

Spies Hecker® VOC Compliance Chart
 State of Wisconsin
 Chapter NR 422 Part 095 - Automobile Refinishing Operations
 Effective: 3/1/2013



Description	Mix Ratio	Hardener	Reducer/ Additive	Addl Product	Applied VOC lbs/gal	Remarks
Surface Preparation VOC Limit = 4.2 lbs/gal (99 g/L)						
117™ Axalta Low VOC Gun & Equipment Cleaner					0.2	
220™ Axalta Silicone Remover Low VOC					0.2	
205™ Axalta Silicone Remover (Aerosol)					N/A	If using non-refillable aerosol products of less than 160 ounces per day, per facility.
Premahyde® Plastic Cleaner Paste 2001					0.1	
265™ Axalta Plastic Cleaners Paste					0.1	
Premalok® Silicone Remover 7007 (Aerosol)					N/A	If using non-refillable aerosol products of less than 160 ounces per day, per facility.
Premahyde® Silicone Remover 7006					0.2	
Pre-treatment VOC Limit = 6.5 lbs/gal (280 g/L)						
Priema® Primer 3235	+50%	N/A		8580, 3363, 3365	6.5	
Priema® Primer 3235 (Aerosol)	Ready to Use	N/A		N/A	N/A	
Priema® Wash Primer 4021	1:1	4026		N/A	6.5	
Priema® 1K Primer Surface 4085 (Aerosol)	Ready to Use	N/A		N/A	N/A	
Priema® 1K Primer Surface 4085	+50%	N/A		8580, 3363, 3365	6.5	
Axalta® Pretreatment Wipes PS-2000™	Ready to Use	N/A		N/A	6.5	
420™ Axalta Etch Primer	1:1	421		N/A	6.5	
410A™ Axalta 1K Primer Surface Light Gray	Ready to Use	N/A		N/A	N/A	
405A™ Axalta 1K Primer Surface Dark Gray	Ready to Use	N/A		N/A	2.5	
495™ Axalta Metal Pretreatment Wipes	Ready to Use	N/A		N/A	6.5	
Primer/Sealers VOC Limit = 4.8 lbs/gal (200 g/L)						
Premalok® 1K Undercoat Primer Surface 4100	+5-10%	N/A		6000	4.8	
Premalok® EP Primer Surface 4502	3:1+25-30%	4501		3363, 3365	4.8	
Premalok® EP Primer Surface 4502	2:1+10-15%	4503		3394	4.8	
460A™ Axalta Sealer 2K	Ready to Use	Included		N/A	4.8	
Premalok® 1HS Surface 5150	2:1 5 + 5-10%	3230, 3230, 3240, 3245		8580, 3363, 3365, 5408	4.8	
Premalok® 2.1 Surface 5147	4:1 + 5-10%	3307, 3309, 3310, 3315, 3320, 3325		8580, 3363, 3365, 5408, 5409, 5410	4.8	
Premalok® 1HS Surface 5147 Elastized	4:1 +10-20%	3307, 3309, 3310, 3315, 3320, 3325		8580, 3363, 3365, 5408, 5409, 5410	4.8	9050 must be added before hardener.
Premalok® HS Premium Surface 5310	2:1+5-10%	3307, 3309, 3310, 3315, 3320, 3325		8580, 3363, 3365	4.8	
Premalok® HS Premium Surface 5310	7:1+10-20%	3230, 3230, 3240, 3245		8580, 3363, 3365	4.8	
Premalok® Spectro Surface 5400	4:1+10-20%	3307, 3309, 3310, 3315, 3320, 3325		8580, 3363, 3365	4.8	
Premalok® Spectro Surface 5400 Elastized	2:1+5-10%	3307, 3309, 3310, 3315, 3320, 3325		8580, 3363, 3365	4.8	9050 must be added before hardener.
Premalok® Spectro Surface 5400	7:1+20%	3230, 3230, 3240, 3245		8580, 3363, 3365	4.8	
Premalok® Spectro Surface 5400 Elastized	3:1+20%	3230, 3230, 3240, 3245		8580, 3363, 3365	4.8	9050 must be added before hardener.
Premalok® Spectro Sealer 5430	3:1+20-25%	3307, 3309, 3310, 3315, 3320, 3325		5408	4.8	
Premalok® Spectro Sealer 5430 Elastized	2:1+20-25%	3307, 3309, 3310, 3315, 3320, 3325		5408	4.8	9050 must be added before hardener.
Premalok® Spectro Sealer 5450	4:1+20-30%	3230, 3230, 3240, 3245		5408	4.8	
Premalok® Spectro Sealer 5450 Elastized	4:1+25-30%	3230, 3230, 3240, 3245		5408	4.8	9050 must be added before hardener.
Premalok® Vario Surface 8590	3:1+5-10%	3307, 3309, 3310, 3315, 3320, 3325		8580, 3363, 3365	4.8	
Premalok® Vario Surface 8590 Elastized	2:1+5-10%	3307, 3309, 3310, 3315, 3320, 3325		8580, 3363, 3365	4.8	9050 must be added before hardener.
Premalok® Vario Surface 8590	6:1+10-20%	3230, 3230, 3240, 3245		8580, 3363, 3365	4.8	
Premalok® Vario Surface 8590 Elastized	5:1+10-20%	3230, 3230, 3240, 3245		8580, 3363, 3365	4.8	9050 must be added before hardener.
Premalok® 1K UV Starlight Primer Surface 9002 (Aerosol)	Ready to Use	N/A		N/A	N/A	Aerosol
Premalok® 1K UV Starlight Primer Surface 9002	Ready to Use	N/A		N/A	4.8	Non-Aerosol version
Primer-Sealers VOC Limit = 4.6 lbs/gal (200 g/L)						
Premalok® Spectro Surface 5400	2:1+20-30%	3307, 3309, 3310, 3315, 3320, 3325		5407	4.6	
Premalok® Spectro Surface 5400 w/Permicon Reducer	2:1+20-30%	3307, 3309, 3310, 3315, 3320, 3325		5407	4.6	
Premalok® Spectro Surface 5400 Elastized	2:1+20-30%	3307, 3309, 3310, 3315, 3320, 3325		5407	4.6	9050 must be added before hardener.
Premalok® Spectro Surface 5400 Elastized w/Permicon Reducer	2:1	3307, 3309, 3310, 3315, 3320, 3325		+40-20% 5407	4.6	
Premalok® Spectro Surface 5400	3:1+40-50%	3230, 3230, 3240, 3245		+40-20% 8580, 3363, 3365	4.6	
Premalok® Spectro Surface 5400 w/Permicon Reducer	3:1+40-50%	3230, 3230, 3240, 3245		5407	4.6	
Premalok® Spectro Surface 5400 Elastized	3:1+40-50%	3230, 3230, 3240, 3245		5407	4.6	9050 must be added before hardener.
Premalok® Spectro Surface 5400 Elastized w/Permicon Reducer	3:1	3230, 3230, 3240, 3245		+40-40% 5407	4.6	
Premalok® Spectro Sealer 5430	3:1+20-25%	3307, 3309, 3310, 3315, 3320, 3325		5409, 5410	4.6	
Premalok® Spectro Sealer 5430 Elastized	2:1+20-25%	3307, 3309, 3310, 3315, 3320, 3325		5409, 5410	4.6	9050 must be added before hardener.
Premalok® Spectro Sealer 5450	4:1+20-30%	3230, 3230, 3240, 3245		5409, 5410	4.6	
Premalok® Spectro Sealer 5450 Elastized	4:1+25-30%	3230, 3230, 3240, 3245		5409, 5410	4.6	9050 must be added before hardener.
Premahyde® 2K Sealer 8680	1:5%	3080		N/A	4.6	
Premalok® Vario Surface 8590 Elastized	3:1+20%	3307, 3309, 3310, 3315, 3320, 3325		8580, 3363, 3365	4.6	9050 must be added before hardener.
Premalok® Vario Surface 8590 Elastized	5:1+10-20%	3230, 3230, 3240, 3245		8580, 3363, 3365	4.6	9050 must be added before hardener.
Single Stage Topcoats VOC Limit = 6.0 lbs/gal (260 g/L)						
Premalok® Acrylic Urethane Series 297	3:1+5-10%	3307, 3309, 3310, 3315, 3320, 3325		8580, 3363, 3365	5.0	
Premalok® Automotive Topcoat Series 207 PD-1004 Rally Matt Black	4:1+20%	3230, 3230, 3240, 3245		8580, 3363, 3365	5.0	
Premalok® Automotive Topcoat Series 207 Series FC-1002 Blue Black	4:1+20%	3230, 3230, 3240, 3245		8580, 3363, 3365	5.0	
Premalok® Automotive Top Coat FP 1006 Warm Gray V604N	3:1	3307, 3309, 3310, 3315, 3320, 3325		+5-5% 8096, 8098	5.0	
Premalok® Automotive Top Coat FP 1006 Warm Gray V604N	4:1+10%	3230, 3230, 3240, 3245		8580, 3363, 3365, 3368, 5409, 5410	5.0	+5-5% 8096, 8098
2-Stage Topcoat VOC Limit = 4.8 lbs/gal (200 g/L) applied as a system						
3-Stage Topcoat VOC Limit = 8.2 lbs/gal (330 g/L) applied as a system						
Basecoats: Must be used with specific clearcoats for compliance						
Premahyde® 14-TEC Base Coat	+10-30%	N/A		6050, 6051, 6052, 6053	5.0	
Premahyde® 14-TEC Base Coat w/Hardeners	+5-10%+10-30%	3080		6050, 6051, 6052, 6053	5.0	
Premahyde® Base Coat Series 280/285	+5-10%	N/A		6002	5.0	
Premahyde® Base Coat Series 280/285	+10-10%	N/A		6002	5.0	
Premahyde® Base Coat Series 280/285	+5-10%	9007		+10-20% 6000 or 0-10% 8002	5.0	
Premalok® Base Coat Series 292/295	+40-50%	N/A		3054, 3056, 3056	5.0	
Premalok® FP203	+10%+40-50%	3307, 3309, 3310, 3315, 3320, 3325		3054, 3056, 3056	5.0	
Premalok® FP203	+10%+40%	3230, 3230, 3240, 3245		3054, 3056, 3056	5.0	
Premalok® Base Coat Series 292/295 - GMI 1040E	+10%+40-50%	3307, 3309, 3310, 3315, 3320, 3325		3054, 3056, 3056	5.0	
Premalok® Base Coat Series 292/295 - GMI 1040E	+10%+40-50%	3230, 3230, 3240, 3245		3054, 3056, 3056	5.0	
Premalok® Base Coat Series 292/295 - High Temp/Humidity	+30%+15%	3056		9015	5.0	
Premalok® 2K Diamond Midcoat MC 0001	See 9960 TDS for Mixing Recommendations	3307, 3309, 3310, 3315, 3320, 3325 or 3230, 3230, 3240, 3245		8580, 3363, 3365	5.0	+15% 9050
Premalok® 2K Transparent Red Midcoat MC 0002	See 9960 TDS for Mixing Recommendations	3307, 3309, 3310, 3315, 3320, 3325 or 3230, 3230, 3240, 3245		8580, 3363, 3365	5.0	+15% 9050
Premalok® 2K Transparent Blue Midcoat MC 0003	See 9960 TDS for Mixing Recommendations	3307, 3309, 3310, 3315, 3320, 3325 or 3230, 3230, 3240, 3245		8580, 3363, 3365	5.0	+15% 9050
Premalok® Transparent Midcoat 9100	1:1+3%	3240, 3245		3363, 3365	5.0	9045, 9049, 9056, 9057, 9058
Clearcoats: Must be used as a system with basecoats at under 5.0 lbs/gal (200 g/L) 2-stage or 5.2 lbs/gal (230 g/L) 3-stage for compliance						
Premalok® HS Clear Coat 8036	2:1	3307, 3309, 3310, 3315, 3320, 3325		8580, 3363, 3365, 9025	5.0	Compliant when used in a 2-stage coating system.
Premalok® HS Clear Coat 8036 Elastized	2:1+10-10%	3307, 3309, 3310, 3315, 3320, 3325		8580, 3363, 3365, 9025	5.0	Compliant when used in a 2-stage coating system; 9050 must be added before hardener.
Premalok® HS Clear Coat 8036	3:1+15-20%	3230, 3230, 3240, 3245		8580, 3363, 3365, 9025	5.0	Compliant when used with both 2 & 3-stage coating systems.
Premalok® HS Clear Coat 8036 Elastized	3:1+15-20%	3230, 3230, 3240, 3245		8580, 3363, 3365, 9025	5.0	Compliant when used with both 2 & 3-stage coating systems; 9050 must be added before hardener.
Premalok® HS Express Clear Coat 8046	2:1+5-5%	3307, 3309, 3310, 3315, 3320, 3325		8580, 3363, 3365, 9025	5.0	Compliant when used in a 2-stage coating system.
Premalok® HS Express Clear Coat 8046 Elastized	2:1+5-5%	3307, 3309, 3310, 3315, 3320, 3325		8580, 3363, 3365, 9025	5.0	Compliant when used in a 2-stage coating system; 9050 must be added before hardener.
Premalok® HS Express Clear Coat 8046	3:1+10%	3230, 3230, 3240, 3245		8580, 3363, 3365, 9025	5.0	Compliant when used in a 2-stage coating system.
Premalok® HS Express Clear Coat 8046 Elastized	3:1+10%	3230, 3230, 3240, 3245		8580, 3363, 3365, 9025	5.0	Compliant when used in a 2-stage coating system; 9050 must be added before hardener.
Premalok® Low VOC Clear Coat 8096	3:1+5-10%	3307, 3309, 3310, 3315, 3320, 3325		3363, 3365, 8580	5.0	Compliant when used with both 2 & 3-stage coating systems.
Premalok® Low VOC Clear Coat 8096	2.5:1 +20%	3230, 3230, 3240, 3245		3363, 3365, 8580	5.0	Compliant when used with both 2 & 3-stage coating systems.
Premalok® Low VOC Clear Coat 8096 Elastized	3:2 + 5-15%	3307, 3309, 3310, 3315, 3320, 3325		3363, 3365, 8580	5.0	Compliant when used with both 2 & 3-stage coating systems; 9050 must be added before hardener.
Premalok® Low VOC Clear Coat 8096 Elastized	2.5:1 +20-25%	3230, 3230, 3240, 3245		3363, 3365, 8580	5.0	Compliant when used with both 2 & 3-stage coating systems; 9050 must be added before hardener.
Premalok® MS Clear Coat 8180	2:1	3307, 3309, 3310, 3315, 3320, 3325		N/A	5.0	Compliant when used in a 2-stage coating system.
Premalok® MS Clear Coat 8180 Elastized	2:1	3307, 3309, 3310, 3315, 3320, 3325		N/A	5.0	Compliant when used in a 2-stage coating system.
Premalok® MS Clear Coat 8180	3:1+10%	3230, 3230, 3240, 3245		8580, 3363, 3365, 9025	5.0	Compliant when used in a 2-stage coating system.
Premalok® MS Clear Coat 8180 Elastized	3:1+10%	3230, 3230, 3240, 3245		8580, 3363, 3365, 9025	5.0	Compliant when used in a 2-stage coating system; 9050 must be added before hardener.
Premalok® HS Diamond Clear Coat 8400	3:1+10%	3240		8580, 3363, 3365	5.2	Compliant when used with both 2 & 3-stage coating systems.
Premalok® HS Diamond Clear Coat 8400 - AGAP	2:1+10-5%	3240		8580, 3363, 3365	5.0	Compliant when used with both 2 & 3-stage coating systems; 9050 must be added before hardener.
Premalok® HS Optimum Clear Coat 8600	3:1+10-5%	3230, 3230, 3240, 3245		8580, 3363, 3365, 9025	5.2	Compliant when used with both 2 & 3-stage coating systems.
Premalok® HS Optimum Clear Coat 8600 Elastized	3:1	3230, 3230, 3240, 3245		15-30% 9050	5.2	Compliant when used with both 2 & 3-stage coating systems; 9050 must be added before hardener.
Specialty Coatings VOC Limit = 7.0 lbs/gal (280 g/L)						
Adhesion Promoters						
Premalok® Transparent Surface 8550	3:1+20-30%	3307, 3309, 3310, 3315, 3320, 3325		8580, 3363, 3365	7.0	
Premalok® Transparent Surface 8550	4:1+1-30%	3230, 3230, 3240, 3245		8580, 3363, 3365	7.0	
Premalok® Vario Surface 8590	3:1+20-30%	3307, 3309, 3310, 3315, 3320, 3325		8580, 3363, 3365	7.0	
Premalok® Vario Surface 8590	5:1+30-40%	3230, 3230, 3240, 3245		8580, 3363, 3365	7.0	
Elastomeric Coatings						
Premalok® 1:1 Elastic Primer Surface 3300	1:1	3301		N/A	7.0	
Priema® Elastic Primer 3304	Ready to Use	N/A		N/A	7.0	
Priema® Elastic Primer 3304 (Aerosol)	Ready to Use	N/A		N/A	N/A	
Priema® Elastic Primer 4180	Ready to Use	N/A		N/A	7.0	
300™ Axalta Plastic Polyethylene Adhesion Promoter	Ready to Use	N/A		N/A	N/A	
300™ Axalta Plastic Polyethylene Adhesion Promoter	Ready to Use	N/A		N/A	7.0	
410A™ Axalta Plastic Polyethylene Adhesion Promoter Aerosol	Ready to Use	N/A		N/A	N/A	
300™ Axalta Plastic Primer Surface Black	1:1	331		N/A	7.0	
330™ Axalta Plastic Primer Surface Gray	1:1	331		N/A	7.0	
Premalok® Matte Clear Coat Additive 8001 with 8035 Flat Finish	4:1 w/8035	2:1 w/315, 3240		+4-5% 3363	7.0	
Premalok® Matte Clear Coat Additive 8002 with 8035						See TDS 8002 for Mixing Recommendations
Premalok® Semi-solids Elastic Clear Coat 8070	3:1+5-10%	3307, 3309, 3310, 3315, 3320, 3325				