

VOC CHART

For the State of Wisconsin
Automobile Refinishing Operations - Chapter NR 422 Part 095
See applicable counties in footer



Effective date: March 1, 2013

Revised: November 2024

Surface Preparation: VOC Limit = .42 lbs./gal. (50 g/L)							
CODE	DESCRIPTION	MIX RATIO	APPLIED VOC	CODE	DESCRIPTION	MIX RATIO	APPLIED VOC
107™	Low VOC Cleaner	RFU	0.2	2310S™	Plastic Cleaning Paste	RFU	0.1
130™	Cleaner	RFU	0.0	3949S™	Cleaner	RFU	0.4
V-3921S™	Cleaner	RFU	0.2	A-39X0S	Aerosol Cleaner *	RFU	see footer
A-2320S™	Plastic Cleaner (Aerosol)*	RFU	see footer	220™	Axalta Silicone Remover Low VOC	RFU	0.2
205A™	Axalta Silicone Remover (Aerosol)	RFU	see footer	265™	Axalta Plastic Cleaning Paste	RFU	0.2

Specialty Coatings: VOC Limit = 7.0 lbs./gal. (840 g/L) - Consult Technical Data Sheet for usage.							
CODE	DESCRIPTION	MIX RATIO	APPLIED VOC	CODE	DESCRIPTION	MIX RATIO	APPLIED VOC
19301S™	Clearcoat Blender	7.0		236XS	Matting Agent		7.0
A-300S™	Vinyl Fill In Can (Aerosol)	n/a		2370S™	Matted Clearcoat		7.0
222S™	Mid-Coat Adhesion Promoter	7.0		4531S™	Flattener		7.0
7601S™	Uniform Finish	7.0		69301S™	Basecoat Blender		7.0
2322S™	Plastics Adhesion Promoter	7.0		790™	Axalta Blender (Aerosol)		n/a
A-5099S™	1K Bumper & Trim (Aerosol)	n/a		2311S™	Blend Prep Paste		7.0
2330S™	Plastics Adhesion Promoter	7.0		A-2330S™	Polyolefin Adhesion Promoter (Aerosol)		n/a
234XS	Flexible Adhesion Sealer	7.0		JV Color	Vinyl Color System (JV Quality)		7.0
WB209X™	Basecoat Blender	7.0		SBL877S™	Basecoat Blender		7.0
43XA™	Axalta E-Coat Restore Aerosols	n/a		305™	Axalta Plastic Polyolefin Adhesion Promoter Low VOC		7.0
766A™	Axalta 1K Trim Black Satin (Aerosol)	n/a		310A™	Axalta Plastic Polyolefin Adhesion Promoter		n/a
715™	Axalta Sanding Paste	7.0		320™	Axalta Plastic Primer Surfacer Black		7.0
705™	Axalta 1K Fine Putty	7.0		330™	Axalta Plastic Primer Surfacer Gray		7.0

Pretreatments: VOC limit = 6.5 lbs./gal. (780 g/L)							
CODE	DESCRIPTION	REMARKS	MIX RATIO	HARDENER	REDUCER	MAX APPLIED VOC (LE)	
400A™	Axalta 1K Primer Surfacer Dark Gray (Aerosol)		RTS	-	-	n/a	
410A™	Axalta 1K Primer Surfacer Light Gray (Aerosol)		RTS	-	-	n/a	
420™	Axalta Etch Primer		1:1	421	-	6.5	
495™	Axalta Metal Pretreatment Wipes		RTU	-	-	6.5	
225S™	Aluminum Metal Cleaner - Step A		1:2	-	water	6.5	
226S™	Aluminum Conversion Coating - Step B		RTS	-	-	0.0	
22880S™	Low VOC Etch Primer		2:1	2280XS	-	6.5	
244S™	Pretreatment		RTS	-	-	6.5	
5717S™	Metal Conditioner		1:2	-	water	6.5	
5718S™	Conversion Coating		RTS	-	-	0.0	
615S™	Self-Etching Primer		1:1	-	61XS / 620S™	6.5	
A-411XS	Etch Primer (Aerosol)		RTS	-	-	n/a	
CF-5717S™	Metal Conditioner		1:2	-	water	6.5	
PS4000™	Pretreatment Wipes		RTU	-	-	6.5	

Primer / Primer-Surfacers: VOC Limit = 4.8 lbs./gal. (580 g/L)							
Other additives may be used. Consult technical data sheet for usage requirements.							
CODE	DESCRIPTION	REMARKS	MIX RATIO	HARDENER	REDUCER	MAX APPLIED VOC (LE)	
131S™	Primer Surfacer		1:1	32030S™	-	4.8	
33430S™	Primer Filler		4:1:1	1430XS	14375S™	4.8	
3600XS	Primer		1:1	36305S™	-	4.8	
4004S™	Primer-Filler		4:1	4075S™ / 4095S™	-	4.8	
770XS	Primer Filler		4:1	77X5S	-	4.8	
460A™	Axalta Epoxy 2K		RTS	-	-	n/a	
A-3130S™	UVA Primer-Surfacer (Aerosol)		RTS	-	-	n/a	
A-3130S™	UVA Primer-Surfacer (Aerosol)		RTS	-	-	n/a	
A-42X0S	Primer (Aerosol)		RTS	-	-	n/a	
LE3004S™	Primer Surfacer		1:1	NR30X5S	-	4.8	
LE3130S™	UV Primer Surfacer		RTS	-	-	4.8	
LE340XS	Primer Filler		2:1	LE11X5S	-	4.8	
LE350XS	Primer Filler		5:1:1	LE100XS	LE10X5S	4.8	

Primer-Sealer VOC Limit = 4.6 lbs./gal. (550 g/L)							
Other additives may be used. Consult technical data sheet for usage requirements.							
CODE	DESCRIPTION	REMARKS	MIX RATIO	HARDENER	REDUCER	MAX APPLIED VOC (LE)	
25X0S / 2580CR™	Direct to Metal Primer		2:1	250XS	-	4.6	
424X0S	Sealer		4:1:1.5	12305S™	424X5S	4.6	
444X0S	Premier Sealer		4:1:1	14305S™	444X5S	4.6	
77X0S	Sealer		4:1	77X5S	-	4.6	
LE27X0S	Primer Sealer		2:1:0-10%	LE2705S™	LE1075S™	4.6	
LE30X0S	Primer Sealer		3:1	NR30X5S	-	4.6	
LE32X0S	Waterborne 2K Sealer		1:5%	WB2075™	-	4.6	
LE35X0S	Primer Sealer		5:1:1	LE100XS	LE12X5S	4.6	
V-29X0S	Primer Sealer		2:1	V-290XS	-	4.6	

Single Stage Topcoats: VOC Limit = 5.0 lbs./gal. (600 g/L)							
Other additives may be used. Consult technical data sheet for usage requirements.							
CODE	DESCRIPTION	REMARKS	MIX RATIO	HARDENER	REDUCER	MAX APPLIED VOC (LE)	
N Quality	ChromaPremier® Single Stage Topcoat	¥ - See footer	3:1	1430XS	-	5.0	

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)	
CP Quality	Cromax® Pro Basecoat		1:10%-30%	-	WB2040™ / WB2045™	5.0	
B Quality	Cromax® Mosaic™ Basecoat		1:2	-	SBL66XXS	5.0	
K Quality	ChromaBase® Basecoat		1:1:6.25%	71X5S	1430XS / 77X5S	5.0	
F Quality	ChromaPremier® Basecoat		1:1:6.25%	71X5S	1430XS / 77X5S	5.0	
FX Quality	ChromaLusion® Basecoat		1:1:6.25%	71X5S	12305S™	5.0	
XP Quality	Cromax® XP Basecoat		2:1:6%	XP10XX	1430XS / 77X5S	5.0	
A-7160S™	SprayBase™ Fill In Can (Aerosol)	⚠ - See footer	-	-	-	See Remarks	
A-SBL6627S™	Mosaic™ Fill In Can (Aerosol)	⚠ - See footer	-	-	-	See Remarks	
EZ Quality	Cromax® EZ Basecoat		1:20%	-	EZ240™	5.0	

Multi-Stage Topcoats: VOC Limit = 5.0 lbs./gal. (600 g/L)							
Please consult Technical Data Sheet for compliant basecoat recommendation along with any additional additives that may be used.							
CODE	DESCRIPTION	REMARKS	MIX RATIO	HARDENER	REDUCER	MAX APPLIED VOC (LE)	
72200S™	Clearcoat	Compliant with basecoat at/under 6.3 VOC	3:1:30%	1230XS	123X5S	5.0	
72500S™	Clearcoat	Compliant with basecoat at/under 6.3 VOC	2:1:10%	1230XS/1430XS	123X5S/143X5S	5.0	
7400S™	Clearcoat	Compliant with basecoat at/under 6.3 VOC	4:1:1	7405S™	74X5S / 14375S™	5.0	
74500S™	Clearcoat	Compliant with basecoat at/under 6.3 VOC	2:1:1	1430XS	143X5S	5.0	
74700S™	Clearcoat	Compliant with basecoat at/under 6.3 VOC	2:1:1	1430XS	143X5S	5.0	
7480S™	Clearcoat	Compliant with basecoat at/under 6.3 VOC	4:1	1230XS / 79X5S / G2-450XS / 77X5S	-	5.0	
7900S™	Clearcoat	Compliant with basecoat at/under 6.3 VOC	3:1	79X5S	-	5.0	
A-7480S™	Clearcoat (Aerosol)	Exempt: Non-refillable aerosol products	RTS	-	-	n/a	
712A™	Sprayout Clearcoat (Aerosol)	Exempt: Non-refillable aerosol products	RTS	-	-	n/a	
G2-4X00S	Clearcoat	Compliant with basecoat at/under 6.3 VOC	3:1:1	G2-450XS	123X5S	5.0	
G2-7779S™	Clearcoat	Compliant with basecoat at/under 6.3 VOC	4:1	77X5S	-	5.0	
HC-7776S™	Clearcoat	Compliant with basecoat at/under 6.3 VOC	4:1	77X5S	-	5.0	
LE5100S™	Clearcoat	Compliant with basecoat at/under 6.3 VOC	2:1	LE11X5S	-	5.0	
LE5400S™	Clearcoat	Compliant with basecoat at/under 6.3 VOC	4:1	LE11X0S	-	5.0	
LE5600S™	Clearcoat	Compliant with basecoat at/under 6.3 VOC	4:1:1	LE5605S™	LE56X5S	5.0	
LE8300S™	Clearcoat	Compliant with basecoat at/under 6.3 VOC	3:1:1	LE100XS	LE10X5S	5.0	
LE8700S™	Clearcoat	Compliant with basecoat at/under 6.3 VOC	3:1	LE100XS	-	5.0	
LE8800S™	Clearcoat	Compliant with basecoat at/under 6.3 VOC	2:1:20%	LE100XS	LE880XS	5.0	

Three-Stage Topcoats: VOC Limit = 5.2 lbs./gal. (630 g/L)							
Must be used with specified Clearcoats or Basecoat for compliance, please consult technical data sheet. Additional additives may be used.							
CODE	DESCRIPTION	REMARKS	MIX RATIO	HARDENER	REDUCER	MAX APPLIED VOC (LE)	
1000XS	Midcoat		3:1:30%	1430XS	143X5S	5.2	
11000S™	Midcoat Base		1:1:3%	1430XS	110X5S	5.2	
72500S™	Clearcoat		2:1:10%	1230XS	123X5S	5.2	
F Quality	ChromaPremier® Basecoat		1:1:6.25%	71X5S	1430XS / 77X5S	5.2	
FX Quality	ChromaLusion® Basecoat		1:1:6.25%	71X5S	12305S™	5.2	
K Quality	ChromaBase® Basecoat		1:1:6.25%	71X5S	1430XS / 77X5S	5.2	
XP Quality	Cromax® XP Basecoat		2:1:6%	XP10XX	1430XS / 77X5S	5.2	

Limits apply to refinishing operations performed in Kenosha, Kewaunee, Manitowoc, Milwaukee, Ozaukee, Racine, Sheboygan, Washington and Waukesha Counties.
* VOC limit does not apply to cleaning with non-refillable aerosol products if 160 fluid ounces or less is used per day per facility.
All VOC (LE) values listed are Maximum Ready-to-Spray in pounds per gallon
⚠ - Please see Technical Data Sheet for usage and mixing recommendation; Exempt, non-refillable aerosol products.
Hardener = Activator
X = 1, 2, 3, 4, 5, 6, 7, 8, 9
¥ - Does not include 14301S™ activator