



**Wisconsin VOC Chart**  
**AUTOMOBILE REFINISHING OPERATIONS**  
**Natural Resources Chapter 422 Section 95**  
 Effective: 3/1/2013



Coating Category	lbs/U.S. gal Limit: VOC Less Water Less Exempts	
Solvent (Surface Cleaners)	0.42*	*VOC content value limit applies to Kenosha, Milwaukee, Ozaukee, Racine, Sheboygan, Washington, or Waukesha counties if VOC emissions from all industrial cleaning operations associated with automobile refinishing operations at the facility, before consideration of controls, equal or exceed 3 tons on a 12 consecutive month rolling basis.
Pretreatment Coating	6.5	
Primer / Primer Surfacer	4.8	
Primer Sealer	4.6	
Topcoat - Single-Stage	5.0	
Multi-Stage Topcoat 2-stage (BC/CC)	5.0	
Multi-Stage Topcoat 3 or more stage (BC/CC)	5.2	
Specialty Coatings	7.0	

Product Code & Name	Hardener/Activator	Reducer	Mix Ratio	VOC Content*
<b>Solvent (Surface Cleaners)</b>				<b>Limit:* 0.42 lbs/gal</b>
SU4901 Clean and Scuff Sponge	-	-	-	0.06 (7)
SWX350 H <sub>2</sub> O-SO-CLEAN™ Wax & Grease Remover	-	-	-	0.17
SX1005 Low VOC Wax and Grease Remover	-	-	-	0.42
SXA103 Multi Prep**	-	-	As is (aerosol)	5.88 (705)
SXA330 Wax & Grease Remover**	-	-	As is (aerosol)	5.77 (691)

\*See VOC content note in the Category VOC limit chart above

\*\*Under (2) EXEMPTIONS (f) allows "aerosol products if 160 fluid ounces or less of VOC-containing aerosol products are used per day"

Product Code & Name	Hardener/Activator	Reducer	Mix Ratio	Applied VOC Less Water Less Exempt
<b>Pretreatment Coatings</b>				<b>Limit: 6.5 lbs/gal</b>
P330-1100 Etch Primer	P330-1101	-	1:1	6.2
SXA1031 Etch Primer (aerosol)	-	-	RTS	N/A
<b>Primer Surfacer</b>				<b>Limit 4.8 lbs/gal</b>
P330-1300 Acrylic Surfacer	-	P830-2100	1:1	4.8
P330-1700 2K High Build Primer Surfacer	P315-3700	P830-20XX	4:1:1	4.66
<b>Primer Sealer</b>				<b>Limit: 4.6 lbs/gal</b>
P330-1200 Epoxy Primer	P330-1201	-	2:1	4.6
P330-1400 Synthetic Sealer	-	P830-20XX	4:1	4.6
P330-1600 2 Pack Primer Sealer	P315-3500	P830-20XX	8:2-3:1	4.6
<b>Single Stage Coating</b>				<b>Limit: 5.0 lbs/gal</b>
VA Acrylic Enamel	-	P830-20XX	4:1	5.0
VA Acrylic Enamel Activated	P315-3500	P830-20XX	16:1:4	5.0
VU 2-Pack Urethane	P315-3500	P830-20XX	8:1:2	5.0



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Product Code & Name	Hardener/Activator	Reducer	Mix Ratio	Applied VOC Less Water Less Exempt
<b>Multi Stage Topcoat</b>				<b>System VOC Limit<sup>1</sup>: 5.0 lbs/gal</b>
<b>Color Coating</b>				<b>Limit<sup>2</sup>: 6.3 lbs/gal</b>
VB Basecoat	-	P830-20XX	1:1	6.30
VBP Basecoat	-	P830-20XX	1:1	6.30
<b>Clear Coating</b>				<b>Limit<sup>2</sup>: 4.3 5 lbs/gal</b>
P390-4000 HS Clearcoat	P315-3511	P830-20XX	4:1:1	4.3
P390-4001 Rapid Clear	P315-3511	P830-20XX	4:1:1	4.3
P390-4003 Multi-Purpose Clear	P315-353X	-	4:1	4.18

<b>Coatings for Process Specific Purposes / Additives to Create Specialty Coatings<sup>3</sup></b>		<b>Limit 7.0 lbs/gal</b>
P330-1800 Plastics Primer	SXA1044 High Build Flexible Surfacer	
SX1056 Flexible Sealer	SXA1050 Plastic Adhesion Promoter	
SX1057 Flexible Surfacer	SU4901 Clean & Scuff Sponge	
SXA1030 Black Guide Coat	SU4902 Plastic Prep Wipe	
SXA1041 Bumper Black	SU4903/SUA4903 Advanced Plastic Bond	

1. The VOC limit on Tri-Coat and Quad-Coat Multi-Stage Systems is 5.2 lbs/gal.
2. The VOC of the BC/CC (Multi-stage) system is found by BC/CC composite calculation, where the  $VOC_{sys} = (VOC_{bc} + 2VOC_{cc}) / 3$ , as specified by current air quality regulations.
3. Specialty coatings include, but are not limited to, the listed products.

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