

# Transportation VOC Chart

For the State of Tennessee | Group 1 Vehicles : see note in footer



Rule 1200-03-18-.45 Commercial Motor Vehicle & Mobile Equipment Refinishing Operations

Revised: November 2019

Effective: March 1, 2013

Surface Cleaner VOC Limit   1.7 lbs./gal (208 g/L)						
CODE	DESCRIPTION	REMARKS	MIX RATIO			APPLIED VOC
107™	Low VOC Cleaner	Ready to use	-			0.2
130™	Cleaner	Ready to use	-			0.0
3821S™	Low VOC Cleaner	Ready to use	-			0.2
Specialty Coating VOC Limit   7.0 lbs./gal. (840 g/L) - shall not exceed 10% of all coatings applied on a weekly basis.						
CODE	DESCRIPTION	REMARKS	MIX RATIO	HARDENER	REDUCER	MAX APPLIED VOC (LE)
230S™	Adhesion Promoter		2:98	-	DI Water	7.0
231XS	Sanding Paste	Ready to use	-	-	-	7.0
3401S™	Blender	¥ - Note in footer	-	-	-	7.0
6650S™	Blender	¥ - Note in footer	16:1	15305S™/15309S™/294S™	-	7.0
830S™	Adhesion Promoter	Ready to use	-	-	-	7.0
Pretreatment VOC limit   6.5 lbs./gal. (780 g/L)						
CODE	DESCRIPTION	REMARKS	MIX RATIO	HARDENER	REDUCER	MAX APPLIED VOC (LE)
225S™	Aluminum Metal Cleaner - Step A		1:2	-	water	6.5
226S™	Aluminum Conversion Coating - Step B		RTS	-	-	0.0
235S™	Pretreatment		4:1	236S™	-	6.5
244S™	Pretreatment		RTS	-	-	6.5
250-S™	Pretreatment		1:1	255S™	-	6.5
5717S™	Pretreatment		1:2	-	water	6.5
5718S™	Pretreatment		RTS	-	-	0.0
CF-5717S™	Pretreatment		1:2	-	water	6.5
Primer / Primer-Surfacer VOC Limit   4.8 lbs./gal. (580 g/L)						
Other additives may be used. Consult technical data sheet for usage requirements.						
CODE	DESCRIPTION	REMARKS	MIX RATIO	HARDENER	REDUCER	MAX APPLIED VOC (LE)
1220S™	Primer		4:1	194S™	-	4.8
1480S™	Primer		4:1	1481S™ / 1489S™	-	4.8
RV400™	Rival™ Urethane Primer		6:1	RV128™ / RV135™	-	4.8
Primer-Sealer VOC Limit   4.6 lbs./gal. (550 g/L)						
Other additives may be used. Consult technical data sheet for usage requirements.						
CODE	DESCRIPTION	REMARKS	MIX RATIO	HARDENER	REDUCER	MAX APPLIED VOC (LE)
821CR™	DTM Primer		2:1	82XS	-	4.6
92XS	Primer		2:1	92XS	-	4.6
934S™	Primer Sealer		5:1	936S™	-	4.6
13X0S™	Primer Filler		4:1	194S™	-	4.6
185XS	Primer		4:1	1852S™	-	4.6
RV450™	Rival™ Epoxy Primer Sealer		4:1	RV455™	-	4.6
Single Stage Topcoat VOC Limit   5.0 lbs./gal. (600 g/L)						
Other additives may be used. Consult technical data sheet for usage requirements.						
QUALITY	DESCRIPTION	REMARKS	MIX RATIO	HARDENER	REDUCER	MAX APPLIED VOC (LE)
A	Centari® Single Stage Topcoat		8:1:2	793S™	80XXS	5.0
EA	Imron® Elite Single Stage Topcoat		3:1	194S™	-	5.0
EF	Imron® Elite Express Single Stage Topcoat		3:1	196S™	-	5.0
EU	Imron® Single Stage Topcoat		3:1	V-192S™	-	5.0
EX	Imron® Elite Productive Single Stage Topcoat		3:1 / 2.5:1	1530XS / 15309S™	-	5.0
EZ	Excel™ Pro Single Stage Urethane		4:1 / 2.5:1	1530XS / 15309S™	-	5.0
RV28/35	Rival™ Single Stage		6:1	RV128™ / RV135™	-	5.0
EX28	Imron® Elite Productive Single Stage Topcoat		3:1	15309S™	-	5.0
Multi-Stage Topcoat VOC Limit   5.2 lbs./gal. (630 g/L) - Other additives may be used, consult technical data sheet for usage. Must be used with specified clearcoats for compliance. Consult technical data sheet.						
QUALITY	DESCRIPTION	REMARKS	MIX RATIO	HARDENER	REDUCER	MAX APPLIED VOC (LE)
CT	Imron® Basecoat	¥ - Note in footer	4:1:12	15305S™/15309S™/294S™	66X5S	5.2
EW	Imron® Elite Productive Basecoat		3:1	1530XS	-	5.2
EB	Imron® Elite Basecoat		3:1	194S™	-	5.2
EG	Imron® Elite Express Basecoat		3:1	196S™	-	5.2
EK	Excel™ Pro Basecoat		4:1	1530XS	-	5.2
EY	Imron® Elite Productive Basecoat		3:1	294S™	-	5.2
Multi-Stage Topcoat VOC Limit   5.2 lbs./gal. (630 g/L) - Other additives may be used, consult technical data sheet for usage. Must be used with specified basecoats for compliance. Consult technical data sheet.						
CODE	DESCRIPTION	REMARKS	MIX RATIO	HARDENER	REDUCER	MAX APPLIED VOC (LE)
500S™	Clearcoat		3:1	V-192S™	-	5.2
8430S™	Clearcoat		2:1	1530XS	-	5.2
EZ-3460S™	Clearcoat		3:1	EZ-3461S™	-	5.2
3480S™	Clearcoat		3:1	194S™	-	5.2
3430S™	Clearcoat		3:1	1530XS	-	5.2
8460S™	Clearcoat		2:1	1530XS	-	5.2
8461S™	Clearcoat		2:1	1530XS	-	5.2
8821S™	Clearcoat		3:1	15309S™	-	5.2
8831S™	Clearcoat		3:1	15309S™/15310S™	-	5.2
8840S™	Clearcoat		3:1	194S™	-	5.2
8890S™	Clearcoat		3:1	294S™	-	5.2
RV500™	Rival Clearcoat		6:1	RV128™ / RV135™	-	5.2
Other components that may be used, please consult technical data sheet for usage and compliance. This list is not all-inclusive.						
CODE	DESCRIPTION	REMARKS	CODE	DESCRIPTION	REMARKS	
89S™	Pot Life Extender		19379S™	Application Enhancer		
X89S™	Accelerator		8989S™	Accelerator		
X59S™	Additive		V-2350S™	Flex Additive		
VGF70050	Anti-Cratering Additive		V-389S™	Accelerator		
			2350S™	Flex Additive		

Group 1 : Passenger cars, large truck cabs & chassis, light & medium duty trucks and vans, motor homes, recreational vehicles, and motorcycles.

Aerosol coating products exempt from Rule 1200-03-18-45

¥ Please see Technical Data Sheet for usage and mixing recommendation.

X = 1, 2, 3, 4, 5, 6, 7, 8

All VOC (LE) values listed are Maximum Ready-to-Spray in pounds per gallon

Axalta Coating Systems

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