PRODUCT BULLETIN

August 2019

IMPULSE® 996 Series

Visual Effects Gel Coats

DESCRIPTION

IMPULSE® 996 Series gel coats are in-mold coatings for the marine and transportation industries. They are designed to create visual effects similar to popular automotive metallic and pearl finishes. IMPULSE® 996 Series gel coats use a three-layer application process to create a deep, rich, sparkling finish that enhances appearance. The layers are clear, visual effect and base color.

BENEFITS & FEATURES

- Unique visual effect
- Sparkling finish
- Deep, rich color
- Superior Weathering

IMPULSE® 996 Series gel coats meet the EPA National Emission Standards for Hazardous Air Pollutants (NESHAP) for the Boat Manufacturing Industry.

When IMPULSE® 996 Series gel coats are backed by IMEDGE® High Performance Barrier Coat (HPB), a durable, crack-resistant composite can be made that is suitable for applications with extended water exposure.

IMPULSE® 996 Series visual effects and base colors are available in coordinated colors reflecting popular automotive finishes. See MB-376 for a complete listing of colors offered.

PROPERTIES – LIQUID

Property[1]	Unit	Marine Clear 996CD100/ 996 CD105	Visual Effect	Base Color
Viscosity[2]	cps	3,100	3,100	2,750
Thix Index (2/20)	-	6.0	6.0	6.0
Gel Time	minutes	7 13	7, 13	12, 20
Hide	-	N/A	N/A	Most complete @ 20 mils
Color Match(CMC max ΔE)	-	N/A	N/A	0.30
Weight per Gallon	lbs/gal	8.60	8.50	10.6

1) All properties at 25°C/77°F unless otherwise noted
2) Brookfield Viscometer RVT Spindle #4 at 20 RPM
3) 100 g mass, 1.5% Luperox® DDM-9
4) 100 g mass, 2.5% Norox® MEKP-9
5) IMPULSE® Visual Effect gel coats are available with 100 g mass gel times of 7 minutes (1.5% Luperox® DDM-9) and 13 minutes (2.5% NOROX® MEKP-9) depending on color.
6) IMPULSE® Base Colors are available with 100 g mass gel times of 12 minutes (1.8% Luperox® DDM-9) and 20 minutes (2.0% NOROX® MEKP-9) depending on color.

APPLICATION

To create the effect, three layers must be applied: IMPULSE® Marine Clear, IMPULSE® Visual Effect and IMPULSE® Base Color. The layers may be applied wet-on-wet or can be allowed to film gel between applications. Each layer should be applied at 7-10 mils wet for a total gel coat thickness of 21-30 mils. Some Base Colors may require additional film thicknesses for hide. Refer to MB-376 IMPULSE® 996 Series Color Palette for color-specific hide recommendations. Films above 35 mils may pre-release, trap porosity, crack and are more subject to weathering discoloration. Films less than 21 mils may not cure properly, can be hard to patch, show more print-through, and be more susceptible to water blisters. For the Visual Effect Layer Polynt recommends using an LED light to verify coverage.

Delamination can occur if the gel coat is left in the mold overnight without a laminate being applied. Ideally, a laminate should be applied within 8 hours of gel coat application.

Each user must determine the suitability of this product to his/her particular mode of operation and intended end-use application. A Polynt representative will be available to assist in the proper selection of all Polynt-Reichhold products available for commercial use.

SHELF LIFE & STORAGE

The shelf life of IMPULSE® 996 Series is 120 days from the date of manufacture from Polynt. To maximize usage life and maintain optimum properties, resins and gel coats should be stored in the original closed container at temperatures below 23°C/73°F and away from ignition sources and sunlight. Keep containers sealed to prevent moisture pick-up and monomer loss.

RELATED LITERATURE

MB-403 IMPULSE® Patching Procedure

SAFETY & WARRANTY

To receive a copy of our safety and warranty information, please email safetyandwarranty@polynt.com.