

Spies Hecker® VOC Compliance Chart

Indiana Dept. of Environmental Management - 326 IAC Rule 19 - Automobile Refinishing - Effective 6/1/2009

Illinois Environmental Protection Agency - Title 35 BIC Parts 212/219 - Motor Vehicle Refinishing - Effective May 1995



Description		Compliant Rules		Applied VOC Isatol		Remarks	
Surface Preparation VOC Limit = 1.4 Isatol (188 g/L)							
107™ Asaite Low VOC Gun & Equipment Cleaner					0.2		
110™ Asaite Silicone Remover/Waxer					1.4		
220™ Asaite Silicone Remover/Low VOC					0.2		
Pennacraft Plastic Cleaner Paste 281					0.1		
305™ Asaite Plastic Cleaning Paste					0.1		
Plastic Surface Preparation VOC Limit = 6.5 Isatol (780 g/L)							
200™ Asaite Silicone Remover/Waxer					6.5		
445™ Asaite Bar & Tie Remover					2.9	FOR PLASTICS ONLY!	
Description	Mix Ratio	Hardener	Reducer/Additive	Addl Product	Max Applied VOC (LE)	Remarks	
Primer/VOC Limit = 6.5 Isatol (780 g/L)							
Pennacraft Primer 3025	+50%	N/A	8880, 3363, 3365	N/A	6.5		
Pennacraft Primer 3025 (Aerosol)	Ready to Use	N/A	N/A	N/A	N/A		
Pennacraft Wash Primer 4075	1:1	4075	N/A	N/A	6.5		
Pennacraft 1K Primer Surface 4085 (Aerosol)	Ready to Use	N/A	N/A	N/A	N/A		
Pennacraft 1K Primer Surface 4085	+50%	N/A	8880, 3363, 3365	N/A	6.5		
Asaite® 488™	Ready to Use	N/A	N/A	N/A	6.5		
400™ Asaite E-ten Primer	1:1	421	N/A	N/A	6.5		
410A™ Asaite 1K Primer Surface Light Gray	Ready to Use	N/A	N/A	N/A	N/A		
400A™ Asaite 1K Primer Surface Dark Gray	Ready to Use	N/A	N/A	N/A	N/A		
495™ Asaite Metal Pre-treatment Waxes	Ready to Use	N/A	N/A	N/A	6.5		
Primer/VOC Limit = 4.8 Isatol (580 g/L)							
Pennacraft 1K Pre-treatment Primer Surface 4100	+4-10%	N/A	8880	N/A	4.8		
Pennacraft EP Primer Surface 4500	2:1 (+25-30%)	4501	3363, 3365	N/A	4.8		
Pennacraft EP Primer Surface 4502	2:1 (+10-15%)	4503	3364	N/A	4.8		
450A™ Asaite Epoxy 2K	Ready to Use	Included	N/A	N/A	4.8		
Pennacraft VHS Surface 5100	2:1 5:4 +5-10%	3200, 3230, 3240, 3245	8880, 3363, 3365, 5409	N/A	4.8		
Pennacraft 2K Surface 5101	4:1 +5-10%	3307, 3309, 3310, 3315, 3320, 3325	8880, 3363, 3365, 5409, 5410	N/A	4.8	9050 must be added before hardener.	
Pennacraft HS Premium Surface 5101	2:1 (+10-20%)	3200, 3230, 3240, 3245	8880, 3363, 3365	N/A	4.8		
Pennacraft HS Premium Surface 5110	4:1 (+10-15%)	3307, 3309, 3310, 3315, 3320, 3325	8880, 3363, 3365	N/A	4.8		
Pennacraft Spectro Surface 5400	2:1 (+10-15%)	3307, 3309, 3310, 3315, 3320, 3325	8880, 3363, 3365	N/A	4.8		
Pennacraft Spectro Surface 5400 Electrocoat	2:1 (+10-15%)	3307, 3309, 3310, 3315, 3320, 3325	8880, 3363, 3365	+30% 9050	4.8	9050 must be added before hardener.	
Pennacraft Spectro Surface 5400	2:1 (+10-15%)	3200, 3230, 3240, 3245	8880, 3363, 3365	N/A	4.8		
Pennacraft Spectro Surface 5400 Electrocoat	2:1 (+10-15%)	3200, 3230, 3240, 3245	8880, 3363, 3365	+30% 9050	4.8	9050 must be added before hardener.	
Pennacraft Spectro Sealer 5400	2:1 (+10-20%)	3307, 3309, 3310, 3315, 3320	5409	N/A	4.8	9050 must be added before hardener.	
Pennacraft Spectro Sealer 5450 Electrocoat	2:1 (+10-20%)	3307, 3309, 3310, 3315, 3320	5409	+15-30% 9050	4.8		
Pennacraft Spectro Sealer 5450	2:1 (+10-20%)	3200, 3230, 3240, 3245	5409	N/A	4.8		
Pennacraft Spectro Sealer 5450 Electrocoat	2:1 (+10-20%)	3200, 3230, 3240, 3245	5409	+15-30% 9050	4.8		
Pennacraft Vario Surface 8900	1:1	3365	N/A	N/A	4.8		
Pennacraft Vario Surface 8900 Electrocoat	2:1 (+10-15%)	3307, 3309, 3310, 3315, 3320, 3325	8880, 3363, 3365	N/A	4.8	9050 must be added before hardener.	
Pennacraft Vario Surface 8900	2:1 (+10-15%)	3307, 3309, 3310, 3315, 3320, 3325	8880, 3363, 3365	+30% 9050	4.8	9050 must be added before hardener.	
Pennacraft Vario Surface 8900	2:1 (+10-20%)	3200, 3230, 3240, 3245	8880, 3363, 3365	N/A	4.8		
Pennacraft Vario Surface 8900 Electrocoat	2:1 (+10-20%)	3200, 3230, 3240, 3245	8880, 3363, 3365	+30% 9050	4.8	9050 must be added before hardener.	
Pennacraft 1K UV Stencil Primer Surface 9002 (Aerosol)	Ready to Use	N/A	N/A	N/A	N/A	Aerosol	
Pennacraft 1K UV Stencil Primer Surface 9002	Ready to Use	N/A	N/A	N/A	N/A	Non-Aerosol version	
Primer-Sealers VOC Limit = 4.8 Isatol (580 g/L)							
Pennacraft Spectro Surface 5400	2:1 (+10-30%)	3307, 3309, 3310, 3315, 3320, 3325	5407	N/A	4.8		
Pennacraft Spectro Surface 5400 w/Pennacraft Reducer	2:1 (+10-20%)	3307, 3309, 3310, 3315, 3320, 3325	5407	+0-1% 8880, 3363, 3365	4.8		
Pennacraft Spectro Surface 5400 Electrocoat	2:1 (+10-20%)	3307, 3309, 3310, 3315, 3320, 3325	5407	+30% 9050	4.8	9050 must be added before hardener.	
Pennacraft Spectro Surface 5400 Electrocoat w/Pennacraft Reducer	2:1	3307, 3309, 3310, 3315, 3320, 3325	+0-20% 5407	+30% 9050, 3363, 3365	4.8		
Pennacraft Spectro Surface 5400	2:1 (+40-50%)	3200, 3230, 3240, 3245	5407	N/A	4.6		
Pennacraft Spectro Surface 5400 w/Pennacraft Reducer	2:1 (+40-50%)	3200, 3230, 3240, 3245	5407	+14-16% 8880, 3363, 3365	4.6		
Pennacraft Spectro Surface 5400 Electrocoat	2:1 (+40-50%)	3200, 3230, 3240, 3245	5407	+30% 9050	4.6	9050 must be added before hardener.	
Pennacraft Spectro Surface 5400 Electrocoat w/Pennacraft Reducer	2:1	3200, 3230, 3240, 3245	+0-40% 5407	+30% 9050, 3363, 3365	4.6		
Pennacraft Spectro Sealer 5400	2:1 (+10-20%)	3307, 3309, 3310, 3315, 3320	5409, 5410	N/A	4.6		
Pennacraft Spectro Sealer 5450 Electrocoat	2:1 (+10-20%)	3307, 3309, 3310, 3315, 3320	5409, 5410	+15-30% 9050	4.6	9050 must be added before hardener.	
Pennacraft Spectro Sealer 5450	2:1 (+10-20%)	3200, 3230, 3240, 3245	5409, 5410	N/A	4.6		
Pennacraft Spectro Sealer 5450 Electrocoat	2:1 (+10-20%)	3200, 3230, 3240, 3245	5409, 5410	+15-30% 9050	4.6	9050 must be added before hardener.	
Pennacraft Vario Surface 8900 Electrocoat	2:1 (+10-20%)	3307, 3309, 3310, 3315, 3320, 3325	8880, 3363, 3365	+30% 9050	4.6	9050 must be added before hardener.	
Pennacraft Vario Surface 8900	2:1 (+10-20%)	3200, 3230, 3240, 3245	8880, 3363, 3365	+30% 9050	4.6	9050 must be added before hardener.	
Single Stage Topcoat VOC Limit = 8.0 Isatol (960 g/L)							
Pennacraft Asaite® Ultimate Series 267	3:1 (+1-10%)	3307, 3309, 3310, 3315, 3320, 3325	8880, 3363, 3365	N/A	5.0		
Pennacraft Automotive Topcoat Series 257 FP-1004 Ruby Mat Black	4:1 (+20%)	3200, 3230, 3240, 3245	8880, 3363, 3365	+10% 9050	5.0		
Pennacraft Automotive Topcoat 257 Series FP-1002 Blue Black	4:1 (+20%)	3200, 3230, 3240, 3245	8880, 3363, 3365	+10% 9050	5.0		
Pennacraft Automotive Top Coat FP-1003 Warm Gray V/RO4N	3:1	3307, 3309, 3310, 3315, 3320, 3325	8880, 3363, 3365, 5409, 5410	+0-5% 8880, 8095	5.0		
Pennacraft Automotive Top Coat FP-1003 Warm Gray V/RO4N	3:1 (+10%)	3200, 3230, 3240, 3245	8880, 3363, 3365	+0-5% 8880, 8095	5.0		
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