



PLAS-STICK® 2361S™ LOW VOC MATTING AGENT



GENERAL

DESCRIPTION

A matting agent designed for use in 2.1 VOC collision clears to reduce gloss. This product will maintain compliance 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

Plas-Stick® 2361S™ Low VOC Matting Agent
 Cromax® LE LE5100S™ Multi-Panel Clearcoat
 Cromax® LE LE5400S™ Snap Dry Clearcoat
 Cromax® Premier LE LE8300S™ Productive Clearcoat

Shake well before use. Mix 2361S™ Low VOC Matting Agent with clearcoats by cumulative weight (grams) as indicated in the tables below and mix well to achieve the desired level of gloss.

	Flat (2-10 Gloss)	Egg Shell (20-30 Gloss)	Semi-Gloss (50-60 Gloss)
LE5100S™	98	140	172
2361S™	581	585	590
LE1165S™	965	969	971
LE1075S™	1068	1064	1060
LE5400S™	148	209	268
2361S™	625	646	666
LE1170S™	960	976	992
LE1075S™	1067	1061	1056
LE8300S™	104	143	187
2361S™	588	589	593
LE1005S™	827	827	827
LE1075S™	1071	1069	1066

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 2361S™ Low VOC Matting Agent 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 2361S™ Low VOC Matting Agent in combination with the clearcoat.

APPLICATION

Apply 2 light medium coats. Do not flash between coats. This technique will produce the most uniform gloss.

Tips for Success

- Achieving a uniform finish with consistent gloss can be achieved on a routine basis. Keeping film builds in the lower range of recommendations, allowing minimum flash times between coats, consistency in spray overlap during application and baking the clear versus allowing it to air dry are items with the most benefit to a achieving a uniform finish.
- 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. Time to assemble will be next day even with a bake cycle. Use the standard bake cycle for the clearcoat.

CLEANUP

Clean spray equipment as soon as possible with cleaner.



DRY TIMES

SANDING

The use of 2361S™ Low VOC Matting Agent in clearcoat will slow dry times and cure times. Allow additional dry time before processing.

RECOATABILITY/RE-REPAIR

Allow overnight dry before performing re-repair operations.



PHYSICAL PROPERTIES

All Values Ready To Spray

	LE5100S™	LE5400S™	LE8300S™
Max. VOC (LE):	229 g/L (1.9 lbs./gal)	228 g/L (1.9 lbs./gal)	222 g/L (1.8 lbs./gal)
Max. VOC (AP):	119 g/L (1.0 lbs./gal)	119 g/L (1.0 lbs./gal)	111 g/L (.9 lbs./gal)
Avg. Gal. Wt.:	1122 g/L (9.36 lbs./gal)	1126 g/L (9.40 lbs./gal)	1140 g/L (9.51 lbs./gal)
Avg. Wt.% Volatiles:	59.3%	59.3%	60.5%
Avg. Wt.% Exempt Solvent:	48.8%	48.9%	50.9%
Avg. Wt.% Water:	0.0%	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	48.4%	48.6%	50.0%
Avg. Vol.% Water:	0.0%	0.0%	0.0%

Theoretical Coverage: 544 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 the United States:
1.855.6.AXALTA
cromax.us

In Canada:
1.800.668.6945
cromax.ca

