PRODUCT BULLETIN
December 2020

STYPOL® 040-4985, 040-4988

Spray Granite Resins

DESCRIPTION

STYPOL® 040-4985 and 040-4988 are clear, light colored, acrylic modified, chemical resistant NPG isophthalic resins designed specifically for spray granite applications where the user incorporates granite effect fillers.

BENEFITS & FEATURES

- Good sprayability
- Excellent non-sagging properties when filled with granite effect fillers
- High clarity
- Light stabilized
- Good color retention

PROPERTIES – LIQUID

Property[1]	Unit	STYPOL® 040-4985	STYPOL® 040-4988
NVM	%	56	55.5
Viscosity[2]	cps	2,350	2,100
Thix Index	-	5.1	5.0
Gel Time[3]	minutes	12	5.5
Castable Time[4]	minutes	40	30

1) All properties at 25°C/77°F unless otherwise noted
2) Brookfield Viscometer RV Spindle #3 at 20 RPM.
3) 2.0% DDM-9
4) Castable refers to the point at which a gel coat film is ready to be cast upon.

APPLICATION

Do not add any material, other than the recommended methyl ethyl ketone peroxide, to this product without the advice of a of Polynt Composites representative.

STYPOL® 040-4985 and 040-4988 are acrylic modified ISO/NPG resins designed for applications using spray granite fillers. They are formulated with a very high thixotropic index for excellent suspension of granite particulates. When properly mixed, catalyzed, sprayed, and cured, STYPOL® 040-4985 and 040-4988 granite filled coatings will give the same finished surface qualities as cast solid surface.

Follow recommendations from the granite effect filler supplier when incorporating their filler into STYPOL® 040-4985 and 040-4988.

STYPOL® 040-4985 and 040-4988 resins filled with a granite effect filler can be sprayed behind a high-quality clear marble gel coat, such as STYPOL® 040-4917, or they can be sprayed as a solid surface coating to replicate solid surface appearance.

STYPOL® 040-4985 and 040-4988 resins filled with granite effect filler should be applied to a total thickness of 30-60 mils to ensure coverage. Gel time should be 8-20 minutes on the part to allow the material to flow while minimizing problems with filler settling. In order to prevent driving the granite effect fillers through the filled mix to the mold surface, spray at the minimum pressure. The filled mix can be sprayed through a cup gun using number 8 or number 9 tips.

Make sure catalyst is well dispersed in the resin. Cup gun pressure should be regulated at about 50 psi. Many marble manufacturers drill out the vacuum relief hole on the metal cap to 1/16-1/8″ to reduce vapor lock.

The filled mix can also be sprayed through a pressure pot spray system. Generally, an internal mix gun is best to ensure proper catalyst incorporation into the filled system. It is helpful to pre-wet and to purge the system when it will not be used for a long period (such as the end of the day) with STYPOL® 040-4985 and 040-4988 resin without the granite effect filler added. This will significantly reduce problems with line plugging.

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 STYPOL® 040-4985 and 040-4988 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 PRODUCTS

Polynt does not recommend addition of wax-containing additives when patching STYPOL® 040-4985 and 040-4988 gel coats. Options are as follows:

• FC PATCHAID® 970C961 Fast Cure Spraycure™– Monomer based product that 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.