PRODUCT BULLETIN

November 2020

POLYCOR® 969 Series

MACT Compliant Sanding Gel Coats

DESCRIPTION

POLYCOR® 969 Series sanding gel coats have been specifically formulated for use as a sanding substrate. Sanding gel coats are used for FRP parts that will be subsequently painted. They can used for room temperature and heated molding (RTM) applications. Customer experiences have proven that these products can be post-baked at temperatures up to 165˚F for as long as two hours. They are not intended (nor should they be used) as a surface coat for marine, tub/shower or swimming pool industries. They should not be used for water immersion service (boat hull, swimming pool, spa, water tank, etc.), even if painted.

POLYCOR® 969 Series sanding gel coats meet the EPA National Emission Standards for Hazardous Air Pollutants (NESHAP): Reinforced Composites Production. Some versions in the POLYCOR® 969 Series are formulated to meet South Coast Air Quality Management District (SCAQMD) Rule 1162.

BENEFITS & FEATURES

- Easy to spray
- Resistant to porosity, pinholes and sagging
- Easy to sand and prep for painting
- MACT Compliant (Low VOC's)
- Reduced monomer loss during spray creating less over-spray and 5-7% increase in film thickness compared to other gel coats
- Ready to use with only the addition of MEKP

PROPERTIES – LIQUID

Property[1]	Unit	POLYCOR® 969 Series Colors- Standard Cure	POLYCOR® 969 Series- Colors Fast Cure	POLYCOR® 969 Series- Whites	POLYCOR® 969 Series- Conductive Black
Viscosity[2]	cps	15,500[2]	16,500[2]	4,7509[3]	12,750[2]
Thix Index	-	6.5	6.0	5.5	5.5
Gel Time	minutes	12.5[4]	8.5[4]	13.5[4]	11.5[5]
Weight per Gallon	lbs	11.0	11.7	11.65	10.2
Electrical Resistance	kΩ	-	-	-	50

1) All properties at 25°C/77°F unless otherwise noted
2) Brookfield Viscometer RVF Spindle #4 at 4 RPM
3) Brookfield Viscometer RV Spindle #4 at 20 RPM
4) 1.8% Arkema Luperox® DDM-9
5) 1.8% United Initiators Norox® MEKP-9H

APPLICATION

POLYCOR® 969 Series sanding gel coats are not compatible in the liquid state with isophthalic gel coats or isophthalic resins. Spray and pumping equipment must be completely clean of these gel coats or resins before POLYCOR® 969 Series sanding gel coat can be used.

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

RTM
The recommended catalyst level range for proper cure is 1.0-2.0%.

- The common RTM molding temperature is 140°F. At 140°F, the gel time is very fast (less than 3 minutes). Changes in catalyst levels will not greatly affect gel time at temperatures above 100°F but will affect the cure. For proper cure, DO NOT use less than 1.0% MEKP. Because of the heated molds, fewer promoters are typically used and gel and cure times at room temperature are longer.

- Temperatures above 180°F may require a specialized catalyst/promotion system.

Lay-up, glass placement and/or resin injection time will vary depending on temperature. At temperatures in the 140°F range, the injection window is between 5-10 minutes. Note: When heated molds are used, the gel coat must be processed as soon as possible to prevent pre-release and poor adhesion.

Refer to Polynt 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® 969 Series is 120 days from the date of manufacture from Polynt. The shelf life of fast cure (gel time less than 9 minutes) POLYCOR® 969 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® 969 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.