

PG6 / 34 product category	Spies Hecker product to be used:	> April 1998 / April 2000 permitted VOC limit - (g/l)	Actual ready for use VOC (g/l)	Comments
Gunwash	Not supplied by SH	850	—	
Precleaner	Silicone Remover 7080	200	190	No mixing required
Primers / surfacers				
Etch Primer	1K Etch Primer 4080 grey	780	711	See note 1 below
Precoat	Permahyd Primer 4100 beige (waterborne)	250	177	
Primer surfacer	VHS Surfacers 5150 grey <i>HS Surfacers 5110</i>	250	233	See note 2 below
Non-sand / wet-on-wet Surfacer	EP-Thermo-Filler 5035 (waterborne) <i>Vario Surfacers 8590</i>	250	110	See note 3 below
Topcoats				
Single stage	HS Topcoat Series 270	420	c. 335 – 402 RFU VOC is 417 g/l (max)	Packaged VOC of tinters varies hence range.
Two stage / Three stage basecoat & clearcoat (WATERBORNE)	Permahyd Basecoat Series 280/285 + HS Clearcoat 8030	420	c. 252 – 407 HS 8030 is 420 Composite RFU VOC is 416 (max)	Packaged VOC of tinters varies hence range. VOC stated is composite as laid out in PG6 / 34
Special products				
	Plastics system (including Elastic Matt Clearcoat 8070)	840	c. 480 – 520	Mixed with a variety of other products before use
	Transparent Sealer 5180	840	601	
	Organic solvent degreasers	840	748	Silicone Remover 7010 "special product" category See note 4 below

Notes

1. Should not form more than 5% of total coating applied.
2. HS Surfacers 5110 (<540 g/l) may be re-introduced to this range if proposed changes to the primer surfacer VOC limits are ratified. Currently considered BATNEEC.
3. Vario Surfacers 8590 (<540 g/l) may be re-introduced to this range if proposed changes to the non-sand / wet-on-wet surfacer VOC limits are ratified. Currently considered BATNEEC.
4. Used for specific purpose of removing stubborn wax or grease contamination only.

3. Three stage topcoat (Permahyd Basecoat Series 280/285... and HS Clearcoat 8030)

Groundcoat

Highest VOC: WB817 407 g/l

Mix ratio 15:1 with VE Water 6000 (VOC 0 g/l). VOC of RFU basecoat = 407 g/l
(All less water as per PG6/34)

(Please note: WB817 would not be used as a groundcoat so exercise is theoretical)

Basecoat

Highest VOC: WB817 407 g/l

Mix ratio 15:1 with VE Water 6000 (VOC 0 g/l). VOC of RFU basecoat = 407 g/l
(All less water as per PG6/34)

(Please note: WB817 would not be used in isolation but only in mixture with other mixing colours)

Clearcoat

HS 8030 VOC: 372

Mix ratio 2:1 with HS Hardener 3340 (VOC 516 g/l)

Calculation:

$$2 \times 372 = 744 + 1 \times 516 = 1260 \text{ divided by } 3 (2+1) = 420 \text{ g/l}$$

Composite VOC (2 x RFU clearcoat VOC + 1 x groundcoat VOC + 1 x basecoat VOC divided by 3)

Calculation:

$$2 \times 420 = 840 + 1 \times 407 + 1 \times 407 = 1247 \text{ divided by } 4 = 413 \text{ g/l}$$

VOC data correct as of March 2002

Topcoat VOC calculations (worst case scenarios)**1. Single stage topcoat (HS Topcoat Series 270...**

Highest VOC: HG902 Deep Black – 367 g/l

Mix ratio 2:1 with HS Hardener 3340 (VOC 516 g/l)

Calculation:

$$2 \times 367 = 734 + 1 \times 516 = 1250 \text{ divided by } 3 (2+1) = 417 \text{ g/l}$$

(Please note: HG902 would not be used in isolation but only in mixture with other mixing colours)

2. Two stage topcoat (Permahyd Basecoat Series 280/285... and HS Clearcoat 8030)**Basecoat**

Highest VOC: WB817 407 g/l

Mix ratio 15:1 with VE Water 6000 (VOC 0 g/l). VOC of RFU basecoat = 407 g/l
(All less water as per PG6/34)

(Please note: WB817 would not be used in isolation but only in mixture with other mixing colours)

Clearcoat

HS 8030 VOC: 372

Mix ratio 2:1 with HS Hardener 3340 (VOC 516 g/l)

Calculation:

$$2 \times 372 = 744 + 1 \times 516 = 1260 \text{ divided by } 3 (2+1) = 420 \text{ g/l}$$

Composite VOC (2 x RFU clearcoat VOC + 1 x basecoat VOC divided by 3)

Calculation:

$$2 \times 420 = 840 + 1 \times 407 = 1247 \text{ divided by } 3 = 416 \text{ g/l}$$

SPIES HECKER PRODUCT OFFER

29th APRIL 2004

124

T-March 2004 VOC: 60 WATT (PCRN) 29-04-04

PROD REF NO	DESCRIPTION	SH ART. NO	PACK SIZE	VOC gm/ltr	Total VOC Used
NEW TECHNOLOGY					
280 Series - Base Coat (Permahyd)					
6707061A16	WB 800 New Effect	360.1800.7	1 ltr	69	0
6707060A16	WB 801 White	360.1801.5	1 ltr	99	792
6707062A16	WB 803 Special Black	360.1803.1	1 ltr	95	5795
6707064A16	WB 805 Ochre	360.1805.8	1 ltr	96	192
6707065A16	WB 807 Red Oxide	360.1807.4	1 ltr	99	99
6707065A16	WB 808 Ruby		1 ltr	87	87
6707067A17	WB 811 Red	360.1811.8	500 ml	52	104
6707068A16	WB 813 Coarse Silver	360.1813.9	1 ltr	112	112
6707069A16	WB 814 Silver	360.1814.7	1 ltr	115	2990
6707011A16	WB 816 Micro Silver	360.1816.3	1 ltr	117	1521
6707063A16	WB 817 Micro Silver	360.1817.1	1 ltr	105	1680
6707012A16	WB 818 Fine Silver	360.1818.0	1 ltr	114	4704
6707013A16	WB 820 Transparent Purple	360.1820.1	1 ltr	99	198
6707005A16	WB 821 Ochre Yellow		500ml	51	51
6707015A16	WB 822 Transparent Emerald	360.1822.8	1 ltr	91	910
6707016A17	WB 823 Transparent Reddish Yellow	360.1823.1	500 ml	43	43
6707017A16	WB 825 Transparent Black	360.1825.2	1 ltr	100	200
6707018A16	WB 827 Transparent Black	360.1827.9	1 ltr	90	180
6707019A16	WB 829 Transparent Brilliant Red	360.1829.5	1 ltr	86	258
6707020A16	WB 831 Transparent Oxide	360.1831.7	1 ltr	91	273
6707020A16	WB 835 Tinted		500ml	94	94
6707025A16	WB 837 Dark Blue	360.1837.0	1 ltr	59	712
6707026A16	WB 838 Transparent Green	360.1838.4	1 ltr	85	255
6707027A16	WB 842 Micro White	360.1842.2	1 ltr	76	352
6707028A16	WB 843 Granada Red	360.1843.0	1 ltr	87	261
6707029A17	WB 848 Bluish Green	360.1848.7	500 ml	46	46
6707030A16	WB 853 Azure Blue	360.1853.8	1 ltr	96	288
6707031A16	WB 854 Transparent Deep Blue	360.1854.6	1 ltr	85	1620
6707032A17	WB 856 Deep Purple	360.1856.8	500 ml	86	86
6707033A16	WB 857 Brilliant Fine Silver	360.1857.0	1 ltr	114	2964
6707064A16	WB 858 Brilliant Silver	360.1858.9	1 ltr	107	2782
6707034A16	WB 859 Brilliant Blue	360.1859.7	1 ltr	85	423
6707034A16	WB 861 Tinted		500ml	58	58
6707034A16	WB 871 pink pearl		500ml	58	58
6707034A16	WB 875 green		500ml	48	48
6707036A16	WB 877 Special Red	360.1877.5	1 ltr	94	94
6707062A17	WB 879 Brilliant Gold	360.1879.5	500 ml	113	280
6707037A16	WB 881 Maroon	360.1881.3	1 ltr	81	162
6707038A16	WB 882 Transparent Maroon	360.1882.1	1 ltr	83	498
	WB 889 curcume		500ml	58	116
	WB 8172 Black		1 ltr	93	950

TOTAL VOC

30938

285 Series - Pearl Base Coat (Permahyd)

6707042A16	WB 863 Pearl Hi-Line Blue	361.1863.0	1 ltr	107	321
	WB 864 Pearl Copper		500ml	115	58
6707045A16	WB 868 Pearl Lilac	361.1868.6	1 ltr	107	214
6707047A16	WB 870 Pearl Fine White	361.1870.2	1 ltr	113	226
6707049A16	WB 872 Pearl Green	361.1872.9	1 ltr	115	230
6707055A16	WB 891 Pearl White	361.1891.5	1 ltr	115	469
6707054A16	WB 892 Pearl Gold	361.1892.5	1 ltr	107	428
6707055A16	WB 893 Pearl Blue	361.1893.1	1 ltr	113	678
	WB 894 Pearl Red		1 ltr	107	214
6707057A16	WB 895 Pearl Ruby	361.1895.9	1 ltr	107	428
	WB 887 xirillie diamond		500ml	190	190
	WB 897 xirillie diamond		500ml	48	144
	WB 898 Diamond White Xirillie Pearl		500ml	97	97
6707050A17	WB 886 Pearl Platinum	361.1886.4	500 ml	107	162
6707051A17	WB 887 Pearl Fine Blue	361.1887.2	500 ml	110	174

TOTAL VOC

4024

Waterborne Associated Products

6705023A14	7080	Pre-cleaner	379.7080.3	5 ltr	156	7020
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TOTAL VOC

7020

NEW TECHNOLOGY

270 Series - 2K High Solid Tinters

6708000A16	HG 901 White	241.0901.0	1 ltr	349	2443
6708001A16	HG 902 Deep Black	241.0902.9	1 ltr	351	702
	HG 903 Tinter		1 ltr	361	361
	HG 906 Tinter		1 ltr	366	366
	HG 907 Tinter		1 ltr	382	762
	HG 913 Tinter		1 ltr	359	359
	HG 915 Tinter		1 ltr	374	374
6708009A16	HL 917 Blue	241.0917.7	1 ltr	362	362
	HL 918 Green		1 ltr	367	367
	HL 919 Brilliant Red		1 ltr	348	348
	HL 922 Tinter		1 ltr	367	367
	HL 928 Tinter		1 ltr	342	342
6708013A16	HL 925 Special Black	241.0925.8	1 ltr	375	750
	HG 936 Tinter		1 ltr	360	360

SPIES HECKER PRODUCT OFFER

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T-March 2004 VOC @WATERBORNE2964-04

PROD REF NO	DESCRIPTION	SH ART. NO	PACK SIZE	VOC gms/ltr	Total VOC Used
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TOTAL VOC 7883

Ready Mixed 1 Coat Conventional

Series 257		Solid colour		1ltr	504	2520
Series 293		Basecoat colour		1ltr	702	22815
Series 295		Pearlcoat colour		1ltr	702	0
G22-1		Solid Colour		1ltr	372	0
G55-1		Solid Basecoat colour		1ltr	700	0

TOTAL VOC 26335

Clear Coats

B704003A14	8030	CS Clear Coat	375.8030.2	5 ltr	372	90580
B704006A14	8040	MS Brilliant Clear Coat MS ONLY	375.8040.0	5 ltr	513	0
B704005A16	8070	Elastic Clear Coat	371.8070.3	1 ltr	509	1527

TOTAL VOC 100107

SPIES HECKER PRODUCT OFFER

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T-March 2003 VOC-GROW WATERBORNE 29/04/04

PROD REF NO	DESCRIPTION	SH ART. NO	PACK SIZE	VOC gms/ltr	Total VOC Used
Reducers					
G352-91	Glasure Thinners		1 ltr	876	0
6702008A14	3365 Reducer	370.3365.4	5 ltr	807	31745
6702009A14	6620 Mainline Reducer	375.6620.4	5 ltr	883	61910
6702007A14	8580 MS Duraplas	375.8580.0	5 ltr	878	13170
6702010A14	1035 Blend in Additive	371.1035.5	1 ltr	892	18732

TOTAL VOC 125457

Hardeners					
6701032A16	3035 MS Hardener	373.3035.8	1 ltr	633	0
6703015A14	3313 MS Express Hardener	375.3313.9	5 ltr	648	3240
6703016A18	3335 MS Express Hardener Fast	373.3335.0	2.5 ltr	614	22190
	3310 Permasolid hardener		2.5 ltr	1290	3670
	3315 Permasolid hardener		2.5 ltr	1280	16240
6703009A16	3307 HS Topcoat Hardener Extra Fast	371.3307.1	1 ltr	514	11822
6703006A14	3340 HS Hardener Fast	375.3340.1	5 ltr	517	49020

TOTAL VOC 100382

Primers					
6701027B14	4080-6 UK Each Primer Grey	373.4080.8	3 ltr	630	16450
6701027B14	4085-6 UK Each Primer Grey	373.4080.8	3 ltr	630	5634
6701028199	4085-8 UK Surfacer Aerosols	412.8869.6	400 ml	317	1744
6701023A16	5110 HS Primer Surfacer Beige	371.5110.0	1 ltr	360	0
6701023B14	5110 HS Primer Surfacer Beige	376.5110.6	3 ltr	560	14500
6701018999	7874 7119 One Pack Primer - Red Brown i Aerosol	412.7119.0	400 ml	324	8280
6701016B14	8389 Vario Surfacer	370.8389.5	3 ltr	454	23184

TOTAL VOC 54712

Plastic System					
6701024A16	3300 Elastic Primer Beige	371.3300.4	1 ltr	540	2160
6701025A16	3301 Elastic Hardener	371.3301.2	1 ltr	797	3985
	SA101 Coarse texture additive		1 ltr	553	553
6705033A16	MA100 Permasolid Elastic Matting Additive	371.0010.5	1 ltr	592	2308

TOTAL VOC 9066

Ancillaries					
6705021A14	7010 Silicone Remover	372.7010.2	5 ltr	747	4835
	8510 Anti-silicone		1 ltr	842	3368
6705027A14	9030 HS Accelerator	372.9030.8	5 ltr	745	25900

TOTAL VOC 77823

Gunwash					
PERSUD-25	Gun Cleaner		25 ltr	20750	664000

TOTAL VOC 1141250

TOTAL VOC for 6 MONTHS JULY-DECEMBER 2002

1683997

RETURNED WASTE SOLVENT

7WMS118	Waste Thinner		25 ltr		
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TOTAL VOC 1493873

TOTAL VOC RETURNED for 6 MONTHS JAN-MAY 2003

1493873

TOTAL VOC FOR 6 MONTHS JAN-MAY 2003

1493873