

1 TITLE 35: ENVIRONMENTAL PROTECTION  
2 SUBTITLE B: AIR POLLUTION  
3 CHAPTER I: POLLUTION CONTROL BOARD  
4 SUBCHAPTER c: EMISSIONS STANDARDS AND LIMITATIONS  
5 FOR STATIONARY SOURCES  
6

7 PART 219  
8 ORGANIC MATERIAL EMISSION STANDARDS AND LIMITATIONS  
9 FOR THE METRO EAST AREA  
10

11 SUBPART A: GENERAL PROVISIONS  
12

13 Section

- 14 219.100 Introduction
- 15 219.101 Savings Clause
- 16 219.102 Abbreviations and Conversion Factors
- 17 219.103 Applicability
- 18 219.104 Definitions
- 19 219.105 Test Methods and Procedures
- 20 219.106 Compliance Dates
- 21 219.107 Operation of Afterburners
- 22 219.108 Exemptions, Variations, and Alternative Means of Control or Compliance  
23 Determinations
- 24 219.109 Vapor Pressure of Volatile Organic Liquids
- 25 219.110 Vapor Pressure of Organic Material or Solvent
- 26 219.111 Vapor Pressure of Volatile Organic Material
- 27 219.112 Incorporations by Reference
- 28 219.113 Monitoring for Negligibly-Reactive Compounds  
29

30 SUBPART B: ORGANIC EMISSIONS FROM STORAGE AND LOADING OPERATIONS  
31

32 Section

- 33 219.119 Applicability for VOL
- 34 219.120 Control Requirements for Storage Containers of VOL
- 35 219.121 Storage Containers of VPL
- 36 219.122 Loading Operations
- 37 219.123 Petroleum Liquid Storage Tanks
- 38 219.124 External Floating Roofs
- 39 219.125 Compliance Dates
- 40 219.126 Compliance Plan (Repealed)
- 41 219.127 Testing VOL Operations
- 42 219.128 Monitoring VOL Operations
- 43 219.129 Recordkeeping and Reporting for VOL Operations

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SUBPART C: ORGANIC EMISSIONS FROM MISCELLANEOUS EQUIPMENT

Section

- 219.141 Separation Operations
- 219.142 Pumps and Compressors
- 219.143 Vapor Blowdown
- 219.144 Safety Relief Valves

SUBPART E: SOLVENT CLEANING

Section

- 219.181 Solvent Cleaning Degreasing Operations
- 219.182 Cold Cleaning
- 219.183 Open Top Vapor Degreasing
- 219.184 Conveyorized Degreasing
- 219.185 Compliance Schedule (Repealed)
- 219.186 Test Methods
- 219.187 Other Industrial Solvent Cleaning Operations

SUBPART F: COATING OPERATIONS

Section

- 219.204 Emission Limitations
- 219.205 Daily-Weighted Average Limitations
- 219.206 Solids Basis Calculation
- 219.207 Alternative Emission Limitations
- 219.208 Exemptions From Emission Limitations
- 219.209 Exemption From General Rule on Use of Organic Material
- 219.210 Compliance Schedule
- 219.211 Recordkeeping and Reporting
- 219.212 Cross-Line Averaging to Establish Compliance for Coating Lines
- 219.213 Recordkeeping and Reporting for Cross-Line Averaging Participating Coating Lines
- 219.214 Changing Compliance Methods
- 219.215 Wood Furniture Coating Averaging Approach
- 219.216 Wood Furniture Coating Add-On Control Use
- 219.217 Wood Furniture Coating and Flat Wood Paneling Coating Work Practice Standards
- 219.218 Work Practice Standards for Paper Coatings, Metal Furniture Coatings, and Large Appliance Coatings
- 219.219 Work Practice Standards for Aerospace Facilities, Automobile and Light-Duty Truck Assembly Coatings, and Miscellaneous Metal and Plastic Parts Coatings

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SUBPART G: USE OF ORGANIC MATERIAL

- Section
- 219.301 Use of Organic Material
- 219.302 Alternative Standard
- 219.303 Fuel Combustion Emission Units
- 219.304 Operations with Compliance Program

SUBPART H: PRINTING AND PUBLISHING

- Section
- 219.401 Flexographic and Rotogravure Printing
- 219.402 Applicability
- 219.403 Compliance Schedule
- 219.404 Recordkeeping and Reporting
- 219.405 Lithographic Printing: Applicability
- 219.406 Provisions Applying to Heatset Web Offset Lithographic Printing Prior to March 15, 1996 (Repealed)
- 219.407 Emission Limitations and Control Requirements for Lithographic Printing Lines
- 219.408 Compliance Schedule for Lithographic Printing On and After March 15, 1996 (Repealed)
- 219.409 Testing for Lithographic Printing
- 219.410 Monitoring Requirements for Lithographic Printing
- 219.411 Recordkeeping and Reporting for Lithographic Printing
- 219.412 Letterpress Printing Lines: Applicability
- 219.413 Emission Limitations and Control Requirements for Letterpress Printing Lines
- 219.415 Testing for Letterpress Printing Lines
- 219.416 Monitoring Requirements for Letterpress Printing Lines
- 219.417 Recordkeeping and Reporting for Letterpress Printing Lines

SUBPART Q: SYNTHETIC ORGANIC CHEMICAL AND  
POLYMER MANUFACTURING PLANT

- Section
- 219.421 General Requirements
- 219.422 Inspection Program Plan for Leaks
- 219.423 Inspection Program for Leaks
- 219.424 Repairing Leaks
- 219.425 Recordkeeping for Leaks
- 219.426 Report for Leaks
- 219.427 Alternative Program for Leaks
- 219.428 Open-Ended Valves

130	219.429	Standards for Control Devices
131	219.430	Compliance Date (Repealed)
132	219.431	Applicability
133	219.432	Control Requirements
134	219.433	Performance and Testing Requirements
135	219.434	Monitoring Requirements
136	219.435	Recordkeeping and Reporting Requirements
137	219.436	Compliance Date

138

139

**SUBPART R: PETROLEUM REFINING AND  
RELATED INDUSTRIES; ASPHALT MATERIALS**

140

141

142 Section

143	219.441	Petroleum Refinery Waste Gas Disposal
144	219.442	Vacuum Producing Systems
145	219.443	Wastewater (Oil/Water) Separator
146	219.444	Process Unit Turnarounds
147	219.445	Leaks: General Requirements
148	219.446	Monitoring Program Plan for Leaks
149	219.447	Monitoring Program for Leaks
150	219.448	Recordkeeping for Leaks
151	219.449	Reporting for Leaks
152	219.450	Alternative Program for Leaks
153	219.451	Sealing Device Requirements
154	219.452	Compliance Schedule for Leaks
155	219.453	Compliance Dates (Repealed)

156

157

**SUBPART S: RUBBER AND MISCELLANEOUS PLASTIC PRODUCTS**

158

159 Section

160	219.461	Manufacture of Pneumatic Rubber Tires
161	219.462	Green Tire Spraying Operations
162	219.463	Alternative Emission Reduction Systems
163	219.464	Emission Testing
164	219.465	Compliance Dates (Repealed)
165	219.466	Compliance Plan (Repealed)

166

167

**SUBPART T: PHARMACEUTICAL MANUFACTURING**

168

169 Section

170	219.480	Applicability
171	219.481	Control of Reactors, Distillation Units, Crystallizers, Centrifuges and Vacuum Dryers

172

173	219.482	Control of Air Dryers, Production Equipment Exhaust Systems and Filters
174	219.483	Material Storage and Transfer
175	219.484	In-Process Tanks
176	219.485	Leaks
177	219.486	Other Emission Units
178	219.487	Testing
179	219.488	Monitoring for Air Pollution Control Equipment
180	219.489	Recordkeeping for Air Pollution Control Equipment

181  
182                   SUBPART V: BATCH OPERATIONS AND AIR OXIDATION PROCESSES

183		
184	Section	
185	219.500	Applicability for Batch Operations
186	219.501	Control Requirements for Batch Operations
187	219.502	Determination of Uncontrolled Total Annual Mass Emissions and Actual
188		Weighted Average Flow Rate Values for Batch Operations
189	219.503	Performance and Testing Requirements for Batch Operations
190	219.504	Monitoring Requirements for Batch Operations
191	219.505	Reporting and Recordkeeping for Batch Operations
192	219.506	Compliance Date
193	219.520	Emission Limitations for Air Oxidation Processes
194	219.521	Definitions (Repealed)
195	219.522	Savings Clause
196	219.523	Compliance
197	219.524	Determination of Applicability
198	219.525	Emission Limitations for Air Oxidation Processes (Renumbered)
199	219.526	Testing and Monitoring
200	219.527	Compliance Date (Repealed)

201  
202                                   SUBPART W: AGRICULTURE

203		
204	Section	
205	219.541	Pesticide Exception

206  
207                                   SUBPART X: CONSTRUCTION

208		
209	Section	
210	219.561	Architectural Coatings
211	219.562	Paving Operations
212	219.563	Cutback Asphalt

213  
214                                   SUBPART Y: GASOLINE DISTRIBUTION

215

216	Section	
217	219.581	Bulk Gasoline Plants
218	219.582	Bulk Gasoline Terminals
219	219.583	Gasoline Dispensing Operations – Storage Tank Filling Operations
220	219.584	Gasoline Delivery Vessels
221	219.585	Gasoline Volatility Standards (Repealed)
222	219.586	Gasoline Dispensing Operations – Motor Vehicle Fueling Operations (Repealed)

223

224

SUBPART Z: DRY CLEANERS

225

226 Section

227	219.601	Perchloroethylene Dry Cleaners (Repealed)
228	219.602	Exemptions (Repealed)
229	219.603	Leaks (Repealed)
230	219.604	Compliance Dates (Repealed)
231	219.605	Compliance Plan (Repealed)
232	219.606	Exception to Compliance Plan (Repealed)
233	219.607	Standards for Petroleum Solvent Dry Cleaners
234	219.608	Operating Practices for Petroleum Solvent Dry Cleaners
235	219.609	Program for Inspection and Repair of Leaks
236	219.610	Testing and Monitoring
237	219.611	Exemption for Petroleum Solvent Dry Cleaners
238	219.612	Compliance Dates (Repealed)
239	219.613	Compliance Plan (Repealed)

240

241

SUBPART AA: PAINT AND INK MANUFACTURING

242

243 Section

244	219.620	Applicability
245	219.621	Exemption for Waterbase Material and Heatset-Offset Ink
246	219.623	Permit Conditions
247	219.624	Open-Top Mills, Tanks, Vats or Vessels
248	219.625	Grinding Mills
249	219.626	Storage Tanks
250	219.628	Leaks
251	219.630	Clean Up
252	219.636	Compliance Schedule
253	219.637	Recordkeeping and Reporting

254

255

SUBPART BB: POLYSTYRENE PLANTS

256

257 Section

258	219.640	Applicability
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259 219.642 Emissions Limitation at Polystyrene Plants  
 260 219.644 Emissions Testing

261  
 262 SUBPART FF: BAKERY OVENS

263  
 264 Section  
 265 219.720 Applicability (Repealed)  
 266 219.722 Control Requirements (Repealed)  
 267 219.726 Testing (Repealed)  
 268 219.727 Monitoring (Repealed)  
 269 219.728 Recordkeeping and Reporting (Repealed)  
 270 219.729 Compliance Date (Repealed)  
 271 219.730 Certification (Repealed)

272  
 273 SUBPART GG: MARINE TERMINALS

274  
 275 Section  
 276 219.760 Applicability  
 277 219.762 Control Requirements  
 278 219.764 Compliance Certification  
 279 219.766 Leaks  
 280 219.768 Testing and Monitoring  
 281 219.770 Recordkeeping and Reporting

282  
 283 SUBPART HH: MOTOR VEHICLE REFINISHING

284  
 285 Section  
 286 219.780 Emission Limitations  
 287 219.782 Alternative Control Requirements  
 288 219.784 Equipment Specifications  
 289 219.786 Surface Preparation Materials  
 290 219.787 Work Practices  
 291 219.788 Testing  
 292 219.789 Monitoring and Recordkeeping for Control Devices  
 293 219.790 General Recordkeeping and Reporting (Repealed)  
 294 219.791 Compliance Date  
 295 219.792 Registration (Repealed)  
 296 219.875 Applicability of Subpart BB (Renumbered)  
 297 219.877 Emissions Limitation at Polystyrene Plants (Renumbered)  
 298 219.879 Compliance Date (Repealed)  
 299 219.881 Compliance Plan (Repealed)  
 300 219.883 Special Requirements for Compliance Plan (Repealed)  
 301 219.886 Emissions Testing (Renumbered)

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SUBPART II: FIBERGLASS BOAT MANUFACTURING MATERIALS

- Section
- 219.890 Applicability
- 219.891 Emission Limitations and Control Requirements
- 219.892 Testing and Monitoring Requirements
- 219.894 Recordkeeping and Reporting Requirements

SUBPART JJ: MISCELLANEOUS INDUSTRIAL ADHESIVES

- Section
- 219.900 Applicability
- 219.901 Emission Limitations and Control Requirements
- 219.902 Testing Requirements
- 219.903 Monitoring Requirements
- 219.904 Recordkeeping and Reporting Requirements

SUBPART PP: MISCELLANEOUS FABRICATED PRODUCT  
MANUFACTURING PROCESSES

- Section
- 219.920 Applicability
- 219.923 Permit Conditions
- 219.926 Control Requirements
- 219.927 Compliance Schedule
- 219.928 Testing

SUBPART QQ: MISCELLANEOUS FORMULATION  
MANUFACTURING PROCESSES

- Section
- 219.940 Applicability
- 219.943 Permit Conditions
- 219.946 Control Requirements
- 219.947 Compliance Schedule
- 219.948 Testing

SUBPART RR: MISCELLANEOUS ORGANIC CHEMICAL  
MANUFACTURING PROCESSES

- Section
- 219.960 Applicability

- 345 219.963 Permit Conditions
- 346 219.966 Control Requirements
- 347 219.967 Compliance Schedule
- 348 219.968 Testing

349

350 SUBPART TT: OTHER EMISSION UNITS

351

- 352 Section
- 353 219.980 Applicability
- 354 219.983 Permit Conditions
- 355 219.986 Control Requirements
- 356 219.987 Compliance Schedule
- 357 219.988 Testing

358

359 SUBPART UU: RECORDKEEPING AND REPORTING

360

- 361 Section
- 362 219.990 Exempt Emission Units
- 363 219.991 Subject Emission Units

364

- 365 219.APPENDIX A List of Chemicals Defining Synthetic Organic Chemical and Polymer Manufacturing
- 366
- 367 219.APPENDIX B VOM Measurement Techniques for Capture Efficiency (Repealed)
- 368 219.APPENDIX C Reference Methods and Procedures
- 369 219.APPENDIX D Coefficients for the Total Resource Effectiveness Index (TRE) Equation
- 370 219.APPENDIX E List of Affected Marine Terminals
- 371 219.APPENDIX G TRE Index Measurements for SOCFI Reactors and Distillation Units
- 372 219.APPENDIX H Baseline VOM Content Limitations for Subpart F, Section 219.212 Cross-Line Averaging
- 373

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375 AUTHORITY: Implementing Section 10 and authorized by Sections 27, 28 and 28.5 of the  
 376 Environmental Protection Act [415 ILCS 5/10, 27, 28 and 28.5].

377

378 SOURCE: Adopted in R91-8 at 15 Ill. Reg. 12491, effective August 16, 1991; amended in R91-  
 379 24 at 16 Ill. Reg. 13597, effective August 24, 1992; amended in R91-30 at 16 Ill. Reg. 13883,  
 380 effective August 24, 1992; emergency amendment in R93-12 at 17 Ill. Reg. 8295, effective May  
 381 24, 1993, for a maximum of 150 days; amended in R93-9 at 17 Ill. Reg. 16918, effective  
 382 September 27, 1993 and October 21, 1993; amended in R93-28 at 18 Ill. Reg. 4242, effective  
 383 March 3, 1994; amended in R94-12 at 18 Ill. Reg. 14987, effective September 21, 1994;  
 384 amended in R94-15 at 18 Ill. Reg. 16415, effective October 25, 1994; amended in R94-16 at 18  
 385 Ill. Reg. 16980, effective November 15, 1994; emergency amendment in R95-10 at 19 Ill. Reg.  
 386 3059, effective February 28, 1995, for a maximum of 150 days; amended in R94-21, R94-31 and  
 387 R94-32 at 19 Ill. Reg. 6958, effective May 9, 1995; amended in R94-33 at 19 Ill. Reg. 7385,

388 effective May 22, 1995; amended in R96-2 at 20 Ill. Reg. 3848, effective February 15, 1996;  
 389 amended in R96-13 at 20 Ill. Reg. 14462, effective October 28, 1996; amended in R97-24 at 21  
 390 Ill. Reg. 7721, effective June 9, 1997; amended in R97-31 at 22 Ill. Reg. 3517, effective  
 391 February 2, 1998; amended in R04-12/20 at 30 Ill. Reg. 9799, effective May 15, 2006; amended  
 392 in R06-21 at 31 Ill. Reg. 7110, effective April 30, 2007; amended in R10-10 at 34 Ill. Reg. 5392,  
 393 effective March 23, 2010; amended in R10-8 at 34 Ill. Reg. 9253, effective June 25, 2010;  
 394 amended in R10-20 at 34 Ill. Reg. 14326, effective September 14, 2010; amended in R10-8(A) at  
 395 35 Ill. Reg. 496, effective December 21, 2010; amended in R11-23 at 35 Ill. Reg. 13676,  
 396 effective July 27, 2011; amended in R11-23(A) at 35 Ill. Reg. 18830, effective October 25, 2011;  
 397 amended in R12-24 at 37 Ill. Reg. 1722, effective January 28, 2013; amended in R13-18 at 38 Ill.  
 398 Reg. 1061, effective December 23, 2013; amended in R21-18 at 45 Ill. Reg. 3553, effective  
 399 March 4, 2021; amended in R25-25 at 50 Ill. Reg. \_\_\_\_\_, effective \_\_\_\_\_.

401 **SUBPART F: COATING OPERATIONS**

403 **Section 219.204 Emission Limitations**

405 Except as provided in Sections 219.205, 219.207, 219.208, 219.212, 219.215 and 219.216, an  
 406 owner or operator of a coating line must not apply at any time any coating in which the VOM  
 407 content exceeds the following emission limitations for the specified coating. Except as otherwise  
 408 provided in subsections (a), (c), (g), (h), (j), (l), (n), (o), (q), and (r), compliance with the  
 409 emission limitations marked with an asterisk in this Section is required on and after March 15,  
 410 1996, and compliance with emission limitations not marked with an asterisk is required until  
 411 March 15, 1996. The following emission limitations are expressed in units of VOM per volume  
 412 of coating (minus water and any compounds which are specifically exempted from the definition  
 413 of VOM) as applied at each coating applicator, except where noted. Compounds which are  
 414 specifically exempted from the definition of VOM should be treated as water for the purpose of  
 415 calculating the "less water" part of the coating composition. Compliance with this Subpart must  
 416 be demonstrated through the applicable coating analysis test methods and procedures specified in  
 417 Section 219.105(a) and the recordkeeping and reporting requirements specified in Section  
 418 219.211(c) except where noted. (Note: The equation presented in Section 219.206 must be used  
 419 to calculate emission limitations for determining compliance by add-on controls, credits for  
 420 transfer efficiency, emissions trades and cross-line averaging.) The emission limitations are as  
 421 follows:

a)	Automobile or Light-Duty Truck Coating	kg/l	lb/gal
	1) Prior to May 1, 2012:		
	A) Prime coat	0.14	(1.2)
		0.14*	(1.2)*
	B) Primer surface coat	1.81	(15.1)
		1.81*	(15.1)*

423  
 424 BOARD NOTE: The primer surface coat limitation is in units of kg (lbs) of  
 425 VOM per l (gal) of coating solids deposited. Compliance with the limitation must  
 426 be based on the daily-weighted average from an entire primer surface operation.  
 427 Compliance must be demonstrated in accordance with the topcoat protocol  
 428 referenced in Section 219.105(b)(1)(A) and the recordkeeping and reporting  
 429 requirements specified in Section 219.211(f). Testing to demonstrate compliance  
 430 must be performed in accordance with the topcoat protocol and a detailed testing  
 431 proposal approved by the Agency and USEPA specifying the method of  
 432 demonstrating compliance with the protocol. Section 219.205 does not apply to  
 433 the primer surface limitation.  
 434

C)	Topcoat	kg/l	lb/gal
		1.81	(15.1)
		1.81*	(15.1)*

435  
 436 BOARD NOTE: The topcoat limitation is in units of kg (lbs) of VOM per l (gal) of  
 437 coating solids deposited. Compliance with the limitation must be based on the daily-  
 438 weighted average from an entire topcoat operation. Compliance must be  
 439 demonstrated in accordance with the topcoat protocol referenced in Section  
 440 219.105(b)(1)(A) and the recordkeeping and reporting requirements specified in  
 441 Section 219.211(f). Testing to demonstrate compliance must be performed in  
 442 accordance with the topcoat protocol and a detailed testing proposal approved by  
 443 the Agency and USEPA specifying the method of demonstrating compliance with  
 444 the protocol. Section 219.205 does not apply to the topcoat limitation.  
 445

D)	Final repair coat	kg/l	lb/gal
		0.58	(4.8)
		0.58*	(4.8)*

446  
 447 2) On and after May 1, 2012, subject automobile and light-duty truck coating  
 448 lines must comply with the following limitations. These limitations must  
 449 not apply to materials supplied in containers with a net volume of 0.47  
 450 liters (16 oz) or less, or a net weight of 0.45 kg (1 lb) or less:  
 451

452 A) Electrodeposition primer (EDP) operations. For purposes of this  
 453 subsection (a)(2)(A), "electrodeposition" means a water-borne dip  
 454 coating process in which opposite electrical charges are applied to  
 455 the substrate and the coating. The coating is attracted to the  
 456 substrate due to the electrochemical potential difference that is  
 457 created.  
 458

kg VOM/l lb VOM/gal

	coating solids applied	coating solids applied
i) When solids turnover ratio ( $R_T$ ) is greater than or equal to 0.160	0.084	(0.7)
ii) When $R_T$ is greater than or equal to 0.040 and less than 0.160	$0.084 \times 350^{0.160-R_T}$	$(0.084 \times 350^{0.160-R_T} \times 8.34)$
B) Primer surfacer operations		
	kg VOM/l coating solids deposited	lb VOM/gal coating solids deposited
i) VOM content limitation	1.44	(12.0)
ii) Compliance with the limitation in subsection (a)(2)(B)(i) must be based on the daily-weighted average from an entire primer surfacer operation. Compliance must be demonstrated in accordance with the topcoat protocol referenced in Section 219.105(b)(1)(B) and the recordkeeping and reporting requirements specified in Section 219.211(f). Testing to demonstrate compliance must be performed in accordance with the topcoat protocol and a detailed testing proposal approved by the Agency and USEPA specifying the method of demonstrating compliance with the protocol. Section 219.205 does not apply to the primer surfacer limitation.		
C) Topcoat operations		
	kg VOM/l coating solids deposited	lb VOM/gal coating solids deposited
i) VOM content limitation	1.44	(12.0)
ii) Compliance with the limitation in subsection (a)(2)(C)(i) must be based on the daily-weighted average from an entire		

topcoat operation. Compliance must be demonstrated in accordance with the topcoat protocol referenced in Section 219.105(b)(1)(B) and the recordkeeping and reporting requirements specified in Section 219.211(f). Testing to demonstrate compliance must be performed in accordance with the topcoat protocol and a detailed testing proposal approved by the Agency and USEPA specifying the method of demonstrating compliance with the protocol. Section 219.205 does not apply to the topcoat limitation.

- D) Combined primer surfacer and topcoat operations
- |   | kg VOM/l<br>coating<br>solids<br>deposited | lb VOM/gal<br>coating solids<br>deposited |
|---|--|---|
| i) VOM content limitation   | 1.44                                       | (12.0)                                    |
| ii) Compliance with the limitation in subsection (a)(2)(D)(i) must be based on the daily-weighted average from the combined primer surfacer and topcoat operations. Compliance must be demonstrated in accordance with the topcoat protocol referenced in Section 219.105(b)(1)(B) and the recordkeeping and reporting requirements specified in Section 219.211(f). Testing to demonstrate compliance must be performed in accordance with the topcoat protocol and a detailed testing proposal approved by the Agency and USEPA specifying the method of demonstrating compliance with the protocol. Section 219.205 does not apply to the combined primer surfacer and topcoat limitation. |  |   |
- E) Final repair coat operations
- |  | kg/l<br>coatings | lb/gal<br>coatings |
|--|------------------|--------------------|
| i) VOM content limitation  | 0.58             | (4.8)              |
| ii) Compliance with the final repair operations limitation in subsection (a)(2)(E)(i) must be on an occurrence-weighted average basis, calculated in accordance with the equation below, in which clear coatings must have a weighting factor of 2 and all other coatings must have a weighting factor of 1. |                  |                    |

For purposes of this subsection (a)(2)(E)(ii), an "occurrence" is the application of the combination of coatings that constitute a final repair coat for a single automobile or light-duty truck. Section 219.205 does not apply to the final repair coat limitation.

459

460

$$VOM_{tot} = \frac{2VOM_{cc} + \sum_{i=1}^n VOM_i}{n + 2}$$

461

462

463

where:

$VOM_{tot}$  = Total VOM content of all coatings, as applied, on an occurrence weighted average basis, and used to determine compliance with this subsection (a)(2)(E).

$i$  = Subscript denoting a specific coating applied.

$n$  = Total number of coatings applied in the final repair operation, other than clear coatings.

$VOM_{cc}$  = The VOM content, as applied, of the clear coat used in the final repair operation.

$VOM_i$  = The VOM content of each coating used in the final repair operation, as applied, other than clear coatings.

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F) Miscellaneous Materials. For reactive adhesives subject to this subsection (a)(2)(F), compliance must be demonstrated in accordance with the methods and procedures set forth in appendix A to Subpart PPPP of 40 CFR 63, incorporated by reference in Section 219.112.

	kg/l	lb/gal
i) Glass bonding primer	0.90	(7.51)
ii) Adhesive	0.25	(2.09)
iii) Cavity wax	0.65	(5.42)
iv) Trunk sealer	0.65	(5.42)
v) Deadener	0.65	(5.42)

vi)	Gasket/gasket sealing material	0.20	(1.67)
vii)	Underbody coating	0.65	(5.42)
viii)	Trunk interior coating	0.65	(5.42)
ix)	Bedliner	0.20	(1.67)
x)	Weatherstrip adhesive	0.75	(6.26)
xi)	Lubricating wax/compound	0.70	(5.84)

471

b)	Can Coating	kg/l	lb/gal
1)	Sheet basecoat and overvarnish		
	A) Sheet basecoat	0.34	(2.8)
		0.26*	(2.2)*
	B) Overvarnish	0.34	(2.8)
		0.34	(2.8)*
2)	Exterior basecoat and overvarnish	0.34	(2.8)
		0.25*	(2.1)*
3)	Interior body spray coat		
	A) Two piece	0.51	(4.2)
		0.44*	(3.7)*
	B) Three piece	0.51	(4.2)
		0.51*	(4.2)*
4)	Exterior end coat	0.51	(4.2)
		0.51*	(4.2)*
5)	Side seam spray coat	0.66	(5.5)
		0.66*	(5.5)*
6)	End sealing compound coat	0.44	(3.7)
		0.44*	(3.7)*

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c) Paper Coating

1)	Prior to May 1, 2011:	kg/l 0.28	lb/gal (2.3)
2)	On and after May 1, 2011:	kg VOM/kg (lb VOM/lb) solids applied	kg VOM/kg (lb VOM/lb) coatings applied
A)	Pressure sensitive tape and label surface coatings	0.20	(0.067)
B)	All other paper coatings	0.40	(0.08)

3) The paper coating limitation in this subsection (c) does not apply to any owner or operator of any paper coating line on which flexographic, rotogravure, lithographic, or letterpress printing is performed if the paper coating line complies with the applicable emissions limitations in Subpart H. In addition, screen printing on paper is not regulated as paper coating, but is regulated under Subpart TT. On and after May 1, 2011, the paper coating limitation also does not apply to coating performed on or in-line with any digital printing press, or to size presses and on-machine coaters on papermaking machines applying sizing or water-based clays.

d) Coil Coating

kg/l	lb/gal
0.31	(2.6)
0.20*	(1.7)*

e) Fabric Coating

0.35	(2.9)
0.28*	(2.3)*

f) Vinyl Coating

0.45	(3.8)
0.28*	(2.3)*

g) Metal Furniture Coating

1)	Prior to May 1, 2011:	kg/l	lb/gal
A)	Air dried	0.34	(2.8)
B)	Baked	0.28	(2.3)
2)	On and after May 1, 2011:	kg/l	kg/l (lb/gal)

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	(lb/gal)	solids applied
A) General, One Component	0.275 (2.3)	0.40 (3.3)
B) General, Multi-Component		
i) Air dried	0.340 (2.8)	0.55 (4.5)
ii) Baked	0.360 (3.0)	0.61 (5.1)
C) Extreme High Gloss		
i) Air dried	0.340 (2.8)	0.55 (4.5)
ii) Baked	0.360 (3.0)	0.61 (5.1)
D) Extreme Performance		
i) Air dried	0.420 (3.5)	0.80 (6.7)
ii) Baked	0.360 (3.0)	0.61 (5.1)
E) Heat Resistant		
i) Air dried	0.420 (3.5)	0.80 (6.7)
ii) Baked	0.360 (3.0)	0.61 (5.1)
F) Metallic	0.420 (3.5)	0.80 (6.7)
G) Pretreatment Coatings	0.420 (3.5)	0.80 (6.7)
H) Solar Absorbent		
i) Air dried	0.420 (3.5)	0.80 (6.7)
ii) Baked	0.360	0.61

(3.0) (5.1)

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3) On and after May 1, 2011, the limitations in this subsection (g) do not apply to stencil coatings, safety-indicating coatings, solid-film lubricants, electric-insulating and thermal-conducting coatings, touch-up and repair coatings, or coating applications utilizing hand-held aerosol cans.

h) Large Appliance Coating

1)	Prior to May 1, 2011:	kg/l	lb/gal
	A) Air dried	0.34	(2.8)
	B) Baked	0.28	(2.3)
2)	On and after May 1, 2011:	kg/l (lb/gal)	kg/l (lb/gal) solids applied
	A) General, One Component	0.275 (2.3)	0.40 (3.3)
	B) General, Multi-Component		
	i) Air dried	0.340 (2.8)	0.55 (4.5)
	ii) Baked	0.275 (2.3)	0.40 (3.3)
	C) Extreme High Gloss		
	i) Air dried	0.340 (2.8)	0.55 (4.5)
	ii) Baked	0.360 (3.0)	0.61 (5.1)
	D) Extreme Performance		
	i) Air dried	0.420 (3.5)	0.80 (6.7)
	ii) Baked	0.360 (3.0)	0.61 (5.1)
	E) Heat Resistant		

	i) Air dried	0.420 (3.5)	0.80 (6.7)
	ii) Baked	0.360 (3.0)	0.61 (5.1)
F)	Metallic	0.420 (3.5)	0.80 (6.7)
G)	Pretreatment Coatings	0.420 (3.5)	0.80 (6.7)
H)	Solar Absorbent		
	i) Air dried	0.420 (3.5)	0.80 (6.7)
	ii) Baked	0.360	0.61

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3) The limitations in this subsection (h) do not apply to the use of quick-drying lacquers for repair of scratches and nicks that occur during assembly, provided that the volume of coating does not exceed 0.95 l (1 quart) in any one rolling eight-hour period. On and after May 1, 2011, these limitations also do not apply to stencil coatings, safety-indicating coatings, solid-film lubricants, electric-insulating and thermal-conducting coatings, touch-up and repair coatings, or coating applications utilizing hand-held aerosol cans.

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i)	Magnet Wire Coating	kg/l 0.20 0.20*	lb/gal (1.7) (1.7)*
j)	Prior to May 1, 2012: Miscellaneous Metal Parts and Products Coating		
	1) Clear coating	0.52 0.52*	(4.3) (4.3)*
	2) Extreme performance coating		
	A) Air dried	0.42 0.42*	(3.5) (3.5)*
	B) Baked	0.42 0.40*	(3.5) (3.3)*

3)	Steel pail and drum interior coating	0.52 0.52*	(4.3) (4.3)*
4)	All other coatings		
	A) Air dried	0.42 0.40*	(3.5) (3.3)*
	B) Baked	0.36 0.34*	(3.0) (2.8)*
5)	Metallic Coating		
	A) Air dried	0.42 0.42*	(3.5) (3.5)*
	B) Baked	0.36 0.36	(3.0) (3.0)*
6)	For purposes of subsection (j)(5), "metallic coating" means a coating which contains more than ¼ lb/gal of metal particles, as applied.		

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BOARD NOTE: On and after May 1, 2012, the limitations in Section 219.204(q) apply to this category of coating.

k)	Heavy Off-Highway Vehicle Products Coating	kg/l	lb/gal
	1) Extreme performance prime coat	0.42 0.42*	(3.5) (3.5)*
	2) Extreme performance topcoat (air dried)	0.42 0.42*	(3.5) (3.5)*
	3) Final repair coat (air dried)	0.42 0.42*	(3.5) (3.5)*
	4) All other coatings are subject to the emission limitations for miscellaneous metal parts and products coatings in subsection (j).		
l)	Wood Furniture Coating		
	1) Limitations before March 15, 1998:	kg/l	lb/gal
	A) Clear topcoat	0.67	(5.6)

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B)	Opaque stain	0.56	(4.7)
C)	Pigmented coat	0.60	(5.0)
D)	Repair coat	0.67	(5.6)
E)	Sealer	0.67	(5.6)
F)	Semi-transparent stain	0.79	(6.6)
G)	Wash coat	0.73	(6.1)

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BOARD NOTE: Prior to March 15, 1998, an owner or operator of a wood furniture coating operation subject to this Section must apply all coatings, with the exception of no more than 37.8 l (10 gal) of coating per day used for touch-up and repair operations, using one or more of the following application systems: airless spray application system, air-assisted airless spray application system, electrostatic spray application system, electrostatic bell or disc spray application system, heated airless spray application system, roller coating, brush or wipe coating application system, dip coating application system or high volume low pressure (HVLV) application system.)

2) On and after March 15, 1998, wood furniture sealers and topcoats must comply with one of the limitations specified in subsections (1)(2)(A) through (E):

		kg VOM/kg solids	lb VOM/lb solids
A)	Topcoat	0.8	(0.8)
B)	Sealers and topcoats with the following limits:		
	i) Sealer other than acid-cured alkyd amino vinyl sealer	1.9	(1.9)
	ii) Topcoat other than acid-cured alkyd amino conversion varnish topcoat	1.8	(1.8)
	iii) Acid-cured alkyd amino vinyl sealer	2.3	(2.3)
	iv) Acid-cured alkyd amino conversion varnish topcoat	2.0	(2.0)

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- 526 C) Meet the provisions of Section 219.215 for use of an averaging
- 527 approach;
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- 529 D) Achieve a reduction in emissions equivalent to the requirements of
- 530 subsection (1)(2)(A) or (B), as calculated using Section 219.216; or
- 531
- 532 E) Use a combination of the methods specified in subsections
- 533 (1)(2)(A) through (D).
- 534

3) Other wood furniture coating limitations on and after March 15, 1998:

		kg/l	lb/gal
A)	Opaque stain	0.56	(4.7)
B)	Non-topcoat pigmented coat	0.60	(5.0)
C)	Repair coat	0.67	(5.6)
D)	Semi-transparent stain	0.79	(6.6)
E)	Wash coat	0.73	(6.1)

4) Other wood furniture coating requirements on and after March 15, 1998:

- 535
- 536 A) A source subject to the limitations of subsection (1), (2) or (3) and
- 537 utilizing one or more wood furniture coating spray booths must not
- 538 use strippable spray booth coatings containing more than 0.8 kg
- 539 VOM/kg solids (0.8 lb VOM/lb solids), as applied.
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- 543 B) Any source subject to the limitations of subsection (1)(2) or (3)
- 544 must comply with Section 219.217.
- 545
- 546 C) Any source subject to the limitations of subsection (1)(2)(A) or (B)
- 547 and utilizing one or more continuous coaters, must for each
- 548 continuous coater, use an initial coating which complies with the
- 549 limitations of subsection (1)(2)(A) or (B). The viscosity of the
- 550 coating in each reservoir must always be greater than or equal to
- 551 the viscosity of the initial coating in the reservoir. The owner or
- 552 operator must:
- 553
- 554 i) Monitor the viscosity of the coating in the reservoir with a
- 555 viscosity meter or by testing the viscosity of the initial

- 556 coating and retesting the coating in the reservoir each time
- 557 solvent is added;
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- 559 ii) Collect and record the reservoir viscosity and the amount
- 560 and weight of VOM per weight of solids of coating and
- 561 solvent each time coating or solvent is added; and
- 562
- 563 iii) Maintain these records at the source for a period of three
- 564 years.
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m)	Prior to May 1, 2012: Plastic Parts Coating: Automotive/Transportation	kg/l	lb/gal
	1) Interiors		
	A) Baked		
	i) Color coat	0.49*	(4.1)*
	ii) Primer	0.46*	(3.8)*
	B) Air dried		
	i) Color coat	0.38*	(3.2)*
	ii) Primer	0.42*	(3.5)*
	2) Exteriors (flexible and non-flexible)		
	A) Baked		
	i) Primer	0.60*	(5.0)*
	ii) Primer non-flexible	0.54*	(4.5)*
	iii) Clear coat	0.52*	(4.3)*
	iv) Color coat	0.55*	(4.6)*
	B) Air dried		
	i) Primer	0.66*	(5.5)*
	ii) Clear coat	0.54*	(4.5)*
	iii) Color coat (red & black)	0.67*	(5.6)*

	iv)	Color coat (others)	0.61*	(5.1)*
3)		Specialty		
	A)	Vacuum metallizing basecoats, texture basecoats	0.66*	(5.5)*
	B)	Black coatings, reflective argent coatings, air bag cover coatings, and soft coatings	0.71*	(5.9)*
	C)	Gloss reducers, vacuum metallizing topcoats, and texture topcoats	0.77*	(6.4)*
	D)	Stencil coatings, adhesion primers, ink pad coatings, electrostatic prep coatings, and resist coatings	0.82*	(6.8)*
	E)	Head lamp lens coatings	0.89*	(7.4)*

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BOARD NOTE: On and after May 1, 2012, the limitations in Section 219.204(q) apply to this category of coating.

n)		Prior to May 1, 2012: Plastic Parts Coating: Business Machine	kg/l	lb/gal
	1)	Primer	0.14*	(1.2)*
	2)	Color coat (non-texture coat)	0.28*	(2.3)*
	3)	Color coat (texture coat)	0.28*	(2.3)*
	4)	Electromagnetic interference/radio frequency interference (EMI/RFI) shielding coatings	0.48*	(4.0)*
	5)	Specialty Coatings		
	A)	Soft coat	0.52*	(4.3)*
	B)	Plating resist	0.71*	(5.9)*
	C)	Plating sensitizer	0.85*	(7.1)*

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BOARD NOTE: On and after May 1, 2012, the limitations in Section 219.204(q) apply to this category of coating.

o) Flat Wood Paneling Coatings. On and after August 1, 2010, flat wood paneling

575 coatings must comply with one of the following limitations:

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577 1) 0.25 kg VOM/l of coatings (2.1 lb VOM/gal coatings); or

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579 2) 0.35 kg VOM/l solids (2.9 lb VOM/gal solids).

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581 BOARD NOTE: The Board has omitted subsection (p) and adopted a subsection (q) in  
 582 order to preserve consistent labeling with similar requirements in 35 Ill. Adm. Code 218.

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584 q) Miscellaneous Metal Parts and Products Coatings and Plastic Parts and Products  
 585 Coatings On and After May 1, 2012. On and after May 1, 2012, the owner or  
 586 operator of a miscellaneous metal or plastic parts coating line must comply with  
 587 the limitations in subsection (q). The limitations in subsection (q) do not apply to  
 588 aerosol coating products, powder coatings, or primer sealants and ejection  
 589 cartridge sealants used in ammunition manufacturing. Primer sealants and  
 590 ejection cartridge sealants are regulated under Subpart TT.

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592 1) Metal Parts and Products. For purposes of this subsection (q)(1),  
 593 "corrosion resistant basecoat" means a water-borne epoxy coating applied  
 594 via an electrodeposition process to a metal surface prior to spray coating,  
 595 for the purpose of enhancing corrosion resistance. The limitations in  
 596 subsection (q)(1) do not apply to stencil coats, safety-indicating coatings,  
 597 solid-film lubricants, electric-insulating and thermal-conducting coatings,  
 598 magnetic data storage disk coatings, and plastic extruded onto metal parts  
 599 to form a coating. The limitations in Section 219.219 apply to these  
 600 coatings unless specifically excluded.

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		kg VOM/l coating solids applied	lb VOM/gal coating solids applied
A)	General one component coating		
	i) Air dried	0.34 (2.8)	0.54 (4.52)
	ii) Baked	0.28 (2.3)	0.40 (3.35)
B)	General multi-component coating		
	i) Air dried	0.34	0.54

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		(2.8)	(4.52)
	ii) Baked	0.28 (2.3)	0.40 (3.35)
C)	Camouflage coating	0.42 (3.5)	0.80 (6.67)
D)	Electric-insulating varnish	0.42 (3.5)	0.80 (6.67)
E)	Etching filler	0.42 (3.5)	0.80 (6.67)
F)	Extreme high-gloss coating		
	i) Air dried	0.42 (3.5)	0.80 (6.67)
	ii) Baked	0.36 (3.0)	0.61 (5.06)
G)	Extreme performance coating		
	i) Air dried	0.42 (3.5)	0.80 (6.67)
	ii) Baked	0.36 (3.0)	0.61 (5.06)
H)	Heat-resistant coating		
	i) Air dried	0.42 (3.5)	0.80 (6.67)
	ii) Baked	0.36 (3.0)	0.61 (5.06)
I)	High performance architectural coating	0.42 (3.5)	0.80 (6.67)
J)	High temperature coating	0.42 (3.5)	0.80 (6.67)

K)	Metallic coating		
	i) Air dried	0.42 (3.5)	0.80 (6.67)
	ii) Baked	0.36 (3.0)	0.61 (5.06)
L)	Military specification coating		
	i) Air dried	0.34 (2.8)	0.54 (4.52)
	ii) Baked	0.28 (2.3)	0.40 (3.35)
M)	Mold-seal coating	0.42 (3.5)	0.80 (6.67)
N)	Pan backing coating	0.42 (3.5)	0.80 (6.67)
O)	Prefabricated architectural coating: multi-component		
	i) Air dried	0.42 (3.5)	0.80 (6.67)
	ii) Baked	0.28 (2.3)	0.40 (3.35)
P)	Prefabricated architectural coating: one-component		
	i) Air dried	0.42 (3.5)	0.80 (6.67)
	ii) Baked	0.28 (2.3)	0.40 (3.35)
Q)	Pretreatment coating	0.42 (3.5)	0.80 (6.67)

R)	Repair coats and touch-up coatings		
	i) Air dried	0.42 (3.5)	
	ii) Baked	0.36 (3.01)	
S)	Silicone release coating	0.42 (3.5)	0.80 (6.67)
T)	Solar-absorbent coating		
	i) Air dried	0.42 (3.5)	0.80 (6.67)
	ii) Baked	0.36 (3.0)	0.61 (5.06)
U)	Vacuum-metalizing coating	0.42 (3.5)	0.80 (6.67)
V)	Drum coating, new, exterior	0.34 (2.8)	0.54 (4.52)
W)	Drum coating, new, interior	0.42 (3.5)	0.80 (6.67)
X)	Drum coating, reconditioned, exterior	0.42 (3.5)	0.80 (6.67)
Y)	Drum coating, reconditioned, interior	0.50 (4.2)	1.17 (9.78)
Z)	Ammunition sealants		
	i) Air dried	0.42 (3.5)	0.80 (6.67)
	ii) Baked	0.36 (3.0)	0.61 (5.06)

AA)	Electrical switchgear compartment coatings		
	i) Air dried	0.42 (3.5)	0.80 (6.67)
	ii) Baked	0.36 (3.0)	0.61 (5.06)
BB)	All other coatings		
	i) Air dried	0.40 (3.3)	0.73 (5.98)
	ii) Baked: primer/topcoat	0.34 (2.8)	0.54 (4.52)

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2) Plastic Parts and Products: Miscellaneous. For purposes of this subsection (q)(2), miscellaneous plastic parts and products are plastic parts and products that are not subject to subsection (q)(3), (q)(4), (q)(5), or (q)(6). The limitations in subsection (q)(2) do not apply to touch-up and repair coatings; stencil coats applied on clear or transparent substrates; clear or translucent coatings; coatings applied at a paint manufacturing facility while conducting performance tests on the coatings; any individual coating category used in volumes less than 189.2 liters (50 gallons) in any one calendar year, if the total usage of all such coatings does not exceed 756.9 liters (200 gallons) per calendar year per source and substitute compliant coatings are not available; reflective coatings applied to highway cones; mask coatings that are less than 0.5 mm thick (dried) if the area coated is less than 25 square inches; electromagnetic interference/radio frequency interference (EMI/RFI) shielding coatings; and heparin-benzalkonium chloride (HBAC)-containing coatings applied to medical devices if the total usage of all such coatings does not exceed 378.4 liters (100 gallons) per calendar year per source. The limitations in Section 219.219 apply to these coatings unless specifically excluded.

		kg/l (lb/gal) coatings	kg/l (lb/gal) solids
A)	General one component coating	0.28 (2.3)	0.40 (3.35)

B)	General multi-component	0.42 (3.5)	0.80 (6.67)
C)	Electric dissipating coatings and shock-free coatings	0.80 (6.7)	8.96 (74.7)
D)	Extreme performance (2-pack coatings)	0.42 (3.5)	0.80 (6.67)
E)	Metallic coating	0.42 (3.5)	0.80 (6.67)
F)	Military specification coating		
	i) 1-pack coatings	0.28 (2.3)	0.54 (4.52)
	ii) 2-pack coatings	0.42 (3.5)	0.80 (6.67)
G)	Mold-seal coating	0.76 (6.3)	5.24 (43.7)
H)	Multi-colored coating	0.68 (5.7)	3.04 (25.3)
I)	Optical coating	0.80 (6.7)	8.96 (74.7)
J)	Vacuum-metalizing coating	0.80 (6.7)	8.96 (74.7)

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3) Plastic Parts and Products  
Automotive/Transportation

		kg/l (lb/gal) coatings	kg/l (lb/gal) solids
A)	High bake coatings – interior and exterior parts		

	i) Flexible primer	0.54 (4.5)	1.39 (11.58)
	ii) Non-flexible primer	0.42 (3.5)	0.80 (6.67)
	iii) Basecoats	0.52 (4.3)	1.24 (10.34)
	iv) Clear coat	0.48 (4.0)	1.05 (8.76)
	v) Non-basecoat/clear coat	0.52 (4.3)	1.24 (10.34)
B)	Low bake/air dried coatings – exterior parts		
	i) Primers	0.58 (4.8)	1.66 (13.80)
	ii) Basecoat	0.60 (5.0)	1.87 (15.59)
	iii) Clear coats	0.54 (4.5)	1.39 (11.58)
	iv) Non-basecoat/clear coat	0.60 (5.0)	1.87 (15.59)
C)	Low bake/air dried coatings – interior parts		
	i) Color coat	0.38 (3.2)	0.67 (5.66)
	ii) Primer	0.42 (3.5)	0.80 (6.67)
D)	Touchup and repair coatings	0.62 (5.2)	2.13 (17.72)
E)	Specialty		

i)	Vacuum metallizing basecoats	0.66 (5.5)	2.62 (21.8)
ii)	Vacuum metallizing topcoats	0.77 (6.4)	6.06 (49.1)

F) Red, yellow, and black coatings: Subject coating lines must comply with a limit determined by multiplying the appropriate limit in subsections (q)(3)(A) through (q)(3)(C) by 1.15.

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4) Plastic Parts and Products: Business Machine. The limitations of this subsection (q)(4) do not apply to vacuum metallizing coatings, gloss reducers, texture topcoats, adhesion primers, electrostatic preparation coatings, stencil coats, and resist coats other than plating resist coats. The limitations in Section 219.219 apply to these coatings unless specifically excluded.

		kg/l (lb/gal) coatings	kg/l (lb/gal) solids
A)	Primers	0.35 (2.9)	0.57 (4.80)
B)	Topcoat	0.35 (2.9)	0.57 (4.80)
C)	Color coat (texture coat)	0.28 (2.3)	0.40 (4.80)
D)	Color coat (non-texture coat)	0.28 (2.3)	0.40 (4.80)
E)	Texture coats other than color texture coats	0.35 (2.9)	0.57 (4.80)
F)	EMI/RFI shielding coatings	0.48 (4.0)	1.05 (8.76)
G)	Fog coat	0.26 (2.2)	0.38 (3.14)

H)	Touchup and repair	0.35 (2.9)	0.57 (4.80)
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5) Pleasure Craft Surface Coatings

		kg/l (lb/gal) coatings	kg/l (lb/gal) solids
A)	Extreme high gloss coating – topcoat	0.60 (5.0)	1.88 (15.6)
B)	High gloss coating – topcoat	0.42 (3.5)	0.80 (6.7)
C)	Pretreatment wash primer	0.78 (6.5)	6.67 (55.6)
D)	Finish primer surfacer		
	Prior to January 1, 2014	0.60 (5.0)	1.88 (15.6)
	On and after January 1, 2014	0.42 (3.5)	0.80 (6.7)
E)	High build primer/surfacer	0.34 (2.8)	0.55 (4.6)
F)	Aluminum substrate antifoulant coating	0.56 (4.7)	1.53 (12.8)
G)	Other substrate antifoulant coating	0.40 (3.3)	0.73 (5.8)
H)	Antifouling Sealer/Tie Coat	0.42 (3.5)	0.80 (6.7)
I)	All other pleasure craft surface coatings for metal or plastic	0.42 (3.5)	0.80 (6.7)

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6) Motor Vehicle Materials

	kg/l (lb/gal) coatings
A) Cavity wax	0.65 (5.42)
B) Sealer	0.65 (5.42)
C) Deadener	0.65 (5.42)
D) Gasket/gasket sealing material	0.20 (1.67)
E) Underbody coating	0.65 (5.42)
F) Trunk interior coating	0.65 (5.42)
G) Bedliner	0.20 (1.67)
H) Lubricating wax/compound	0.70 (5.84)

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r) Aerospace Facilities. On and after July 1, 2021, the owner or operator of an aerospace facility must comply with the coating limitations in this subsection (r). The limitations in this subsection (r) do not apply to the following activities in which coating of aerospace components and vehicles may take place: research and development, quality control, laboratory testing, and electronic parts and assemblies (except for coating of completed assemblies). The limitations in this subsection (r) also do not apply to aerospace facility operations involving space vehicles or rework operations performed on antique aerospace vehicles or components. The coating limitations in subsections (r)(1) and subsection (r)(2) do not apply to ~~aerosol coatings, Department of Defense classified coatings, or the~~ use of separate formulations of primers, topcoats, and chemical milling maskants, or the use of separate formulations of aerospace specialty coatings, in volumes of less than 50 gallons per year, subject to a maximum exemption of 200 gallons for all such formulations applied annually. The coating limitations in subsection

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(r)(2) do not apply to aerosol coatings or Department of Defense classified coatings.

1) VOM Content Limitations for Primers, Topcoats, and Chemical Milling Maskants

		kg/l	lb/gal
A)	Aerospace primer	0.350	(2.9)
B)	Primer for general aviation rework facility	0.540	(4.5)
C)	Exterior primer for large commercial aircraft (components or fully assembled)	0.650	(5.4)
D)	Topcoat	0.420	(3.5)
E)	Topcoat for general aviation rework facility	0.540	(4.5)
F)	Self-priming topcoat for aerospace applications	0.420	(3.5)
G)	Self-priming topcoat for general aviation rework facility	0.540	(4.5)
H)	Chemical milling maskant, type I	0.662	(5.2)
I)	Chemical milling maskant, type II	0.160	(1.3)

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2) VOM Content Limitations for Aerospace Specialty Coatings

		kg/l	lb/gal
A)	Ablative coating	0.600	(5.0)
B)	Adhesion promoter for aerospace applications	0.890	(7.4)
C)	Adhesive bonding primer cured above 250 °F	1.030	(8.6)

D)	Adhesive bonding primer cured at or below 250 °F	0.850	(7.1)
E)	Aerospace flexible primer	0.640	(5.3)
F)	Aerospace pretreatment coating	0.780	(6.5)
G)	Antichafe coating	0.660	(5.5)
H)	Bearing coating	0.620	(5.2)
I)	Bonding maskant	1.230	(10.3)
J)	Caulking and smoothing compounds	0.850	(7.1)
K)	Chemical agent-resistant coating	0.550	(4.6)
L)	Clear coating for aerospace applications	0.720	(6.0)
M)	Commercial exterior aerodynamic structure primer	0.650	(5.4)
N)	Commercial interior adhesive	0.760	(6.3)
O)	Compatible substrate primer	0.780	(6.5)
P)	Corrosion prevention system	0.710	(5.9)
Q)	Critical use and line sealer maskant	1.020	(8.5)
R)	Cryogenic flexible primer	0.645	(5.4)
S)	Cryoprotective coating	0.600	(5.0)
T)	Cyanoacrylate adhesive	1.020	(8.5)
U)	Dry lubricative material for aerospace applications	0.880	(7.3)
V)	Electrostatic discharge and electromagnetic interference	0.800	(6.7)

coating

W)	Elevated temperature Skydrol-resistant commercial primer	0.740	(6.2)
X)	Epoxy-polyamide topcoat	0.660	(5.5)
Y)	Extrudable, rollable, or brushable sealant for aerospace applications	0.280	(2.3)
Z)	Fire-resistant interior coating	0.800	(6.7)
AA)	Flight test coatings: missile or single use aircraft	0.420	(3.5)
BB)	Flight test coatings: all other	0.840	(7.0)
CC)	Fuel tank adhesive for aerospace applications	0.620	(5.2)
DD)	Fuel tank coating for aerospace applications	0.720	(6.0)
EE)	High temperature coating	0.850	(7.1)
FF)	Insulation covering	0.740	(6.2)
GG)	Intermediate release coating	0.750	(6.3)
HH)	Lacquer	0.830	(6.9)
II)	Metallized epoxy coating	0.740	(6.2)
JJ)	Mold release coating for aerospace applications	0.780	(6.5)
KK)	Nonstructural adhesive for aerospace applications	0.360	(3.0)
LL)	Optical anti-reflective coating	0.750	(6.3)
MM)	Part marking aerospace coating	0.850	(7.1)

NN)	Radiation-effect or electric coating	0.800	(6.7)
OO)	Rain erosion-resistant coating	0.850	(7.1)
PP)	Rocket motor bonding adhesive	0.890	(7.4)
QQ)	Rocket motor nozzle coating	0.660	(5.5)
RR)	Rubber-based adhesive	0.850	(7.1)
SS)	Scale inhibitor	0.880	(7.3)
TT)	Screen print ink for aerospace applications	0.840	(7.0)
UU)	Seal coat maskant	1.230	(10.3)
VV)	Sprayable sealant for aerospace applications	0.600	(5.0)
WW)	Silicone insulation material	0.850	(7.1)
XX)	Solid film lubricant	0.880	(7.3)
YY)	Specialized function coating	0.890	(7.4)
ZZ)	Structural autoclavable adhesive for aerospace applications	0.060	(0.5)
AAA)	Structural nonautoclavable adhesive for aerospace applications	0.850	(7.1)
BBB)	Temporary protective coating for aerospace applications	0.320	(2.7)
CCC)	Thermal control coating for aerospace applications	0.800	(6.7)
DDD)	Wet fastener installation coating	0.675	(5.6)
EEE)	Wing coating	0.850	(7.1)

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(Source: Amended at 50 Ill. Reg. \_\_\_\_\_, effective \_\_\_\_\_)