PRODUCT BULLETIN

March 2026

POLYCOR® 948 Series

Enamel Gel Coats

DESCRIPTION

POLYCOR® 948 Series enamels are formulated to be used as topcoats on fiberglass laminates. POLYCOR® 948 enamels seal the laminate surface and provide a durable, cosmetically appealing finish.

POLYCOR® 948 Series enamels were primarily developed for marine applications; however, they may be used in many FRP applications where high performance characteristics are desired. Applications for POLYCOR® 948 enamels include marine hatch covers, bilge and storage areas, exterior of filament-wound parts such as tanks and booms, and camper shells.

POLYCOR® 948 Series enamels are available in white or any colors on the Polynt Gel Coat Color Card. Other colors are available upon request. POLYCOR® 948 Series can be made from isophthalic or ISO/NPG base resins.

BENEFITS & FEATURES

- Reduced laminate maintenance by sealing with a hard, tough, durable coating
- Improved laminate appearance with a cosmetically appealing flat finish
- Superior weathering properties
- Good water resistance characteristics
- Smoother sprayed film; less orange peel
- Tack-free cure

Enamels cannot be used in-mold like gel coats because they contain surfacing agents that may interfere with adhesion. Standard enamels should not be used for constant water immersion service due to potential water spotting and water blistering.

PROPERTIES – LIQUID

Property[1]	Unit	948 Series Colors	948 Series Whites	948 Series Brushables
Viscosity[2]	cps	11,000 – 20,000	15,000 – 21,000	18,000 – 23,000
Thix Index	-	5.0 – 8.0	5.5 – 7.5	6.0 – 9.0
Gel Time[3]	minutes	10 - 17	10 - 17	11 – 20
Tack Free/Dull Gloss Time	minutes	60 - 90	60 - 90	60 - 90
Adhesion Time	hours	4	4	4
Solvent Wipe Time	minutes	-	After overnight cure, slight color may be removed but surface will remain tack-free	
Sag Resistance	-	Good @ 20 mils	Good @ 20 mils	Good @ 20 mils
Hide	-	-	Generally complete at 10 mils	
Weight per Gallon	lbs/gal	10.0 – 10.8	10.5 – 11.0	10.0 – 11.0

1) All properties at 25°C/77°F unless otherwise noted
2) Brookfield Viscometer RVF Spindle #4 at 4 RPM
3) 1.8 % Arkema Luperox® DDM-9

APPLICATION

Refer to Polynt's Composites Applications Guide ("Cookbook") for equipment and application recommendations. 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 products available for commercial use.

SHELF LIFE & STORAGE

The shelf life of POLYCOR® 948 Series is 120 days from the date of manufacture from Polynt. Fast cure products (gel time less than 9.0 minutes) have a shelf life of 60 days. 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 PRODUCTS

PATCHAID® 970XJ037, 970X900, and 970XA014 – Resin based products that can be mixed into the gel coat to improve the working properties of spray patches.

SAFETY & WARRANTY

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