

Spies Hecker® VOC Compliance Chart



US National Rule for Automotive Refinishing - Effective 01/11/1999

Description	Compliant Rules	Applied VOC lbs/gal	Remarks
Surface Preparation			
105™ Axalta Gun & Equipment Cleaner	No Surface Preparation limits are set forth in the National Rule. Check local Surface Preparation regulations for limits.	5.4	
106™ Axalta Cleaner		4.4	
107™ Axalta Low VOC Gun & Equipment Cleaner		0.2	
108™ Axalta Low HAP Cleaner		3.9	
130™ Axalta Cleaner		0	
139™ Axalta Bug & Tar Remover		2.9	
200™ Axalta Silicone Remover Slow		6.5	
205A™ Axalta Silicone Remover (Aerosol)		6.3	
210™ Axalta Silicone Remover Water		1.4	
220™ Axalta Silicone Remover Low VOC		0.2	
225™ Axalta Bug & Tar Remover		2.9	
275™ Axalta Plastic Cleaning Solvent		7.2	
Permanent® Silicone Remover 7010 Slow		6.2	
Permahyd® Plastic Cleaning Paste 7081		0.1	
Permahyd® Silicone Remover 7085		1.5	
Permahyd® Silicone Remover 7086		1.4	
Permaloid® Silicone Remover 7087 (Aerosol)		n/a	
Permahyd® Silicone Remover 7096		0.2	
Primat® Plastic Reducer 8581		7.1	

Description	Mix Ratio	Hardener	Reducer/ Additive	Addtl Product	Max Applied VOC (LE) lbs/gal	Remarks
Pretreatment VOC Limit = 6.5 lbs/gal (780 g/L)						
Primat® Primer 3255	+50%	N/A	8580, 3363, 3365	N/A	6.5	
Primat® Primer 3255 (Aerosol)	Ready to Use	N/A	N/A	N/A	N/A	
Primat® 1K Primer Surfacer 4085	+50%	N/A	8580, 3363, 3365	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	N/A	
400A™ Axalta 1K Primer Surfacer Dark Gray	Ready to Use	N/A	N/A	N/A	N/A	
495™ Axalta Metal Pretreatment Wipes	Ready to Use	N/A	N/A	N/A	6.5	
Primers/Primer-Surfacers VOC Limit = 4.8 lbs/gal (580 g/L)						
Permahyd® 1K Productive Primer Surfacer 4100	+5-10%	N/A	6000	N/A	4.8	
Permasolid® EP Primer Surfacer 4500	3:1+25-30%	4501	3363, 3365	N/A	4.8	
Permasolid® EP Primer Surfacer 4502	2:1+0-10%	4503	3394	N/A	4.8	
460A™ Axalta Epoxy 2K	Ready to Use	included	N/A	N/A	4.8	
Spies Hecker® HS Speed Surfacer 5560	2:1+30-40%	3251, 3254	9065, 3380, 3385	N/A	4.8	
Spies Hecker® HS Speed Surfacer 5560 with Plastic Additive	2:1+25%+25%	3251, 3254	3380, 3385	N/A	4.8	
Permasolid® HS Premium Surfacer 5310	4:1+0-10%	3307, 3309, 3310, 3315, 3320, 3325	8580, 3363, 3365	N/A	4.8	
Permasolid® HS Premium Surfacer 5310	7:1+10-20%	3220, 3230, 3240, 3245	8580, 3363, 3365	N/A	4.8	
Permacron® 2.1 VHS Surfacer 5150	2:1 5 + 5-10%	3220, 3230, 3240, 3245	8580, 3363, 3365, 5408	N/A	4.8	
Permasolid® 2.1 Surfacer 5157	4:1 + 5-10%	3307, 3309, 3310, 3315, 3320, 3325	8580, 3363, 3365, 5408, 5409, 5410	N/A	4.8	
Permasolid® 2.1 Surfacer 5157 Elastified	4:1 +10-20%	3307, 3309, 3310, 3315, 3320, 3325	8580, 3363, 3365, 5408, 5409, 5410	+30% 9050	4.8	9050 must be added before hardener.
Permasolid® Spectro Surfacer 5400	4:1+0-15%	3307, 3309, 3310, 3315, 3320, 3325	8580, 3363, 3365	N/A	4.8	
Permasolid® Spectro Surfacer 5400 Elasticized	2:1+0-15%	3307, 3309, 3310, 3315, 3320, 3325	8580, 3363, 3365	+30% 9050	4.8	9050 must be added before hardener.
Permasolid® Spectro Surfacer 5400	7:1+25%	3220, 3230, 3240, 3245	8580, 3363, 3365	N/A	4.8	
Permasolid® Spectro Surfacer 5400 Elasticized	3:1+25%	3220, 3230, 3240, 3245	8580, 3363, 3365	+30% 9050	4.8	9050 must be added before hardener.
Permasolid® Spectro Sealer 5450	3:1+20-25%	3307, 3309, 3310, 3315, 3320	5408	N/A	4.8	
Permasolid® Spectro Sealer 5450 Elasticized	2:1+20-25%	3307, 3309, 3310, 3315, 3320	5408	15-30% 9050	4.8	9050 must be added before hardener.
Permasolid® Spectro Sealer 5450	5:1+25-30%	3220, 3230, 3240, 3245	5408	N/A	4.8	
Permasolid® Spectro Sealer 5450 Elasticized	4:1+25-30%	3220, 3230, 3240, 3245	5408	15-30% 9050	4.8	9050 must be added before hardener.
Permasolid® Vario Surfacer 8590	3:1+5-10%	3307, 3309, 3310, 3315, 3320, 3325	8580, 3363, 3365		4.8	
Permasolid® Vario Surfacer 8590 Elasticized	3:1+5-10%	3307, 3309, 3310, 3315, 3320, 3325	8580, 3363, 3365	+30% 9050	4.8	9050 must be added before hardener.
Permasolid® Vario Surfacer 8590	5:1+10-20%	3220, 3230, 3240, 3245	8580, 3363, 3365		4.8	
Permasolid® Vario Surfacer 8590 Elasticized	5:1+10-20%	3220, 3230, 3240, 3245	8580, 3363, 3365	+30% 9050	4.8	9050 must be added before hardener.
Permasolid® 1K UV Starlight Primer Surfacer 9002 (Aerosol)	Ready to Use	N/A	N/A	N/A	N/A	Aerosol
Permasolid® 1K UV Starlight Primer Surfacer 9002	Ready to Use	N/A	N/A	N/A	4.8	Non-Aerosol version

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Primer-Sealers VOC Limit = 4.6 lbs/gal (550 g/L)							
Spies Hecker® HS Speed Surfacers 5560	2:1+30-40%	3251, 3254, 3250, 3252	9065, 3380, 3385	N/A	4.8		
Spies Hecker® HS Speed Surfacers 5560 with Plastic Additive	2:1+25%+25%	3251, 3254, 3250, 3253	3380, 3385	N/A	4.8		
Permasolid® Spectro Surfacers 5400	2:1+20-30%	3307, 3309, 3310, 3315, 3320, 3325	5407	N/A	4.6		
Permasolid® Spectro Surfacers 5400 w/Permacron Reducer	2:1+20-25%	3307, 3309, 3310, 3315, 3320, 3325	5407	+0-5% 8580, 3363, 3365	4.6		
Permasolid® Spectro Surfacers 5400 Elasticized	2:1+20-30%	3307, 3309, 3310, 3315, 3320, 3325	5407	+30% 9050	4.6		9050 must be added before hardener.
Permasolid® Spectro Surfacers 5400 Elasticized w/Permacron Reducer	2:1	3307, 3309, 3310, 3315, 3320, 3325	+20-25% 5407 +0-5% 8580, 3363, 3365	+30% 9050	4.6		
Permasolid® Spectro Surfacers 5400	3:1+40-50%	3220, 3230, 3240, 3245	5407	N/A	4.6		
Permasolid® Spectro Surfacers 5400 w/Permacron Reducer	3:1+40-45%	3220, 3230, 3240, 3245	5407	+0-5% 8580, 3363, 3365	4.6		
Permasolid® Spectro Surfacers 5400 Elasticized	3:1+40-50%	3220, 3230, 3240, 3245	5407	+30% 9050	4.6		9050 must be added before hardener.
Permasolid® Spectro Surfacers 5400 Elasticized w/Permacron Reducer	3:1	3220, 3230, 3240, 3245	+40-45% 5407 +0-5% 8580, 3363, 3365	+30% 9050	4.6		
Permasolid® Spectro Sealer 5450	3:1+20-25%	3307, 3309, 3310, 3315, 3320	5409, 5410	N/A	4.6		
Permasolid® Spectro Sealer 5450 Elasticized	2:1+20-25%	3307, 3309, 3310, 3315, 3320	5409, 5410	15-30% 9050	4.6		9050 must be added before hardener.
Permasolid® Spectro Sealer 5450	5:1+25-30%	3220, 3230, 3240, 3245	5409, 5410	N/A	4.6		
Permasolid® Spectro Sealer 5450 Elasticized	4:1+25-30%	3220, 3230, 3240, 3245	5409, 5410	15-30% 9050	4.6		9050 must be added before hardener.
Permahyd® 2K Sealer 5650	1:5%	3080	N/A	N/A	4.6		
Permasolid® Vario Surfacers 8590 Elasticized	3:1+20%	3307, 3309, 3310, 3315, 3320, 3325	8580, 3363, 3365	30% 9050	4.6		9050 must be added before hardener.
Permasolid® Vario Surfacers 8590 Elasticized	5:1+10-20%	3220, 3230, 3240, 3245	8580, 3363, 3365	30% 9050	4.6		9050 must be added before hardener.
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	8580, 3363, 3365	N/A	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	3:1	3307, 3309, 3310, 3315, 3320, 3325		+0-5% 8092, 8096	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		
2-stage Topcoat VOC Limit = 5.0 lbs/gal (600 g/L) applied as a system 3-stage Topcoat VOC Limit = 5.2 lbs/gal (630 g/L) applied as a system							
Basecoats: Must be used with specific clearcoats for compliance							
Permahyd® Hi-TEC Base Coat w/ Hardeners	+5-10% +10-30%	3080	6050, 6051, 6052, 6053	N/A	5.0		
Permahyd® Base Coat Series 280/285	+0-15%	N/A	6000	N/A	5.0		
Permahyd® Base Coat Series 280/285	+0-10%	N/A	6002	N/A	5.0		
Permahyd® Base Coat Series 280/285	+5-10%	9007	+10-20% 6000 or 0-10% 6002	N/A	5.0		
Permacron® Base Coat Series 293/295	+40-50%	N/A	3054, 3055, 3056	N/A	5.0		
Permacron® FP2003	+15% +40-50%	3307, 3309, 3310, 3315, 3320, 3325	3055, 3054, 3056	N/A	5.0		
Permacron® FP2003	+10% +45%	3220, 3230, 3240, 3245	3054, 3055, 3056	N/A	5.0		
Permacron® Base Coat Series 293/295 - GMW 15406	+15% +40-50%	3307, 3309, 3310, 3315, 3320, 3325	3054, 3055, 3056	N/A	5.0		
Permacron® Base Coat Series 293/295 - GMW 15406	+10% +40-50%	3220, 3230, 3240, 3245	3054, 3055, 3056	N/A	5.0		
Permacron® Base Coat Series 293/295 - High Temp/Humidity	+35% +15%	N/A	3056	9015	5.0		
Permasolid® 2K Diamond Midcoat MC 0001	See 996.0 TDS for Mixing Recommendations	3307, 3309, 3310, 3315, 3320, 3325 or 3220, 3230, 3240, 3245	8580, 3363, 3365	+15% 9050	5.0		
Permasolid® 2K Transparent Red Midcoat MC 0002	See 996.0 TDS for Mixing Recommendations	3307, 3309, 3310, 3315, 3320, 3325 or 3220, 3230, 3240, 3245	8580, 3363, 3365	+15% 9050	5.0		
Permasolid® 2K Transparent Blue Midcoat MC 0003	See 996.0 TDS for Mixing Recommendations	3307, 3309, 3310, 3315, 3320, 3325 or 3220, 3230, 3240, 3245	8580, 3363, 3365	+15% 9050	5.0		
Permacron® Transparent Midcoat 9100	1:1+3%	3240, 3245	3363, 3365	9045, 9049, 9056, 9057, 9058	5.0		
Clearcoats: Must be used as a system with basecoats at/under 5.0 lbs/gal (600 g/L) 2-stage or 5.2 lbs/gal (630 g/L) 3-stage for compliance							
Spies Hecker® HS Speed Clear Coat 8820	2:1	3251, 3254, 3250, 3252, 3257	N/A	N/A	5.0		Compliant when used with both 2 & 3-stage coating systems.
Permacron® HS Clear Coat 8035	2:1+0-10%	3307, 3309, 3310, 3315, 3320, 3325	8580, 3363, 3365, 9025	N/A	5.0		Compliant when used in a 2-stage coating system.
Permacron® HS Clear Coat 8035 Elasticized	2:1+0-10%	3307, 3309, 3310, 3315, 3320, 3325	8580, 3363, 3365, 9025	+15-30% 9050	5.0		Compliant when used in a 2-stage coating system; 9050 must be added before hardener.
Permasolid® HS Clear Coat 8035	3:1+15-20%	3220, 3230, 3240, 3245	8580, 3363, 3365, 9025	N/A	5.0		Compliant when used with both 2 & 3-stage coating systems.
Permasolid® HS Clear Coat 8035 Elasticized	3:1+15-20%	3220, 3230, 3240, 3245	8580, 3363, 3365, 9025	+15-30% 9050	5.0		Compliant when used with both 2 & 3-stage coating systems; 9050 must be added before hardener.
Permacron® MS Express Clear Coat 8046	2:1+0-5%	3307, 3309, 3310, 3315, 3320, 3325	8580, 3363, 3365, 9025	N/A	5.0		Compliant when used in a 2-stage coating system.
Permacron® MS Express Clear Coat 8046 Elasticized	2:1+0-5%	3307, 3309, 3310, 3315, 3320, 3325	8580, 3363, 3365, 9025	+15-30% 9050	5.0		Compliant when used in a 2-stage coating system; 9050 must be added before hardener.
Permacron® MS Express Clear Coat 8046	3:1+10%	3220, 3230, 3240, 3245	8580, 3363, 3365, 9025	N/A	5.0		Compliant when used in a 2-stage coating system.
Permacron® MS Express Clear Coat 8046 Elasticized	3:1+10%	3220, 3230, 3240, 3245	8580, 3363, 3365, 9025	+15-30% 9050	5.0		Compliant when used in a 2-stage coating system; 9050 must be added before hardener.
Permasolid® Low VOC Clear Coat 8096	3:2 + 5-15%	3307, 3309, 3310, 3315, 3320, 3325	3363, 3365, 8580	N/A	5.0		Compliant when used with both 2 & 3-stage coating systems.
Permasolid® Low VOC Clear Coat 8096	2.5:1 +20-25%	3220, 3230, 3240, 3245	3363, 3365, 8580	N/A	5.0		Compliant when used with both 2 & 3-stage coating systems.
Permasolid® Low VOC Clear Coat 8096 Elasticized	3:2 + 5-15%	3307, 3309, 3310, 3315, 3320, 3325	3363, 3365, 8580	+15-30% 9050	5.0		Compliant when used with both 2 & 3-stage coating systems; 9050 must be added before hardener.
Permasolid® Low VOC Clear Coat 8096 Elasticized	2.5:1 +20-25%	3220, 3230, 3240, 3245	3363, 3365, 8580	+15-30% 9050	5.0		Compliant when used with both 2 & 3-stage coating systems; 9050 must be added before hardener.
Permacron® MS Clear Coat 8180	2:1	3307, 3309, 3310, 3315, 3320	N/A	N/A	5.0		Only compliant when used in a 2-stage coating system.
Permacron® MS Clear Coat 8180 Elasticized	2:1	3307, 3309, 3310, 3315, 3320	N/A	+15-30% 9050	5.0		Only compliant when used in a 2-stage coating system; 9050 must be added before hardener.
Permacron® MS Clear Coat 8180	3:1+0-10%	3220, 3230, 3240, 3245	8580, 3363, 3365, 9025	N/A	5.0		Only compliant when used in a 2-stage coating system.
Permacron® MS Clear Coat 8180 Elasticized	3:1+10%	3:1 w/3220, 3230, 3240, 3245	8580, 3363, 3365, 9025	+15-30% 9050	5.0		Only compliant when used in a 2-stage coating system; 9050 must be added before hardener.
Permasolid® HS Diamond Clear Coat 8450	3:1+0-5%	3240	8580, 3363, 3365	N/A	5.0		Compliant when used with both 2 & 3-stage coating systems.
Permasolid® HS Diamond Clear Coat 8450 - ASAP	2:1+0-5%	3240	8580, 3363, 3365	+10% 9050	5.0		Compliant when used with both 2 & 3-stage coating systems; 9050 must be added before hardener.
Permasolid® HS Optimum Clear Coat 8600	3:1	3251, 3254, 3250, 3252, 3257	N/A	N/A	5.0		Only compliant if used in a 2-stage coating system with 293/295 basecoat or with a 2 or 3-stage coating system and Permahyd 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	5.0		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	5.0		Only compliant if used in a 2-stage coating system with 293/295 basecoat or with a 2 or 3-stage coating system and Permahyd 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	5.0		Compliant when used with both 2 & 3-stage coating systems; 9050 must be added before hardener.

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Permasolid® Matte Clear Coat Additive 8092 with 8035	See TDS 8092 for Mixing Recommendations	5.0	Refer to TDS for mixing instructions over both metal and plastic.
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Specialty Coatings VOC Limit = 7.0 lbs/gal (840 g/L)						
Adhesion Promoters						
Permacron® Transparent Surfacers 8550	3:1+20-30%	3307, 3309, 3310, 3315, 3320, 3325	8580, 3363, 3365	N/A	7.0	
Permacron® Transparent Surfacers 8550	4:1+ 35%	3220, 3230, 3240, 3245	8580, 3363, 3365	N/A	7.0	
Permasolid® Vario Surfacers 8590	3:1+20-30%	3307, 3309, 3310, 3315, 3320, 3325	8580, 3363, 3365	N/A	7.0	
Permasolid® Vario Surfacers 8590	5:1+30-40%	3220, 3230, 3240, 3245	8580, 3363, 3365	N/A	7.0	
Elastomeric Coatings						
Permacron® 1:1 Elastic Primer Surfacers 3300	1:1	3301	N/A	N/A	7.0	
330™ Axalta Plastic Primer Surfacers Gray	1:1	331	N/A	N/A	7.0	
320™ Axalta Plastic Primer Surfacers Black	1:1	331	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	N/A	
300™ Axalta Plastic Polyolefin Adhesion Promoter	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	
Priomat® Elastic Primer 4190	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	
Permacron® Matt System Clear Coat 8185 / Permacron® Semi-Gloss System Clear Coat 8170	See Matt Clear System TDS	3225, 3240	3365	N/A	7.0	
Permasolid® Mating Component MA110 / Permacron® Semi-Gloss System Clear Coat 8170	See Matt Clear System TDS	3225, 3240	3365	N/A	7.0	
Permacron® Semi-gloss Elastic Clear Coat 8070	3:1+5-10%	3307, 3309, 3310, 3315, 3320, 3325	8580, 3363, 3365	N/A	7.0	
Permacron® Semi-gloss Elastic Clear Coat 8070	5:1+20%	3220, 3230, 3240, 3245	8580, 3363, 3365	N/A	7.0	
Permacron® FP1004 Rally Matte Black	3:1+5-10%	3307, 3309, 3310, 3315, 3320, 3325	8580, 3363, 3365	N/A	7.0	
Fisheye 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	9:1 w/ Spies Hecker® HS Speed Clear Coat 8820 (RTS)				7.0	
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%	N/A	9016	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	N/A	
Other Products/ Additives						
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				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	
766A™ Axalta 1K Trim Black Satin	Ready to Use	N/A	N/A	N/A	N/A	Aerosol
Permahyd® Sanding Paste 1120	Ready to Use	N/A	N/A	N/A		
265™ Axalta Plastic Cleaning Paste	Ready to Use	N/A	N/A	N/A	N/A	
Axalta E-Coat Restore Aerosols	Ready to Use	N/A	N/A	N/A	N/A	See TDS for compliance and usage instructions.
Radical® Spray Polyester 3508	+5%	9520	+5% 7690 or +2.5% 9010	N/A		
Permacron® Fine Putty 7715	Ready to Use	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.

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