

Spies Hecker® VOC Compliance Chart

State of Wisconsin
Chapter NR 422 Part 095 - Automobile Refinishing Operations
Effective: 3/21/2013



Description		Compliant Rules			Applied VOC lb/gal	Remarks
Surface Preparation VOC Limit = 42 lb/gal (69 g/L)						
107™ Anala Low VOC Gun & Equipment Cleaner					0.2	
220™ Anala Silicone Remover Low VOC					0.1	
205A™ Anala Silicone Remover (Aerosol)		Wisconsin			N/A	If using non-volatile aerosol products of less than 100 ounces per day, per facility
Permaseal® Plastic Cleaning Paste 7081					0.1	
285™ Anala Plastic Cleaning Paste					0.1	
Description	Mix Ratio	Hardener	Reducer/ Additive	Addl Product	Max Applied VOC (LE) lb/gal	Remarks
Pre-treatment VOC Limit = 6.5 lb/gal (789 g/L)						
Primer® Primer 3255	+10%	N/A	8590, 3363, 3365	N/A	6.5	
Primer® Primer 3255 (Aerosol)	Ready to Use	N/A	N/A	N/A	N/A	
Primer® Primer 4075	1:1	4076	N/A	N/A	6.5	
Primer® 1K Primer Surface 4085 (Aerosol)	Ready to Use	N/A	N/A	N/A	N/A	
Primer® 1K Primer Surface 4085	+10%	N/A	8590, 3363, 3365	N/A	6.5	
Anala® 485™	Ready to Use	N/A	N/A	N/A	6.5	
420™ Anala Etn Primer	1:1	421	N/A	N/A	6.5	
4150™ Anala 1K Primer Surface Light Gray	Ready to Use	N/A	N/A	N/A	6.5	
400A™ Anala 1K Primer Surface Dark Gray	Ready to Use	N/A	N/A	N/A	N/A	
485™ Anala Metal Conversion Coats	Ready to Use	N/A	N/A	N/A	6.5	
Primer® Primer-Surfaces VOC Limit = 4.8 lb/gal (589 g/L)						
Permaseal® 1K Protective Primer Surface 4100	+4/-10%	N/A	6009	N/A	4.8	
Permaseal® EP Primer Surface 4500	3:1 +1/-20-30%	4501	3303, 3365	N/A	4.8	
Permaseal® EP Primer Surface 4502	2:1 +1/-10-15%	4503	3304	N/A	4.8	
450A™ Anala Epoxy 2K	Ready to Use	included	N/A	N/A	4.8	
Permaseal® VAS Surface 5150	2:1 1.5 + 1/-10%	3220, 3230, 3240, 3245	8590, 3363, 3365, 5408	N/A	4.8	
Permaseal® 2.1 Surface 5157	4:1 + 1/-10%	3307, 3309, 3310, 3315, 3320, 3325	8590, 3363, 3365, 5408, 5409, 5410	N/A	4.8	
Permaseal® 2.1 Surface 5157 Elastified	4:1 +1/-20%	3307, 3309, 3310, 3315, 3320, 3325	8590, 3363, 3365, 5408, 5409, 5410	+30% 9050	4.8	9050 must be added before hardener.
Permaseal® HS Permian Surface 5310	4:1 +1/-10-20%	3307, 3309, 3310, 3315, 3320, 3325	8590, 3363, 3365	N/A	4.8	
Permaseal® HS Permian Surface 5310	7:1 +10-20%	3220, 3230, 3240, 3245	8590, 3363, 3365	N/A	4.8	
Permaseal® Spectra Surface 5400	4:1 +1/-10-15%	3307, 3309, 3310, 3315, 3320, 3325	8590, 3363, 3365	N/A	4.8	
Permaseal® Spectra Surface 5400 Elastified	2:1 +1/-15%	3307, 3309, 3310, 3315, 3320, 3325	8590, 3363, 3365	+30% 9050	4.8	9050 must be added before hardener.
Permaseal® Spectro Surface 5400	7:1 +20%	3220, 3230, 3240, 3245	8590, 3363, 3365	N/A	4.8	
Permaseal® Spectro Surface 5400 Elastified	3:1 +20%	3220, 3230, 3240, 3245	8590, 3363, 3365	+30% 9050	4.8	9050 must be added before hardener.
Permaseal® Spectro Sealer 5450	3:1 +20-25%	3307, 3309, 3310, 3315, 3320	5408	N/A	4.8	
Permaseal® Spectro Sealer 5450 Elastified	3:1 +20-25%	3307, 3309, 3310, 3315, 3320	5408	N/A	4.8	
Permaseal® Spectro Sealer 5450	5:1 +20-30%	3220, 3230, 3240, 3245	5408	15-30% 9050	4.8	9050 must be added before hardener.
Permaseal® Spectro Sealer 5450 Elastified	4:1 +20-30%	3220, 3230, 3240, 3245	5408	15-30% 9050	4.8	9050 must be added before hardener.
Permaseal® Vario Surface 5500	3:1 +4/-10-15%	3307, 3309, 3310, 3315, 3320, 3325	8590, 3363, 3365	N/A	4.8	
Permaseal® Vario Surface 5500 Elastified	3:1 +1/-15%	3307, 3309, 3310, 3315, 3320, 3325	8590, 3363, 3365	+30% 9050	4.8	9050 must be added before hardener.
Permaseal® Vario Surface 5500	5:1 +10-20%	3220, 3230, 3240, 3245	8590, 3363, 3365	N/A	4.8	
Permaseal® Vario Surface 5500 Elastified	3:1 +1/-10-20%	3220, 3230, 3240, 3245	8590, 3363, 3365	+30% 9050	4.8	9050 must be added before hardener.
Permaseal® 1K UV Hardfast Primer Surface 6002 (Aerosol)	Ready to Use	N/A	N/A	N/A	N/A	Aerosol
Permaseal® 1K UV Hardfast Primer Surface 6002	Ready to Use	N/A	N/A	N/A	4.8	Non-Aerosol version
Primer-Sealers VOC Limit = 4.8 lb/gal (589 g/L)						
Permaseal® Spectra Surface 5400	2:1 +1/-20-30%	3307, 3309, 3310, 3315, 3320, 3325	5407	N/A	4.6	
Permaseal® Spectro Surface 5400 wPermaseal Reducer	2:1 +20-25%	3307, 3309, 3310, 3315, 3320, 3325	5407	+0-5% 8590, 3363, 3365	4.6	
Permaseal® Spectro Surface 5400 Elastified	3:1 +1/-20%	3307, 3309, 3310, 3315, 3320, 3325	5407	+30% 9050	4.6	9050 must be added before hardener.
Permaseal® Spectro Surface 5400 Elastified wPermaseal Reducer	2:1	3307, 3309, 3310, 3315, 3320, 3325	+20-25% 5407	+30% 9050	4.6	
Permaseal® Spectro Surface 5400	3:1 +1/-40%	3220, 3230, 3240, 3245	5407	N/A	4.6	
Permaseal® Spectro Surface 5400 Elastified wPermaseal Reducer	3:1	3220, 3230, 3240, 3245	+40-45% 5407	+0-5% 8590, 3363, 3365	4.6	
Permaseal® Spectro Sealer 5450	3:1 +20-25%	3307, 3309, 3310, 3315, 3320	5408, 5410	N/A	4.6	
Permaseal® Spectro Sealer 5450 Elastified	2:1 +20-25%	3307, 3309, 3310, 3315, 3320, 3325	5408, 5410	15-30% 9050	4.6	9050 must be added before hardener.
Permaseal® Spectro Sealer 5450	5:1 +20-30%	3220, 3230, 3240, 3245	5408, 5410	15-30% 9050	4.6	9050 must be added before hardener.
Permaseal® Spectro Sealer 5450 Elastified	4:1 +20-30%	3220, 3230, 3240, 3245	5408, 5410	15-30% 9050	4.6	9050 must be added before hardener.
Permaseal® 2K Sealer 5500	1:1	5500	N/A	N/A	4.6	
Permaseal® Vario Surface 5500 Elastified	3:1 +20%	3307, 3309, 3310, 3315, 3320, 3325	8590, 3363, 3365	30% 9050	4.6	9050 must be added before hardener.
Permaseal® Vario Surface 5500 Elastified	3:1 +10-20%	3220, 3230, 3240, 3245	8590, 3363, 3365	30% 9050	4.6	9050 must be added before hardener.
Single Stage Topcoats VOC Limit = 5.0 lb/gal (601 g/L)						
Permaseal® Ultra-Prime Surface 217	3:1 +1/-10-20%	3307, 3309, 3310, 3315, 3320, 3325	8590, 3363, 3365	N/A	5.0	
Permaseal® Automotive Topcoat Series 257 PP-1004 Rally Matte Black	4:1 +20%	3220, 3230, 3240, 3245	8590, 3363, 3365	+15% 9050	5.0	
Permaseal® Automotive Topcoat 257 Series PP-1002 Blue Black	4:1 +20%	3220, 3230, 3240, 3245	8590, 3363, 3365	+15% 9050	5.0	
Permaseal® Automotive Top Coat EP 1005 Warm Gray V0604b	4:1 +20%	3307, 3309, 3310, 3315, 3320, 3325	8590, 3363, 3365	+15% 9050	5.0	
Permaseal® Automotive Top Coat FP 1005 Warm Gray V0604N	4:1 +10%	3220, 3230, 3240, 3245	8590, 3363, 3365, 3384, 5409, 5410	+0-5% 8052, 8096	5.0	
2-stage Topcoat VOC Limit = 5.0 lb/gal (601 g/L) applied as a system 1-stage Topcoat VOC Limit = 4.1 lb/gal (504 g/L) applied as a system						
Basecoats: Must be used with specific clearcoats for compliance						
Permaseal® HS-TEC Base Coat	+10-30%	N/A	6050, 6051, 6052, 6053	N/A	5.0	
Permaseal® HS-TEC Base Coat w/ Hardeners	+6-10% +10-30%	3080	6050, 6051, 6052, 6053	N/A	5.0	
Permaseal® Base Coat Series 280285	+6-15%	N/A	6050	N/A	5.0	
Permaseal® Base Coat Series 280285	+6-10%	N/A	6050	N/A	5.0	
Permaseal® Base Coat Series 280285	+6-10%	9007	+10-20% 6050 or 0-10% 6002	N/A	5.0	
Permaseal® Base Coat Series 280295	+6-10%	N/A	3054, 3055, 3056	N/A	5.0	
Permaseal® FP2003	+15% +40-50%	3307, 3309, 3310, 3315, 3320, 3325	3054, 3054, 3056	N/A	5.0	
Permaseal® FP2003	+10% +45%	3220, 3230, 3240, 3245	3054, 3055, 3056	N/A	5.0	
Permaseal® Base Coat Series 293295 - GMW 15408	+15% +40%	3307, 3309, 3310, 3315, 3320, 3325	3054, 3055, 3056	N/A	5.0	
Permaseal® Base Coat Series 293295 - GMW 15409	+10% +40-50%	3220, 3230, 3240, 3245	3054, 3055, 3056	N/A	5.2	
Permaseal® Base Coat Series 293295 - High Temp/Humidity	+35% +15%	N/A	3056	9015	5.0	
Permaseal® 2K Diamond Midcoat MC 0001	See 9980 TDS for Mixing Recommendations	3307, 3309, 3310, 3315, 3320, 3325 or 3220, 3230, 3240, 3245	8590, 3363, 3365	+15% 9050	5.0	
Permaseal® 2K Transparent Red Midcoat MC 0002	See 9980 TDS for Mixing Recommendations	3307, 3309, 3310, 3315, 3320, 3325 or 3220, 3230, 3240, 3245	8590, 3363, 3365	+15% 9050	5.0	
Permaseal® 2K Transparent Blue Midcoat MC 0003	See 9980 TDS for Mixing Recommendations	3307, 3309, 3310, 3315, 3320, 3325 or 3220, 3230, 3240, 3245	8590, 3363, 3365	+15% 9050	5.0	
Permaseal® Transparent Midcoat 9100	1:1 +1-10%	3240, 3245	3363, 3365	9045, 9046, 9046, 9057, 9058	5.0	
Clearcoats: Must be used as a system with basecoats at under 5.0 lb/gal (600 g/L) 2-stage or 5.2 lb/gal (630 g/L) 3-stage for compliance						
Spies Hecker® HS Speed Clear Coat 8820	2:1	3251, 3254, 3259, 3262, 3267	N/A	N/A	5.2	Compliant when used with both 2 & 3-stage coating systems.
Permaseal® HS Clear Coat 8035	2:1 +1/-10%	3307, 3309, 3310, 3315, 3320, 3325	8590, 3363, 3365, 9025	N/A	5.0	Compliant when used in a 2-stage coating system.
Permaseal® HS Clear Coat 8035 Elastified	2:1 +1/-10%	3307, 3309, 3310, 3315, 3320, 3325	8590, 3363, 3365, 9025	+15-30% 9050	5.0	Compliant when used in a 2-stage coating system. 9050 must be added before hardener.
Permaseal® HS Clear Coat 8035	3:1 +1/-10-20%	3220, 3230, 3240, 3245	8590, 3363, 3365, 9025	N/A	5.0	Compliant when used with both 2 & 3-stage coating systems.
Permaseal® HS Clear Coat 8035 Elastified	3:1 +1/-10-20%	3220, 3230, 3240, 3245	8590, 3363, 3365, 9025	+15-30% 9050	5.0	Compliant when used with both 2 & 3-stage coating systems. 9050 must be added before hardener.
Permaseal® MS Express Clear Coat 8046	2:1 +10-20%	3307, 3309, 3310, 3315, 3320, 3325	8590, 3363, 3365, 9025	N/A	5.0	Compliant when used in a 2-stage coating system.
Permaseal® MS Express Clear Coat 8046 Elastified	2:1 +10-20%	3307, 3309, 3310, 3315, 3320, 3325	8590, 3363, 3365, 9025	+15-30% 9050	5.0	Compliant when used in a 2-stage coating system. 9050 must be added before hardener.
Permaseal® MS Express Clear Coat 8046	3:1 +10%	3220, 3230, 3240, 3245	8590, 3363, 3365, 9025	N/A	5.0	Compliant when used in a 2-stage coating system.
Permaseal® MS Express Clear Coat 8046 Elastified	3:1 +10%	3220, 3230, 3240, 3245	8590, 3363, 3365, 9025	+15-30% 9050	5.0	Compliant when used in a 2-stage coating system. 9050 must be added before hardener.
Permaseal® Low VOC Clear Coat 8096	3:2 +5%	3307, 3309, 3310, 3315, 3320	3363, 3365, 8590	N/A	5.0	Compliant when used with both 2 & 3-stage coating systems.
Permaseal® Low VOC Clear Coat 8096	2:1 +1/-10-20%	3220, 3230, 3240, 3245	3363, 3365, 8590	N/A	5.0	Compliant when used with both 2 & 3-stage coating systems.
Permaseal® Low VOC Clear Coat 8096 Elastified	3:2 + 5/-10%	3307, 3309, 3310, 3315, 3320, 3325	3363, 3365, 8590	+15-30% 9050	5.0	Compliant when used with both 2 & 3-stage coating systems. 9050 must be added before hardener.
Permaseal® Low VOC Clear Coat 8096 Elastified	2:1 +1/-20-25%	3220, 3230, 3240, 3245	3363, 3365, 8590	+15-30% 9050	5.0	Compliant when used with both 2 & 3-stage coating systems. 9050 must be added before hardener.
Permaseal® MS Clear Coat 8180	2:1	3307, 3309, 3310, 3315, 3320	N/A	N/A	5.0	Compliant when used in a 2-stage coating system.
Permaseal® MS Clear Coat 8180 Elastified	2:1	3307, 3309, 3310, 3315, 3320	N/A	+15-30% 9050	5.0	Compliant when used in a 2-stage coating system. 9050 must be added before hardener.
Permaseal® MS Clear Coat 8180	3:1 +10%	3220, 3230, 3240, 3245	8590, 3363, 3365, 9025	N/A	5.0	Compliant when used in a 2-stage coating system.
Permaseal® MS Clear Coat 8180 Elastified	3:1 +10%	3220, 3230, 3240, 3245	8590, 3363, 3365, 9025	+15-30% 9050	5.0	Compliant when used in a 2-stage coating system. 9050 must be added before hardener.
Permaseal® HS Diamond Clear Coat 8450	3:1 +10-20%	3240	8590, 3363, 3365	N/A	5.2	Compliant when used with both 2 & 3-stage coating systems.
Permaseal® HS Diamond Clear Coat 8450 - ASAP	2:1 +10-20%	3240	8590, 3363, 3365	+10% 9050	5.2	Compliant when used with both 2 & 3-stage coating systems. 9050 must be added before hardener.
Permaseal® HS Optimum Clear Coat 8600	3:1	3251, 3254, 3259, 3262, 3267	N/A	N/A	5.0	Only compliant if used in a 2-stage coating system with 280295 basecoat or with a 2 or 3-stage coating system and Permaseal® HS-TEC Basecoat.
Permaseal® HS Optimum Clear Coat 8600 Elastified	3:1 +10-20%	3251, 3254, 3259, 3262, 3267	8590, 3363, 3365, 9025	+15-30% 9050	5.2	Compliant when used with both 2 & 3-stage coating systems.
Permaseal® HS Optimum Clear Coat 8600	3:1 +10-20%	3220, 3230, 3240, 3245	8590, 3363, 3365, 9025	N/A	5.0	Only compliant if used in a 2-stage coating system with 280295 basecoat or with a 2 or 3-stage coating system and Permaseal® HS-TEC Basecoat.
Permaseal® HS Optimum Clear Coat 8600 Elastified	3:1 +10-20%	3220, 3230, 3240, 3245	8590, 3363, 3365, 9025	+15-30% 9050	5.2	Compliant when used with both 2 & 3-stage coating systems.
Permaseal® Matte Clear Coat Additive 8050 with 8035	See TDS 8062 for Mixing Recommendations				5.0	Refer to TDS for mixing instructions over both metal and plastic.
Specialty Coatings VOC Limit = 7.0 lb/gal (846 g/L)						
Adhesion Promoters						
Permaseal® Transparent Surface 8550	3:1 +20-30%	3307, 3309, 3310, 3315, 3320, 3325	8590, 3363, 3365	N/A	7.0	
Permaseal® Transparent Surface 8550	4:1 + 30%	3220, 3230, 3240, 3245	8590, 3363, 3365	N/A	7.0	
Permaseal® Vario Surface 8590	3:1 +20-30%	3307, 3309, 3310, 3315, 3320, 3325	8590, 3363, 3365	N/A	7.0	
Permaseal® Vario Surface 8590	5:1 +10-40%	3220, 3230, 3240, 3245	8590, 3363, 3365	N/A	7.0	
Elastomeric Coatings						
Permaseal® 1.1 Elastic Primer Surface 3300	1:1	3301	N/A	N/A	7.0	
Primer® Elastic Primer 3304	Ready to Use	N/A	N/A	N/A	7.0	
Primer® Elastic Primer 3304 (Aerosol)	Ready to Use	N/A	N/A	N/A	N/A	
Primer® Elastic Primer 4190	Ready to Use	N/A	N/A	N/A	7	