PRODUCT BULLETIN

July 2020

POLYCOR® 964 Series

MACT Compliant Isophthalic Gel Coats

DESCRIPTION

POLYCOR® 964 isophthalic gel coats are versions of Polynt Composites' popular POLYCOR® 944 Series that meet the EPA National Emission Standards for Hazardous Air Pollutants (NESHAP): Reinforced Composites Production. These products have a HAP content below 37%, the MACT requirement for colors in the Reinforced Plastics Industry.

POLYCOR® 964 isophthalic gel coats are available in a wide range of eye-appealing colors. Customer color matching is available on request.

BENEFITS & FEATURES

- Easy to spray
- Sag resistant
- Fast curing
- Reduced monomer losses into the air
- Blister resistance

PROPERTIES – LIQUID

Property (1)	Unit	964 Series
Viscosity (2)	cps	13,500
Thixotropic Index (3)	-	6.5
Gel Time (5)	minutes	13.5

1) All properties at 25°C/77°F unless otherwise noted
2) Brookfield Viscometer RV Spindle #4 at 4 RPM
3) Brookfield Viscometer RV Spindle #4 at 2/20 RPM
4) 1.8% Arkema Luperox® DDM-9

APPLICATION

POLYCOR® 964 Series gel coats are formulated for spray application. Brushing or rolling is not recommended.

Reds, yellows and dark blues may have low hiding power. Ask a Polynt Composites representative whether the red, yellow or blue selected requires a special application procedure (which would be increased film thickness in multiple applications).

A fiberglass part is the mirror image of the mold. A preventive maintenance program for molds is essential. This will minimize the repair work (sanding and buffing) needed on the fiberglass parts. Sanding and buffing can substantially reduce the durability of the gel coat.

These products (standard or fast cure) should not be used when temperature conditions are below 60°F, as curing may be adversely affected.

CAUTION

POLYCOR® 964 gel coats may not be compatible in the liquid state with other gel coats or resins. Spray and pumping equipment must be completely clean of these gel coats or resins before isophthalics can be used. Do not add any material, other than a recommended methyl ethyl ketone peroxide, to this product without the advice of a representative of Polynt Composites.

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-Reichhold products available for commercial use.

SHELF LIFE & STORAGE

The shelf life of standard cure POLYCOR® 964 Series is 120 days from the date of manufacture from Polynt. The shelf life of fast cure (gel time less than 9 minutes) POLYCOR® 964 Series is 60 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 PRODUCTS

Polynt recommends the use of PATCHAID® when patching POLYCOR® 964 Series gel coats. Options are as follows:

- Polynt's PATCHAID® 970XJ037, 970X900, 970XJ166 and 970XA014 – Resin based products that can be mixed into the gel coat to improve the working properties of spray patches.
- FC PATCHAID® 970C961 Fast Cure Spraycure™– Monomer based product that can be mixed into the gel coat to improve the working properties of spray patches or can be used as an overspray to seal the open side of spray patches.

SAFETY & WARRANTY

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