



# 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
- Cromax® EZ Basecoat
- Cromax® XP 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: 27-29 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

	<b>LE5100S</b>	<b>LE5400S</b>
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%
Solvent:		
Avg. Wt.% Water:	0.0%	0.0%

	<b>LE5600S</b>	<b>LE8300S</b>
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%
Solvent:		
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.



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## 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 the United States:**  
**1.855.6.AXALTA**  
**cromax.us**

**In Canada:**  
**1.800.668.6945**  
**cromax.ca**

