01/1999
 Colusa County APCD Rule 2.42 Group 2- Effective 07/01/2000
 Shasta County AQMD Rule 3:25 Group 2- Effective 07/01/1998
 Tehama County APCD Rule 4:35 Group 2- Effective 07/01/1999

Description	Compliant Rule(s)	Applied VOC g/L	Remarks
Surface Preparation VOC Limit = 1.67 lbs/gal (200 g/L)			
107™ Axalta Low VOC Gun & Equipment Cleaner		25	
210™ Axalta Silicone Remover Water		164	
220™ Axalta Silicone Remover Low VOC		20	
Permaloid® Silicone Remover 7087 (Aerosol)	Butte, Colusa, Shasta, Tehama	N/A	
205™ Axalta Silicone Remover (Aerosol)		N/A	
130™ Axalta Cleaner		0	
Permahyd® Silicone Remover 7085 (in a spray bottle)		188	
Permahyd® Silicone Remover 7086 (in a spray bottle)		165	
Permahyd® Silicone Remover 7096 (in a spray bottle)		25	

Description	Mix Ratio	Hardener	Reducer/ Additive	Addl Product	Max Applied VOC (LE) g/L	Remarks
Surface Preparation (Plastic) VOC Limit = 6.5 lbs/gal (780 g/L) if applied from hand-held spray containers; bug and road tar only.						
Permahyd® Plastic Cleaning Paste 7081					13	
285™ Axalta Plastic Cleaning Paste					13	
225™ Axalta Bug & Tar Remover					347	Must be applied with a spray bottle for compliance.
139™ Axalta Bug & Tar Remover					347	Must be applied with a spray bottle for compliance.
200™ Axalta Silicone Remover Slow					750	Must be applied with a spray bottle for compliance.
Permanent® Silicone Remover 7010 Slow (in a spray bottle)					750	Must be applied with a spray bottle for compliance.

Description	Mix Ratio	Hardener	Reducer/ Additive	Addl Product	Max Applied VOC (LE) g/L	Remarks
Pre-treatment VOC Limit = 6.5 lbs/gal (780 g/L)						
Primat® Primer 3255 (Aerosol)	Ready to Use	N/A	N/A	N/A	N/A	
Primat® Primer 3265	+50%	N/A	8580, 3363, 3365	N/A	780	
Primat® 5.5 Wash Primer 4055	2:1	4056	N/A	N/A	780	
425™ Axalta Etch Primer Low VOC	2:1	426	N/A	N/A	780	
Primat® Wash Primer 4075	1:1	4076	N/A	N/A	780	
420™ Axalta Etch Primer	1:1	421	N/A	N/A	780	
Primat® 1K Primer Surfacer 4085	+50%	N/A	8580, 3363, 3365	N/A	780	
Primat® 1K Primer Surfacer 4085 (Aerosol)	Ready to Use	N/A	N/A	N/A	N/A	
410A™ Axalta 1K Primer Surfacer Light Gray	Aerosol	N/A	N/A	N/A	N/A	
420A™ Axalta 1K Primer Surfacer Dark Gray	Aerosol	N/A	N/A	N/A	N/A	
495™ Axalta Metal Pretreatment Wipes	Ready to Use	N/A	N/A	N/A	780	
Axalta® Pretreatment Wipes PS4000™	Ready to Use	N/A	N/A	N/A	780	

Description	Mix Ratio	Hardener	Reducer/ Additive	Addl Product	Max Applied VOC (LE) g/L	Remarks
Primers/Primer Surfacers VOC Limit = 2.8 lbs/gal (340 g/L)						
Permahyd® 1K Productive Primer Surfacer 4100	+5-10%	N/A	6000	N/A	340	
Permasolid® EP Primer Surfacer 4502	2:1+10%	4503	3394	N/A	340	
460A™ Axalta Epoxy 2K	Ready to Use	Included	N/A	N/A	N/A	
Permacron® VHS Surfacer 5150	1.5:1+0.5%		3392, 3394	N/A	340	
Permacron® VHS Surfacer 5150	2:1+10-20%	3170	3369, 3370, 3371	N/A	340	
Permasolid® 2.1 Surfacer 5155	4:1+20-30%	3193, 3195, 3197, 3199	3369, 3370, 3371	N/A	340	
Permasolid® 2.1 Surfacer 5155 Elasticized	2:1+20-30%	3193, 3195, 3197, 3199	3369, 3370, 3371	+30% 9050	340	9050 must be added before hardener.
Permasolid® 2.1 Surfacer 5157	5:1+10-20%	3192, 3194, 3196	3392, 3392, 3394, 5409, 5410	N/A	340	
Permasolid® 2.1 Surfacer 5157 Elasticized	4:1+10-20%	3192, 3194, 3196	3392, 3392, 3394, 5409, 5410	+15% 9050	340	9050 must be added before hardener.
Permasolid® 1K UV Starlight Primer Surfacer 9002 (Aerosol)	Ready to Use	N/A	N/A	N/A	N/A	Aerosol
Permasolid® 1K UV Starlight Primer Surfacer 9002	Ready to Use	N/A	N/A	N/A	340	Non-aerosol version

Description	Mix Ratio	Hardener	Reducer/ Additive	Addl Product	Max Applied VOC (LE) g/L	Remarks
Primer-Sealers VOC Limit = 2.8 lbs/gal (340 g/L)						
Permasolid® 2.1 Surfacer 5155	2:1+30%	3193, 3195, 3197, 3199	9070	+10-20% 3369, 3370, 3371	340	
Permasolid® 2.1 Surfacer 5155 Elasticized	2:1+30%	3193, 3195, 3197, 3199	9070	+10-20% 3369, 3370, 3371 +15-30% 9050	340	
Permasolid® Spectro Surfacer 5400	2:1+20-30%	3193, 3195, 3197, 3199	9070	N/A	340	
Permasolid® Spectro Surfacer 5400 Elasticized	2:1+20-30%	3193, 3195, 3197, 3199	9070	+30% 9050	340	9050 must be added before hardener.
Permasolid® Spectro Sealer 5450	4:1+30%	3192, 3194, 3196	5409, 5410	N/A	340	
Permasolid® Spectro Sealer 5450 Elasticized	3:1+30%	3192, 3194, 3196	5409, 5410	+15-30% 9050	340	9050 must be added before hardener.
Permahyd® 2K Sealer 5650	1:5%	3080	N/A	N/A	340	

Single Stage Topcoat VOC Limit 1.0 lbs/gal (120 g/L) Additional additives may be used. Consult technical data sheet for usage and compliance.

Description	Mix Ratio	Hardener	Reducer/ Additive	Addl Product	Max Applied VOC (LE) g/L	Remarks
Permacron® Acrylic Urethane Series 257	3:1+5-10%	3307, 3309, 3310, 3315, 3320, 3325	8580, 3363, 3365	N/A	5.0	
Permacron® Automotive Top Coat FP 1005 Warm Gray VV604N	3:1	3307, 3309, 3310, 3315, 3320, 3325		+0-5% 8092, 8096	5.0	
Permacron® Automotive Topcoat Series 257 FP-1004 Rally Matt Black	4:1+25%	3220, 3230, 3240, 3245	8580, 3363, 3365	+15% 9050	5.0	
Permacron® Automotive Topcoat 257 Series FP-1002 Blue Black	4:1+25%	3220, 3230, 3240, 3245	8580, 3363, 3365	+15% 9050	5.0	
Permacron® Automotive Top Coat FP 1005 Warm Gray VV604N	4:1+10%	3220, 3230, 3240, 3245	8580, 3363, 3365, 3394, 5409, 5410	+0-5% 8092, 8096	5.0	

Multi-stage Topcoat VOC Limit = 3.5 lbs/gal (420 g/L) applied as a 2-stage or 3-stage system

Description	Mix Ratio	Hardener	Reducer/ Additive	Addl Product	Max Applied VOC (LE) g/L	Remarks
Basecoats: Must be used with specific clearcoats for compliance, check TDS for usage						
Permahyd® Hi-TEC Base Coat	+10-30%	N/A	6050, 6051, 6052, 6053	N/A	420	
Permahyd® Hi-TEC Base Coat w/ Hardeners	+5-10% +10-30%	3080	6050, 6051, 6052, 6053	N/A	420	
Permahyd® Base Coat Series 280/285	+0-15%	N/A	6000	N/A	420	
Permahyd® Base Coat Series 280/285	+0-10%	N/A	6002	N/A	420	
Permahyd® Base Coat Series 280/285	+5-10%	9007	+10-20% 6000 or 0-10% 6002	N/A	420	
Permasolid® 2K Diamond Midcoat, MC 0001	2:1+10-15%	3192, 3194, 3196	3392, 3394	+15% 9050	420	
Permasolid® 2K Transparent Red Midcoat, MC 0002	2:1+10-15%	3192, 3194, 3196	3392, 3394	+15% 9050	420	
Permasolid® 2K Transparent Blue Midcoat, MC 0003	2:1+10-15%	3192, 3194, 3196	3392, 3394	+15% 9050	420	
Permacron® Transparent Midcoat 3100	1:1+3%	3194, 3196	3394	9045, 9049, 9056, 9057, 9058	420	
Clearcoats: Must be used as a system with basecoats at/under 3.5 lbs/gal (420 g/L) for compliance, check TDS for usage						
Permasolid® Air Dm Clear Coat 8094 Elasticized	4:1+20%	3192, 3194, 3196	3392, 3394	+10% 9050	420	9050 must be added before hardener.
Permacron® 2.1 Clear Coat 8095	2:1+5-10%	3193, 3195, 3197, 3199	3369, 3370, 3371	N/A	420	
Permacron® 2.1 Clear Coat 8095 Elasticized	2:1+5-10%	3193, 3195, 3197, 3199	3369, 3370, 3371	+15-30% 9050	420	9050 must be added before hardener.
Permasolid® Low VOC Clear Coat 8096	2:1+10-15%	3192, 3194, 3196	3392, 3394	N/A	420	
Permasolid® Low VOC Clear Coat 8096 Elasticized	2:1+10-15%	3192, 3194, 3196	3392, 3394	+15% 9050	420	9050 must be added before hardener.
Permacron® Matte Clear Coat Additive 8091 with 8096 Flat Finish	3:1 w/8096	2:1 w/3194, 3196	+10-15% 3392, 3394	N/A	420	
Permacron® Matte Clear Coat Additive 8091 with 8096 Satin Finish	2:5:1 w/8096	2:1 w/3194, 3196	+10-15% 3392, 3394	N/A	420	
Permacron® 2.1 Clear Coat 8097	2:1+10-15%	3193, 3195, 3197, 3199	3369, 3370, 3371	N/A	420	
Permacron® 2.1 Clear Coat 8097 - ASAP	1.5:1+5%	3193, 3195, 3197, 3199	9055	+5% 3369, 3370, 3371	420	
Permacron® 2.1 Clear Coat 8097 Elasticized	2:1+10-15%	3193, 3195, 3197, 3199	3369, 3370, 3371	+15-30% 9050	420	9050 must be added before hardener.
Permacron® Matte Clear Coat Additive 8091 with 8095/8097 Flat Finish	3:1 w/8095/8097	2:1 w/3194, 3196	+0-5% 3371	N/A	420	
Permacron® Matte Clear Coat Additive 8091 with 8095/8097 Satin Finish	3:1 w/8095/8097	2:1 w/3194, 3196	+0-5% 3371	N/A	420	
Permasolid® Low VOC Clear Coat 8098	2:1+5%	3192, 3194, 3196	3392, 3394	N/A	420	
Permasolid® Low VOC Clear Coat 8098 Elasticized	2:1+10%	3192, 3194, 3196	3392, 3394	+15% 9050	420	9050 must be added before hardener.
Permasolid® Low VOC Clear Coat 8098 w/ 9055	See TDS 8098	3192, 3194, 3196	3392, 3392, 3394	N/A	420	
Permasolid® Low VOC Clear Coat 8098 w/ 8092 Matte Clear Coat Additive	See TDS 8092	3192, 3194, 3196	3392, 3394	N/A	420	
Permacron® Matte Clear Coat Additive 8091 with 8098 Flat Finish	6:1 w/8098	2:1 w/3194, 3196	+20% 3392, 3394	N/A	420	
Permacron® Matte Clear Coat Additive 8091 with 8098 Satin Finish	5:1 w/8098	2:1 w/3194, 3196	+20% 3392, 3394	N/A	420	

Specialty Coatings VOC Limit = 7.0 lbs/gal (840 g/L) - Can't exceed 5% paint volume on a monthly basis

Description	Mix Ratio	Hardener	Reducer/ Additive	Addl Product	Max Applied VOC (LE) g/L	Remarks
Elastic Coatings						
Permacron® 1.1 Elastic Primer Surfacer 3300	1:1	3301	N/A	N/A	840	
330™ Axalta Plastic Primer Surfacer Gray	1:1	331	N/A	N/A	840	
320™ Axalta Plastic Primer Surfacer Black	1:1	331	N/A	N/A	840	
Primat® Elastic Primer 3304	Ready to Use	N/A	N/A	N/A	840	
Primat® Elastic Primer 3304 (Aerosol)	Ready to Use	N/A	N/A	N/A	N/A	
Primat® Elastic Primer 4190	Ready to Use	N/A	N/A	N/A	840	
300™ Axalta Plastic Polyolefin Adhesion Promoter	Ready to Use	N/A	N/A	N/A	840	
305™ Axalta Plastic Polyolefin Adhesion Promoter Low VOC	Ready to Use	N/A	N/A	N/A	N/A	
310A™ Axalta Plastic Polyolefin Adhesion Promoter Aerosol	Ready to Use	N/A	N/A	N/A	N/A	
Permacron® Semi-gloss Elastic Clear Coat 8070	3:1+5-10%	3193, 3195, 3197, 3199	8680, 3363, 3365	N/A	840	

Description	Mix Ratio	Hardener	Reducer/ Additive	Addl Product	Max Applied VOC (LE) g/L	Remarks
Uniform Finish Coatings						
Permacron® Speed Blender 1036	4:1 w/Permacron® or Permasolid® Clear Coats (RTS)				840	
Uniform Finish Coatings						
Permacron® Speed Blender 1036 w/8096	See 1036 TDS for compliant mixing recommendations				840	
Permacron® Speed Blender 1036 w/8095 or 8097	See 1036 TDS for compliant mixing recommendations				840	
Permacron® Speed Blender 1036 w/8098	See 1036 TDS for compliant mixing recommendations				840	
Permahyd® Blend-In Additive 9005	1:1 w/Permahyd® Base Coat Series 280/285 (RTS)				840	
Permahyd® Blend-In Additive 9017	1:2 w/Permahyd® Base Coat Series 280/285 (RTS)				840	
Permahyd® Blend-In Additive 9017	+50%	N/A	9016	N/A	840	
Permahyd® Hi-TEC Blend-In Additive 1050 or 1051	+10%	N/A	6050, 6052	N/A	840	
Permahyd® Hi-TEC Blend-In Additive 1050	+5%	N/A	1053	N/A	840	

Description	Mix Ratio	Hardener	Reducer/ Additive	Addl Product	Max Applied VOC (LE) g/L	Remarks
Other Products						
Other components that may be used (list is not all-inclusive). Consult technical data sheet for usage and compliance.						
Permasolid® Additive Maroon 9056			See 998.0 TDS for compliant mixing recommendations		420	
Permasolid® Additive Magenta 9057			See 998.0 TDS for compliant mixing recommendations		420	
Permasolid® Additive Violet 9058			See 998.0 TDS for compliant mixing recommendations		420	
Permasolid® Additive Deep Red 9049			See 998.0 TDS for compliant mixing recommendations		420	
Permasolid® Additive Blue 9045			See 998.0 TDS for compliant mixing recommendations		420	
Rader® Spray Polyester 3508	+5%	9520	+5% 7690 or +2.5% 9010	N/A	N/A	
766A™ Axalta 1K Trim Black Satin	Ready to Use	N/A	N/A	N/A	N/A	Aerosol
715™ Axalta Sanding Paste	Ready to Use	N/A	N/A	N/A	-	
Axalta E-Coat Restore Aerosols	Ready to Use	N/A	N/A	N/A	N/A	See TDS for compliance and usage instructions.

Edition 1/2024
 **** Group 2 Vehicles : Public transit buses and mobile equipment, where color match is required.
 For complete product usage and mixing recommendations, see the product specific technical data sheet located on www.spieshecker.com.
 Copyright © 2024 Axalta Coating Systems, Spies Hecker® and all products designated with TM or ® are trademarks or registered trademarks of Axalta Coating Systems for its brands of refresh systems. All rights reserved.