



Description		Compliant Rule(s)			Applied VOC g/L	Remarks
Surface Preparation VOC Limit = 0.6 lbs/gal (72 g/L)						
107™ Axalta Low VOC Gun & Equipment Cleaner					25	
220™ Axalta Silicone Remover Low VOC					0	
130™ Axalta Cleaner		Glenn			25	
Surface Preparation (Plastic Parts Only) VOC Limit = 6.5 lbs/gal (780 g/L)						
Pernahyd® Plastic Cleaning Paste 7081					13	
265™ Axalta Plastic Cleaning Paste					13	
200™ Axalta Silicone Remover Slow (in a spray bottle)					750	Must be applied with a spray bottle for compliance.
Pernaman® Silicone Remover 7010 Slow (in a spray bottle)					750	Must be applied with a spray bottle for compliance.
725™ Axalta Blue & Tar Remover (in a spray bottle)		Glenn			347	Must be applied with a spray bottle for compliance.
139™ Axalta Blue & Tar Remover (in a spray bottle)					347	Must be applied with a spray bottle for compliance.
210™ Axalta Silicone Remover Water (in a spray bottle)					164	Must be applied with a spray bottle for compliance.
Pernahyd® Silicone Remover 7085 (in a spray bottle)					188	Must be applied with a spray bottle for compliance.
Pernahyd® Silicone Remover 7086 (in a spray bottle)					165	Must be applied with a spray bottle for compliance.
Description	Mix Ratio	Hardener	Reducer/Additive	Addtl Product	Max Applied VOC (LE) g/L	Remarks
Pretreatment VOC Limit = 6.5 lbs/gal (780 g/L)						
Priomat® Primer 3255 (Aerosol)	Ready to Use	N/A	N/A	N/A	N/A	
Priomat® Primer 3255	+50%	N/A	8580, 3363, 3365	N/A	780	
425™ Axalta Etch Primer Low VOC	2:1	426	N/A	N/A	780	
Priomat® 5.5 Wash Primer 4055	2:1	4056	N/A	N/A	780	
Priomat® Wash Primer 4075	1:1	4076	N/A	N/A	780	
420™ Axalta Etch Primer	1:1	421	N/A	N/A	780	
Priomat® 1K Primer Surface 4085	+50%	N/A	8580, 3363, 3365	N/A	780	
Priomat® 1K Primer Surface 4085 (Aerosol)	Ready to Use	N/A	N/A	N/A	N/A	
410A™ Axalta 1K Primer Surface Light Gray	Aerosol	N/A	N/A	N/A	N/A	
410A™ Axalta 1K Primer Surface Dark Gray	Aerosol	N/A	N/A	N/A	N/A	
485™ 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	
Primers/Primer Surfaces VOC Limit = 2.8 lbs/gal (340 g/L)						
Pernahyd® 1K Productive Primer Surface 4100	+5-10%	N/A	6000	N/A	340	
Permasolid® EP Primer Surface 4502	2:1+0-10%	4503	3394	N/A	340	
460A™ Axalta Epoxy 2K	Ready to Use	included	N/A	N/A	N/A	
Permacron® VHS Surface 5150	1.5:1+0-5%	3192, 3194, 3196	3392, 3394	N/A	340	
Permacron® VHS Surface 5150	2:1+10-20%	3170	3369, 3370, 3371	N/A	340	
Permasolid® 2.1 Surface 5155	4:1+20-30%	3193, 3195, 3197, 3199	3369, 3370, 3371	N/A	340	
Permasolid® 2.1 Surface 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 Surface 5157	5:1+10-20%	3192, 3194, 3196	3392, 3392, 3394, 5409, 5410	N/A	340	
Permasolid® 2.1 Surface 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 Startstop Primer Surface 9002 (Aerosol)	Ready to Use	N/A	N/A	N/A	N/A	Aerosol
Permasolid® 1K UV Startstop Primer Surface 9002	Ready to Use	N/A	N/A	N/A	340	Non-aerosol version
Primer-Sealers VOC Limit = 2.8 lbs/gal (340 g/L)						
Permasolid® 2.1 Surface 5155	2:1+30%	3193, 3195, 3197, 3199	9070	+10-20% 3369, 3370, 3371	340	
Permasolid® 2.1 Surface 5155 Elasticized	2:1+30%	3193, 3195, 3197, 3199	9070	+10-20% 3369, 3370, 3371 +15-30% 9050	340	9050 must be added before hardener.
Permasolid® Sococto Sealer 5450	4:1+30%	3192, 3194, 3196	5409, 5410	N/A	340	
Permasolid® Sococto Sealer 5450 Elasticized	3:1+30%	3192, 3194, 3196	5409, 5410	+15-30% 9050	340	9050 must be added before hardener.
Pernahyd® 2K Sealer 5650	1:5%	3080	N/A	N/A	340	
Single Stage Topcoat VOC Limit = 5.0 lbs/gal (600 g/L) Color Match Required; 3.5 lbs/gal (420 g/L) No color match required. Additional additives may be used. Consult technical data sheet for usage and compliance.						
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	3.0:1	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	
Multistage Topcoat VOC Limit = 5.0 lbs/gal (600 g/L) COLOR MATCH REQUIRED; 3.5 lbs/gal (420 g/L) COLOR MATCH NOT REQUIRED - applied as a 2-stage or 3-stage system						
Basecoats: Must be used with specific clearcoats for compliance - check TDS for usage						
Pernahyd® Hi-TEC Base Coat	+10-30%	N/A	6050, 6051, 6052, 6053	N/A	600	
Pernahyd® Hi-TEC Base Coat w/ Hardeners	+5-10% +10-30%	3080	6050, 6051, 6052, 6053	N/A	600	
Pernahyd® Base Coat Series 280/285	+0-15%	N/A	6000	N/A	600	
Pernahyd® Base Coat Series 280/285	+0-10%	N/A	6002	N/A	600	
Pernahyd® Base Coat Series 280/285	+5-10%	9007	+10-20% 6000 or 0-10% 6002	N/A	600	
Permacron® Base Coat Series 293/295	+40-50%	N/A	3054, 3055, 3056	N/A	600	
Permacron® Base Coat Series 293/295 - GMW 15406	+10% +40-50%	3220, 3230, 3240, 3245	3054, 3055, 3056	N/A	600	
Permacron® Base Coat Series 293/295 - GMW 15406	+10% +40-50%	3192, 3194, 3196	3054, 3055, 3056	N/A	600	
Permasolid® FP2003	+15% +40-50%	3193, 3195, 3197, 3199	3055, 3054, 3056	N/A	600	
Permasolid® 2K Diamond Midcoat, MC 0001	2:1+10-15%	3192, 3194, 3196	3392, 3394	+15% 9050	600	
Permasolid® 2K Transparent Red Midcoat, MC 0002	2:1+10-15%	3192, 3194, 3196	3392, 3394	+15% 9050	600	
Permasolid® 2K Transparent Blue Midcoat, MC 0003	2:1+10-15%	3192, 3194, 3196	3392, 3394	+15% 9050	600	
Permasolid® Transparent Midcoat 9100	1:1+3%	3194, 3196	3394	9045, 9049, 9056, 9057	600	
Clearcoats: Must be used as a system with specified basecoats for compliance - check TDS for usage						
Spies Hecker® HS Speed Clear Coat 8820	2:1	3251, 3254, 3250, 3252, 3257	N/A	N/A	600	Compliant when used with both 2 & 3-stage coating systems.
Permasolid® HS Clear Coat 8035	2:1+5%	3193, 3195, 3197, 3199	3369, 3370, 3371, 9025	N/A	600	Not compliant if used in a 3-stage coating system with 293/295 basecoat.
Permasolid® HS Clear Coat 8035 Elasticized	2:1+5%	3193, 3195, 3197, 3199	3369, 3370, 3371, 9025	+15-30% 9050	600	9050 must be added before hardener. Not compliant if used in a 3-stage coating system with 293/295 basecoat.
Permasolid® Air Dry Clear Coat 8094	4:1 +20%	3192, 3194, 3196	3392, 3394	N/A	600	
Permasolid® Air Dry Clear Coat 8094 Elasticized	4:1 +20%	3192, 3194, 3196	3392, 3394	+10% 9050	600	9050 must be added before hardener.
Permasolid® Low VOC Clear Coat 8096	2:1+10-15%	3192, 3194, 3196	3392, 3394	N/A	600	
Permasolid® Low VOC Clear Coat 8096 Elasticized	2:1+10-15%	3192, 3194, 3196	3392, 3394	+15% 9050	600	9050 must be added before hardener.
Permasolid® Low VOC Clear Coat 8098	2:1+5%	3192, 3194, 3196	3392, 3394	N/A	600	
Permasolid® Low VOC Clear Coat 8098 Elasticized	2:1+10%	3192, 3194, 3196	3392, 3394	+15% 9050	600	9050 must be added before hardener.
Permasolid® Low VOC Clear Coat 8098 w/ 9050	See TDS 8098	3192, 3194, 3196	3392, 3392, 3394	N/A	600	
Permasolid® HS Diamond Clear Coat 8450	3:1+0-5%	3240	8580, 3363, 3365	N/A	600	Only compliant if used in a 2-stage coating system with 293/295 basecoat or with a 2 or 3-stage coating system and Pernahyd Basecoat or Pernahyd Hi-TEC Basecoat.
Permasolid® HS Diamond Clear Coat 8450	2:1	3193, 3195, 3197, 3199	N/A	N/A	600	Only compliant if used in a 2-stage coating system with 293/295 basecoat or with a 2 or 3-stage coating system and Pernahyd Basecoat or Pernahyd Hi-TEC Basecoat.
Permasolid® HS Diamond Clear Coat 8450 - ASAP	2:1+0-5%	3240	8580, 3363, 3365	+10% 9050	600	9050 must be added before hardener. Only compliant if used in a 2-stage coating system with 293/295 basecoat or with a 2 or 3-stage coating system and Pernahyd Basecoat or Pernahyd Hi-TEC Basecoat.
Permasolid® HS Optimum Clear Coat 8600	3:1	3251, 3254, 3250, 3252, 3257	N/A	N/A	600	Only compliant if used in a 2-stage coating system with 293/295 basecoat or with a 2 or 3-stage coating system and Pernahyd Hi-TEC Basecoat.
Permasolid® HS Optimum Clear Coat 8600 Elasticized	3:1+0-5%	3251, 3254, 3250, 3252, 3257	8580, 3363, 3365, 9025	+15-30% 9050	600	Compliant when used with both 2 & 3-stage coating systems; 9050 must be added before hardener.
Permasolid® HS Optimum Clear Coat 8600	3:1+0-5%	3220, 3230, 3240, 3245	8580, 3363, 3365, 9025	N/A	600	Only compliant if used in a 2-stage coating system with 293/295 basecoat or with a 2 or 3-stage coating system and Pernahyd Hi-TEC Basecoat.
Permasolid® HS Optimum Clear Coat 8600 Elasticized	3:1+0-5%	3220, 3230, 3240, 3245	8580, 3363, 3365, 9025	+15-30% 9050	600	Compliant when used with both 2 & 3-stage coating systems; 9050 must be added before hardener.
Permasolid® Matte Clear Coat Additive 8092 with 8035	See TDS 8092	3192, 3194, 3196	3392, 3394	N/A	600	Refer to TDS for mixing instructions over both metal and plastic.
Specialty Coatings VOC Limit = 7.0 lbs/gal (840 g/L)						
Elastomeric Coatings						
Permacron® 1:1 Elastic Primer Surface 3300	1:1	3301	N/A	N/A	840	
330™ Axalta Plastic Primer Surface Gray	1:1	331	N/A	N/A	840	
320™ Axalta Plastic Primer Surface Black	1:1	331	N/A	N/A	840	
Priomat® Elastic Primer 3304	Ready to Use	N/A	N/A	N/A	840	
Priomat® Elastic Primer 3304 (Aerosol)	Aerosol	N/A	N/A	N/A	N/A	
Priomat® 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® Matt System Clear Coat 8185 / Permacron® Semi-Gloss System Clear Coat 8170	See Matt Clear System TDS	3225, 3240	3365	N/A	840	
Permasolid® Mating Component MA110 / Permacron® Semi-Gloss System Clear Coat 8170	See Matt Clear System TDS	3225, 3240	3365	N/A	840	
Permacron® Semi-gloss Elastic Clear Coat 8070	3:1+5-10%	3193, 3195, 3197, 3199	8580, 3363, 3365	N/A	840	
Uniform Finish Coatings						
Permacron® Speed Blender 1036	9:1 w/ Spies Hecker® HS Speed Clear Coat 8820 (RTS)				840	
Permacron® Speed Blender 1036	4:1 w/Permacron® or Permasolid® Clear Coats (RTS)				840	
Permacron® Speed Clear Coat 1036 w/8096	See 1036 TDS for compliant mixing recommendations				840	
Permacron® Speed Blender 1036 w/8098	See 1036 TDS for compliant mixing recommendations				840	
Pernahyd® Blend-in Additive 9005	1:1 w/Permahyd® Base Coat Series 280/285 (RTS)				840	
Pernahyd® Blend-in Additive 9017	1:2 w/Permahyd® Base Coat Series 280/285 (RTS)				840	
Pernahyd® Blend-in Additive 9017	+50%	N/A	9016	N/A	840	
Pernahyd® Hi-TEC Blend-in Additive 1050 or 1051	+10%	N/A	6050, 6052	N/A	840	
Pernahyd® Hi-TEC Blend-in Additive 1050	+5%	N/A	1053	N/A	840	
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			600	
Permasolid® Additive Magenta 9057		See 998.0 TDS for compliant mixing recommendations			600	
Permasolid® Additive Violet 9058		See 998.0 TDS for compliant mixing recommendations			600	
Permasolid® Additive Deep Red 9049		See 998.0 TDS for compliant mixing recommendations			600	
Permasolid® Additive Blue 9045		See 998.0 TDS for compliant mixing recommendations			600	
Raderal® Spray Polyester 3508	+5%	9520	+5% 7690 or +2.5% 9010	N/A		
766A™ Axalta 1K Trim Black Satin	Ready to Use	N/A	N/A	N/A	N/A	Aerosol
Axalta E-Coat Restore Aerosols	Ready to Use	N/A	N/A	N/A	N/A	See TDS for compliance and usage instructions.
715™ Axalta Sanding Paste	Ready to Use	N/A	N/A	N/A	N/A	
Pernahyd® Sanding Paste 1120	Ready to Use	N/A	N/A	N/A	N/A	

For complete product usage and mixing recommendations, see the product specific technical data sheet located on www.SpiesHeckerUSA.com.
Copyright © 2020 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 refinish systems. All rights reserved.