



2363S™ LOW VOC MATTING ADDITIVE



GENERAL

DESCRIPTION

A low VOC matting additive designed to reduce gloss of Cromax® clearcoats where the clearcoat limit is 2.1 VOC.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS

- 2363S™ Low VOC Matting Additive
- Cromax® LE LE5100S™ Multi-Panel Clearcoat
- Cromax® LE LE5400S™ Snap Dry Clearcoat
- Cromax® LE LE5600S™ Air Dry Productive Clearcoat
- Cromax® Premier LE LE8300S™ Productive Clearcoat

Shake well before use. Mix 2363S™ with clearcoats as described below and mix well to achieve the desired level of gloss.

MIX RATIO

Mix by weight as indicated in the table. Cumulative weight in grams per pint.

Cromax® LE LE5100S™ Multi-Panel Clearcoat

	Flat (2-10 Gloss)	Low-Egg Shell (10-20 Gloss)	High-Egg Shell (20-30 Gloss)	Semi-Gloss (50-60 Gloss)
LE5100S™	81.3	93.0	112.3	136.2
2363S™	345.2	342.3	338.1	333.0
LE1175S™	508.3	506.2	502.9	498.6
LE1075S™	549.3	547.5	544.5	540.8

LE5100S™ with 2363S™ can be baked 10 minutes at 120°F (49°C). Time to assemble and time to deliver is the next day.

Cromax® LE LE5400S™ Snap Dry Clearcoat

	Flat (2-10 Gloss)	Low-Egg Shell (10-20 Gloss)	High-Egg Shell (20-30 Gloss)	Semi-Gloss (50-60 Gloss)
LE5400S™	125.2	135.0	151.1	186.8
2363S™	411.8	411.4	410.7	408.7
LE1170S™	542.4	541.3	539.5	535.5

LE5400S™ with 2363S™ can be baked 10 minutes at 120°F (49°C). Time to assemble and time to deliver is the next day.

Cromax® LE LE5600S™ Air Dry Productive Clearcoat

	Flat (2-10 Gloss)	Low-Egg Shell (10-20 Gloss)	High-Egg Shell (20-30 Gloss)	Semi-Gloss (50-60 Gloss)
LE5600S™	93.9	103.0	118.0	156.6
2363S™	381.7	381.9	381.9	382.2
LE5605S™	500.2	500.0	499.5	498.4
LE5675S™	541.4	540.6	539.4	536.3



LE5600S™ with 2363S™ can be baked 10 minutes at 120°F (49°C). Time to assemble and time to deliver is the next day.

Cromax® Premier LE LE8300S™ Productive Clearcoat

	Flat (2-10 Gloss)	Low-Egg Shell (10-20 Gloss)	High-Egg Shell (20-30 Gloss)	Semi-Gloss (50-60 Gloss)
LE8300S™	101.6	109.7	121.3	144.6
2363S™	364.5	361.5	357.6	350.1
LE1005S™	464.1	461.3	457.2	449.3
LE1075S™	546.3	545.5	544.3	542.0

LE8300S™ with 2363S™ can be baked 45 minutes at 140°F (60°C). Time to assemble and time to deliver is 2 hours after bake.

POT LIFE

30-60 minutes. Mix the appropriate amount of material for the job and clean equipment immediately after use.



APPLICATION

SUBSTRATES

Cromax® Pro Basecoat
 ChromaBase® Basecoat
 ChromaPremier® Basecoat

GUN SETUPS

Compliant

Gravity Feed: 1.2 mm-1.5 mm

HVLP

Gravity Feed: 1.2 mm-1.5 mm

Tips for Success

The gun setup used for the clearcoat can be used for 2363S™ in combination with the clearcoat.

AIR PRESSURE

Compliant

Gravity Feed: 27-32 psi at the gun.

HVLP

Gravity Feed: 7-10 psi at the gun.

Tips for Success

The air pressure used for the clearcoat can be used for 2363S™ in combination with the clearcoat.

APPLICATION

Apply 2 light medium coats without flash between coats. This technique will produce the most uniform gloss. You can add 5% Cromax® Premier LE LE1075S™ Reducer (1 ½ oz. per RTS quart) to the RTS product to improve application while maintaining VOC compliance.

Tips for Success

To achieve a uniform finish with consistent gloss on a routine basis:

- Keep film builds in the lower range of recommendations
- Allowing minimum flash times between coats
- Ensure consistent spray overlap during application
- Bake the clearcoat versus allowing it to air dry



Items that will impact final gloss are total clearcoat film build, bake temperature and bake schedule. A good practice is to prepare a spray out panel to evaluate the gloss position.

RECOATABILITY/RE-REPAIR

Allow overnight dry before performing re-repair operations.

CLEANUP

Clean spray equipment as soon as possible with a cleaner.



SANDING

The use of 2363S™ in clearcoat will slow dry times and cure times. Allow additional dry time before processing.



PHYSICAL PROPERTIES

All Values Ready To Spray

	LE5100S	LE5400S
Max. VOC (LE):	242 g/L (2.0 lbs./gal)	242 g/L (2.0 lbs./gal)
Max. VOC (AP):	122 g/L (1.0 lbs./gal)	128 g/L (1.1 lbs./gal)
Avg. Gal. Wt.:	1158 g/L (9.66 lbs./gal)	1142 g/L (9.53 lbs./gal)
Avg. Wt.% Volatiles:	63.4%	61.2%
Avg. Wt.% Exempt Solvent:	52.8%	50.0%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	49.1%	47.2%
Avg. Wt.% Water:	0.0%	0.0%

	LE5600S	LE8300S
Max. VOC (LE):	218 g/L (1.8 lbs./gal)	238 g/L (2.0 lbs./gal)
Max. VOC (AP):	111 g/L (.9 lbs./gal)	125 g/L (1.0 lbs./gal)
Avg. Gal. Wt.:	1144 g/L (9.55 lbs./gal)	1164 g/L (9.70 lbs./gal)
Avg. Wt.% Volatiles:	61.3%	62.2%
Avg. Wt.% Exempt Solvent:	51.7%	51.6%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	49.1%	47.8%
Avg. Vol.% Water:	0.0%	0.0%

Theoretical Coverage: 590 sq. ft. per RTS gallon at 1 mil.
 Recommended Dry Film Thickness: 1.8-2.2 mils in 2 coats
 Flash Point: Refer to the MSDS/SDS

VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.



SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS/SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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In Canada:
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