PRODUCT BULLETIN

February 2026

POLYCOR® 944 Series

Isophthalic Gel Coats

DESCRIPTION

These POLYCOR® 944 gel coats are formulated to meet the rigid requirements of transportation, boating, and sanitary applications. They have enabled customers to meet and surpass all requirements of the American National Standard for plastic bathtubs, shower receptors, and shower stalls, ANSI Z124.1, .2 -1995, Sec. 6.1.1.

POLYCOR® 944 gel coats are ready to use, easy to spray, sag resistant, fast-curing and require only the addition of the proper amount of an appropriate methyl ethyl ketone peroxide to cure.

POLYCOR® 944 isophthalic gel coats are available in a wide range of eye-appealing colors. Customer color matching is available on request. See Polynt's POLYCOR® 944W005 data sheet for standard white isophthalic gel coat.

BENEFITS & FEATURES

- Batch-to-batch consistency and uniformity from production utilizing Statistical Process Control (S.P.C) & Statistical Quality Control (S.Q.C) techniques
- Quality finishes
- Chemical/water resistance
- Good, gloss retention, weatherability, and resiliency
- Approved for Transportation, Marine, and Sanitary

PROPERTIES – LIQUID

Property (1)	Unit	944 White	944 Colors	944 Brushables
Viscosity (2)	cps	18,000	13,500	20,500
Thixotropic Index (3)	-	6.5	6.5	7.5
Gel Time (4)	minutes	13.5	13.5	17.5

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

APPLICATION

Proper mold maintenance is important. Although Polynt's POLYCOR® 944 gel coats have excellent patching properties, minimal repair work is always desirable. Sanding and compounding can hasten the chalking and loss of gloss of all gel coats.

Isophthalic gel coats are not compatible in the liquid state with ISO/NPG gel coats or ISO/NPG 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 Polynt representative.

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

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 standard cure POLYCOR® 944 is 120 days from the date of manufacture from Polynt. The shelf life of fast cure (gel time less than 9 minutes) POLYCOR® 944 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® 944 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.