

Spies Hecker® VOC Compliance Chart



Tennessee Rule 1200-03-18-.45 Commercial Motor Vehicle and Mobile Equipment Refinishing Operations
 Group 2 Vehicles - see footer below
 Effective: 3/1/2013

Description	Compliant Rules	Applied VOC lbs/gal	Remarks
Surface Preparation VOC Limit = 1.7 lbs/gal (208 g/L)			
107™ Axalta Low VOC Gun & Equipment Cleaner		0.2	
210™ Axalta Silicone Remover Water		1.4	
220™ Axalta Silicone Remover Low VOC		0.2	
Permahyd® Plastic Cleaning Paste 7081	Tennessee	0.1	
265™ Axalta Plastic Cleaning Paste		0.1	
Permahyd® Silicone Remover 7085		1.6	
Permahyd® Silicone Remover 7086		1.4	
Permahyd® Silicone Remover 7086		0.2	

Description	Mix Ratio	Hardener	Reducer/Additive	Addl Product	Max Applied VOC (LE) lbs/gal	Remarks
Pretreatment VOC Limit = 6.5 lbs/gal (780 g/L)						
Priomat® Primer 3255	+50%	N/A	8560, 3363, 3365	N/A	6.5	
Priomat® Primer 3255 (Aerosol)	Ready to Use	N/A	N/A	N/A	6.5	
Priomat® Wash Primer 4075	1:1	4076	N/A	N/A	6.5	
Priomat® 1K Primer Surfacer 4085 (Aerosol)	Ready to Use	N/A	N/A	N/A	6.5	
Priomat® 1K Primer Surfacer 4085	+50%	N/A	8560, 3363, 3365	N/A	6.5	
Axalta® Pretreatment Wipes P5400™	Ready to Use	N/A	N/A	N/A	6.5	
420™ Axalta Etch Primer	1:1	421	N/A	N/A	6.5	
410A™ Axalta 1K Primer Surfacer Light Gray	Ready to Use	N/A	N/A	N/A	6.5	
400A™ Axalta 1K Primer Surfacer Dark Gray	Ready to Use	N/A	N/A	N/A	6.5	
495™ Axalta Metal Pretreatment Wipes	Ready to Use	N/A	N/A	N/A	6.5	

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	2.8	
Permasolid® EP Primer Surfacer 4502	2:1+0-10%	4503	3394	N/A	2.8	
460A™ Axalta Epoxy 2K	Ready to Use	Included	N/A	N/A	2.8	Aerosol
Permacron® VHS Surfacer 5150	1.5:1+0-3%	3192, 3194, 3196	3392, 3394	N/A	2.8	
Permacron® VHS Surfacer 5150	2:1+10-20%	3170	3369, 3370, 3371	N/A	2.8	
Permasolid® 2.1 Surfacer 5155	4:1+20-30%	3193, 3195, 3197, 3199	3369, 3370, 3371	N/A	2.8	
Permasolid® 2.1 Surfacer 5155 Elasticized	2:1+20-30%	3193, 3195, 3197, 3199	3369, 3370, 3371	+30% 9050	2.8	9050 must be added before hardener.
Permasolid® 2.1 Surfacer 5157	4:1+10-20%	3192, 3194, 3196	3392, 3392, 3394, 5409, 5410	N/A	2.8	
Permasolid® 2.1 Surfacer 5157 Elasticized	4:1+10-20%	3192, 3194, 3196	3392, 3392, 3394, 5409, 5410	+15% 9050	2.8	9050 must be added before hardener.
Permasolid® 1K UV Starlight Primer Surfacer 9002 (Aerosol)	Ready to Use	N/A	N/A	N/A	2.8	Aerosol
Permasolid® 1K UV Starlight Primer Surfacer 9002	Ready to Use	N/A	N/A	N/A	2.8	Non-Aerosol version

Primer-Sealers VOC Limit = 3.5 lbs/gal (420 g/L)						
Permasolid® 2.1 Surfacer 5155	2:1+30%	3193, 3195, 3197, 3199	9070	+10-20% 3369, 3370, 3371	3.5	
Permasolid® 2.1 Surfacer 5155 Elasticized	2:1+30%	3193, 3195, 3197, 3199	9070	+10-20% 3369, 3370, 3371 +15-30% 9050	3.5	
Permasolid® Spectro Surfacer 5400	2:1+20-30%	3193, 3195, 3197, 3199	9070	N/A	3.5	
Permasolid® Spectro Surfacer 5400 Elasticized	2:1+20-30%	3193, 3195, 3197, 3199	9070	+30% 9050	3.5	9050 must be added before hardener.
Permasolid® Spectro Sealer 5450	4:1+30%	3192, 3194, 3196	5409, 5410	N/A	3.5	
Permasolid® Spectro Sealer 5450 Elasticized	3:1+30%	3192, 3194, 3196	5409, 5410	+15-30% 9050	3.5	9050 must be added before hardener.
Permahyd® 2K Sealer 5650	1:5%	3080	N/A	N/A	3.5	

Single Stage Topcoats VOC Limit = 5.0 lbs/gal (600 g/L)						
Permacron® Acrylic Urethane Series 257	3:1+5-10%	3307, 3309, 3310, 3315, 3320, 3325	8560, 3363, 3365	N/A	5.0	
Permacron® Automotive Topcoat Series 257 FP-1004 Rally Matt Black	4:1+25%	3220, 3230, 3240, 3245	8560, 3363, 3365	+15% 9050	5.0	
Permacron® Automotive Topcoat 257 Series FP-1002 Blue Black	4:1+25%	3220, 3230, 3240, 3245	8560, 3363, 3365	+15% 9050	5.0	
Permacron® Automotive Top Coat FP 1005 Warm Gray VV604N	3:1	3307, 3309, 3310, 3315, 3320, 3325	8560, 3363, 3365, 3394, 5409, 5410	+0-5% 8092, 8096	5.0	
Permacron® Automotive Top Coat FP 1005 Warm Gray VV604N	4:1+10%	3220, 3230, 3240, 3245	8560, 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 system with specified Clearcoats

Basecoats: Must be used with specific clearcoats for compliance						
Permahyd® Hi-TEC Base Coat	+10-30%	N/A	6050, 6051, 6052, 6053	N/A	3.5	
Permahyd® Hi-TEC Base Coat w/ Hardeners	+5-10% +10-30%	3080	6050, 6051, 6052, 6053	N/A	3.5	
Permahyd® Base Coat Series 280/285	+0-15%	N/A	6000	N/A	3.5	
Permahyd® Base Coat Series 280/285	+0-10%	N/A	6002	N/A	3.5	
Permahyd® Base Coat Series 280/285	+5-10%	9007	+10-20% 6000 or 0-10% 6002	N/A	3.5	
Permasolid® 2K Diamond Midcoat MC 0001	2:1+10-15%	3192, 3194, 3196	3392, 3394	+15% 9050	3.5	
Permasolid® 2K Transparent Red Midcoat MC 0002	2:1+10-15%	3192, 3194, 3196	3392, 3394	+15% 9050	3.5	
Permasolid® 2K Transparent Blue Midcoat MC 0003	2:1+10-15%	3192, 3194, 3196	3392, 3394	+15% 9050	3.5	
Permacron® Transparent Midcoat 5100	1:1+3%	3194, 3196	3394	9045, 9048, 9056, 9057, 9058	3.5	

Clearcoats: Must be used as a system with specified basecoats						
Permasolid® Air Dry Clear Coat 8084	4:1 +20%	3192, 3194, 3196	3392, 3394	N/A	3.5	
Permacron® Air Dry Clear Coat 8094 Elasticized	4:1 +20%	3192, 3194, 3196	3392, 3394	+10% 9050	3.5	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	3.5	
Permacron® 2.1 Clear Coat 8095 Elasticized	2:1+5-10%	3193, 3195, 3197, 3199	3369, 3370, 3371	+15-30% 9050	3.5	9050 must be added before hardener.
Permasolid® Low VOC Clear Coat 8096	2:1+10-15%	3192, 3194, 3196	3392, 3394	N/A	3.5	
Permasolid® Low VOC Clear Coat 8096 Elasticized	2:1+10-15%	3192, 3194, 3196	3392, 3394	+15% 9050	3.5	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	3.5	
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	3.5	
Permacron® 2.1 Clear Coat 8097	2:1+0-10%	3193, 3195, 3197, 3199	3369, 3370, 3371	N/A	3.5	
Permacron® 2.1 Clear Coat 8097 - ASAP	1.5:1+5%	3193, 3195, 3197, 3199	9056	+5% 3369, 3370, 3371	3.5	
Permacron® 2.1 Clear Coat 8097 Elasticized	2:1+10-10%	3193, 3195, 3197, 3199	3369, 3370, 3371	+15-30% 9050	3.5	9050 must be added before hardener.
Permacron® Matte Clear Coat Additive 8091 with 8095/8097 Flat Finish	4:1 w/8095/8097	2:1 w/3195, 3197	+0-5% 3371	N/A	3.5	
Permacron® Matte Clear Coat Additive 8091 with 8095/8097 Satin Finish	3:1 w/8095/8097	2:1 w/3195, 3197	N/A	N/A	3.5	
Permasolid® Low VOC Clear Coat 8098	2:1+6%	3192, 3194, 3196	3392, 3394	N/A	3.5	
Permasolid® Low VOC Clear Coat 8098 Elasticized	2:1+10%	3192, 3194, 3196	3392, 3394	+15% 9050	3.5	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	3.5	
Permasolid® Low VOC Clear Coat 8098 w/ 8092 Matte Clear Coat Additive	See TDS 8092	3192, 3194, 3196	3392, 3394	N/A	3.5	
Permacron® Matte Clear Coat Additive 8091 with 8098 Flat Finish	6:1 w/8098	2:1 w/3194, 3196	+20% 3392, 3394	N/A	3.5	
Permacron® Matte Clear Coat Additive 8091 with 8098 Satin Finish	5:1 w/8098	2:1 w/3194, 3196	+20% 3392, 3394	N/A	3.5	

Specialty Coatings VOC Limit = 7.0 lbs/gal (840 g/L) - shall not exceed 10% of all coatings applied on a weekly basis.

Adhesion Promoters						
Permacron® Transparent Surfacer 8550	3:1+20-30%	3307, 3309, 3310, 3315, 3320, 3325	8560, 3363, 3365	N/A	7.0	
Permacron® Transparent Surfacer 8550	4:1+35%	3220, 3230, 3240, 3245	8560, 3363, 3365	N/A	7.0	
Permasolid® Vario Surfacer 8590	3:1+20-30%	3307, 3309, 3310, 3315, 3320, 3325	8560, 3363, 3365	N/A	7.0	
Permasolid® Vario Surfacer 8590	5:1+30-40%	3220, 3230, 3240, 3245	8560, 3363, 3365	N/A	7.0	

Elastomeric Coatings						
Permacron® 1:1 Elastic Primer Surfacer 3300	1:1	3301	N/A	N/A	7.0	
Priomat® Elastic Primer 3304	Ready to Use	N/A	N/A	N/A	7.0	
Priomat® Elastic Primer 3304 (Aerosol)	Ready to Use	N/A	N/A	N/A	7.0	
Priomat® Elastic Primer 4190	Ready to Use	N/A	N/A	N/A	7.0	
300™ Axalta Plastic Polyolefin Adhesion Promoter	Ready to Use	N/A	N/A	N/A	7.0	
305™ Axalta Plastic Polyolefin Adhesion Promoter	Ready to Use	N/A	N/A	N/A	7.0	
310A™ Axalta Plastic Polyolefin Adhesion Promoter Aerosol	Ready to Use	N/A	N/A	N/A	7.0	
320™ Axalta Plastic Primer Surfacer Black	1:1	331	N/A	N/A	7.0	
330™ Axalta Plastic Primer Surfacer Gray	1:1	331	N/A	N/A	7.0	
Permacron® Matte Clear Coat Additive 8091 with 8035 Flat Finish	4:1 w/8035	2:1 w/3315, 3320	+0-5% 3363	N/A	7.0	
Permasolid® Matte Clear Coat Additive 8092 with 8035				See TDS 8092 for Mixing Recommendations	7.0	
Permacron® Semi-gloss Elastic Clear Coat 8070	3:1+5-10%	3307, 3309, 3310, 3315, 3320, 3325	8560, 3363, 3365	N/A	7.0	
Permacron® Semi-gloss Elastic Clear Coat 8070	4:1+20%	3220, 3230, 3240, 3245	8560, 3363, 3365	N/A	7.0	
Permacron® FP1004 Rally Matte Black	3:1+5-10%	3307, 3309, 3310, 3315, 3320, 3325	8560, 3363, 3365	N/A	7.0	

Flishey Eliminator						
Permacron® Antisilicone 8510	25ml/1 w/RTS 2k Clear Coat	N/A	N/A	N/A	7.0	
Uniform Finish Coatings						
Permacron® Speed Blender 1036	4:1 w/Permacron® or Permasolid® Clear Coats (RTS)				7.0	
Permacron® Base Coat Blender 8560	1:2 w/293/295 RTS				7.0	
Permahyd® Blend-in Additive 9005	1:1 w/Permahyd® Base Coat Series 280/285 (RTS)				7.0	
Permahyd® Blend-in Additive 9017	1:2 w/Permahyd® Base Coat Series 280/285 (RTS)				7.0	
Permahyd® Blend-in Additive 9017	+50%	8016	N/A	N/A	7.0	
Permahyd® Hi-TEC Blend-in Additive 1050 or 1051	+10%	N/A	6050, 6052	N/A	7.0	
Permahyd® Hi-TEC Blend-in Additive 1050	+5%	N/A	1053	N/A	7.0	
790™ Axalta Blender (Aerosol)	Ready to Use	N/A	N/A	N/A	7.0	

Other Products						
Permasolid® Additive Maroon 9056		See 998.0 TDS for compliant mixing recommendations			5.0	
Permasolid® Additive Magenta 9057		See 998.0 TDS for compliant mixing recommendations			5.0	
Permasolid® Additive Violet 9058		See 998.0 TDS for compliant mixing recommendations			5.0	
Permasolid® Additive Deep Red 9049		See 998.0 TDS for compliant mixing recommendations			5.0	
Permasolid® Additive Blue 9045		See 998.0 TDS for compliant mixing recommendations			5.0	
Permahyd® Sanding Paste 1120	Ready to Use	N/A	N/A	N/A	7.0	
Axalta E-Coat Restore Aerosols	Ready to Use	N/A	N/A	N/A	7.0	See TDS for compliance and usage instructions.
766A™ Axalta 1K Trim Black Satin	Ready to Use	N/A	N/A	N/A	7.0	Aerosol
Redcar® Spray Polyester 3526	+5%	9520	+5% 7690 or +2.5% 9010	N/A	7.0	
Permacron® Fine Putty 7715	Ready to Use	N/A	N/A	N/A	7.0	

Group 2 Vehicles: Buses and mobile equipment (any equipment which could be drawn or driven on a roadway). For complete product usage and mixing recommendations, see the product specific technical data sheet located on www.spieshecker.com.
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