PRODUCT BULLETIN

December 2020

POLYCOR® 970CK115

Inhibitor Solution

DESCRIPTION

POLYCOR® 970CK115 is an inhibitor solution used to extend the gel time of pre-promoted, unsaturated polyester gel coats. It is specifically formulated for use with gel coats used in room temperature cure processes including open molding, closed molding, and casting processes.

POLYCOR® 970CK115 should only be used by industrial or experienced users of polyester products. Polynt Composites does not advise, or recommend, the use of POLYCOR® 970CK115 by manufacturers without the advice of a representative of Polynt.

BENEFITS & FEATURES

- Designed to lengthen gel time of gel coats and resins
- Provides additional pot life where required

PROPERTIES – LIQUID

Property(1)	Unit	970CK115
Color	-	Light Amber
Specific Gravity	lbs/gal	8.0

1) All properties at 25°C/77°F unless otherwise noted

APPLICATION

Polynt Composites recommends that gel time adjustments, if necessary, be made through selection of an alternate gel coat product or through changes in catalyst level and/or type. Please contact Polynt for product recommendations or review your product's technical data sheet for catalyst recommendations. However, in some cases changing products or adjusting the catalyst is not possible or practical. In those cases, use POLYCOR® 970CK115 to extend gel time as follows.

***Note*:** These recommendations apply to room temperature cure, unsaturated polyester gel coats. For other materials please contact Polynt for recommendations.

***Note*:** The recommendations provided below are rules of thumb. Their accuracy will depend on a number of factors including the product type, initial gel time, age, temperature, catalyst type, catalyst level and ambient humidity. When used in applications with fiberglass reinforcement, the cure rate also depends on reinforcement content and laminate thickness as well as other factors. For these reasons, we recommend that customers check the cure rate in their plant.

Product Type	Initial Gel Time	POLYCOR® 970CK115 Addition	Approximate Gel Time Extension
Gel Coat	All	0.03% by weight	1 minute

For color sensitive products such as clear or pigmented gel coats, do not add more than 0.10% by weight POLYCOR® 970CK115. Over adjustment with POLYCOR® 970CK115 may affect color. For gel coats film cure could also be affected. Please contact your Polynt representative for alternate recommendations.

To add POLYCOR® 970CK115 to the gel coat start the mixing equipment. Use mixing equipment with sufficient horsepower (relative to container size) to achieve thorough circulation from top to bottom and out to the sides of the container. The agitator must be properly sized for the container and must allow for uniform mixing regardless of the liquid level in the container. Add the POLYCOR® 970CK115 to the vortex created by the mixer. Mix until thoroughly incorporated; 10 minutes is typically sufficient. Air bubbling should not be used for mixing. It is not effective and only serves as a potential source of water or oil contamination. Do not overmix as overmixing can break down the gel coat viscosity, increasing the tendency to sag.

After adding POLYCOR® 970CK115, wait a minimum of 30 minutes then check the gel time.

***Note*:** Gel times may continue to lengthen with time (overnight or after several days). Recheck gel times before 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-Reichhold products available for commercial use.

SHELF LIFE & STORAGE

The shelf life of POLYCOR® 970CK115 is 180 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.

SAFETY & WARRANTY

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