

VOC CHART

For the State of Illinois - Motor Vehicle Refinishing

Title 35 BIC, Parts 218 and 219 - See note in footer

Effective date: May 1995

Revised: Dec 2020



Surface Preparation: VOC Limit = 1.4 lbs./gal. (170 g/L)							
CODE	DESCRIPTION	MIX RATIO	APPLIED VOC	CODE	DESCRIPTION	MIX RATIO	APPLIED VOC
107™	Low VOC Cleaner	RFU	0.2	3909S™	Cleaner	RFU	0.5
130™	Cleaner	RFU	0.0	3949S™	Cleaner	RFU	0.4
V-3921S™	Cleaner	RFU	0.2	210™	Silicone Remover Water	RFU	1.4
				220™	Silicone Remover Low VOC	RFU	0.2

Plastic Surface Preparation: VOC Limit = 6.5 lbs./gal. (780 g/L) - Plastic parts only!							
CODE	DESCRIPTION	MIX RATIO	APPLIED VOC	CODE	DESCRIPTION	MIX RATIO	APPLIED VOC
A-3970S™	Aerosol Cleaner	RFU	6.4	2320S™	Plastic Cleaner	RFU	6.5
3901S™	Final Klean	RFU	6.1	3919S™	Cleaner	RFU	6.5
3900S™	Cleaner	RFU	6.5	106™	Cleaner	RFU	4.4
105™	Thinner	RFU	5.4	108™	Low Hap Cleaner	RFU	3.9
2319S™	Plastic Preparation	RFU	5.5	231XS	Plastic Paste	RFU	0.5
A-2320S™	Plastic Cleaner (Aerosol)	RFU	5.8	139™	Bug & Tar Remover	RFU	2.9
A-3990S™	Surface Cleaner High Temperature (aerosol)	RFU	6.4	205A™	Axalta Silicone Remover Spray	RFU	6.2

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™	Blender (Aerosol)		n/a
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
A-5099S™	1K Bumper & Trim (Aerosol)		n/a	43XA™	Axalta E-Coat Restore Aerosols		n/a
305™	Axalta Plastic Polyolefin Adhesion Promoter Low VOC		7.0	715™	Axalta Sanding Paste		7.0
310A™	Axalta Plastic Polyolefin Adhesion Promoter		n/a	705™	Axalta 1K Fine Putty		7.0
320™	Axalta Plastic Primer Surfacer Black		7.0	766A™	Axalta 1K Trim Black Satin		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)							
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	
A-3130S™	UVA Primer-Surfacer (Aerosol)		RTS	-	-	n/a	
A-42X0S	Primer (Aerosol)		RTS	-	-	n/a	
460A™	Axalta Epoxy 2K		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)							
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)							
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)							
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	-	SBL66XS	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	
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)							
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	
712A™	Axalta 1K Sprayout Clearcoat	Exempt: Non-refillable aerosol products	RTS	-	-	n/a	
A-7480S™	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	

Three-Stage Topcoats: VOC Limit = 5.2 lbs./gal. (630 g/L)							
CODE	DESCRIPTION	REMARKS	MIX RATIO	HARDENER	REDUCER	MAX APPLIED VOC (LE)	
1000XS	Midcoat		3:1:30%	1430XS	143X5S	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	

Title 35 Subtitle B, Chapter I, Subchapter c: Emissions Standards and Limitations for Stationary Sources - Parts 218 Chicago Area & 219 Metro East Area
Chicago Area : Cook, DuPage, Kane, Lake, McHenry & Will Counties; Aux Sable, Goose Lake and Oswego Townships
Metro East Area : Madison, Monroe, and St.Clair Counties
 ¥ - Does not include 14301S™ activator
 ⚠ - Please see Technical Data Sheet for usage and mixing recommendation; Exempt, non-refillable aerosol products.
 Hardener = Activator
 All VOC (LE) values listed are Maximum Ready-to-Spray in pounds per gallon
 X = 1, 2, 3, 4, 5, 6, 7, 8, 9