PRODUCT BULLETIN

August 2023

IMEDGE® FUSION®

193 and 197 Series

DESCRIPTION

FUSION® 193 and 197 Series gel coats are advanced, high-performance, in-mold coatings formulated for use in producing reinforced plastic parts. FUSION® 193 and 197 Series gel coats are pigmented products available in a wide range of colors from pastels to jet black. Custom color matching is available.

FUSION® 193 (HAP 33%) products are formulated to meet the NESHAP for Reinforced Composites Production and Boat Manufacturing. FUSION® 197 (HAP 37%) products are formulated to meet the NESHAP for Reinforced Composites Production. HAP 37% products may be used in marine applications if HAP content averaging allows the fabricator to meet permitted HAP and emission levels.

When FUSION® 193 and 197 Series gel coats are backed by IMEDGE® High Performance Barrier Coat (HPB), ARMORGUARD® vinyl ester barrier coat products, or ArmorStar® or HYDREX® vinyl ester skin resins, a durable osmotic, blister-resistant composite can be made that is suitable for applications with extended water exposure.

FUSION® 193 and 197 Series gel coats are durable and crack resistant. When used in combination with IMEDGE® HPB the resulting composite has exceptional crack resistance.

While offering these benefits, FUSION® 193 and 197 Series gel coats have retained the important construction and application qualities expected from Polynt Composites coatings, such as resistance to color separation and sag, consistent liquid properties, and more. These add up to higher quality appeal in FRP parts made with FUSION® 193 and 197 Series gel coat products.

BENEFITS & FEATURES

- Incredible depth of image
- Bold, rich, high gloss colors
- Superior blush resistance
- Excellent crack resistance
- Excellent weathering resistance
- Superior cosmetics
- User friendly application
- Resistant to sagging and porosity
- Excellent patch-ability

PROPERTIES – LIQUID

Property[1]	Unit	193 Series	197 Series
Viscosity[2]	cps	13,000	13,000
Thix Index[3]	-	5.0	5.0
Gel Time[4]	minutes	13.5	16
Lay-up Time	minutes	< 60	< 60
Weight per Gallon	lbs/gal	8.7-9.3, depending on color	8.7-9.3, depending on color
Hide (most formulations)	mils	Complete at 20	Complete at 20
Sag Resistance	mils	Good at 20	Good at 20

1) All properties at 25°C/77°F unless otherwise noted
2) Brookfield Viscometer RVF Spindle #4 at 4 RPM
3) Brookfield Viscometer RVF Spindle #4 at 2/20 RPM
4) 100 g mass, 1.8% Arkema Luperox® DDM-9

Reds, yellows and dark blues may have lower hiding power. Ask a Polynt representative whether your red, yellow or blue requires a special application procedure (e.g. increased film thickness through multiple applications).

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 products available for commercial use.

SHELF LIFE & STORAGE

The shelf life of standard cure FUSION® 193 and 197 Series gel coats is 120 days from the date of manufacture. Fast cure FUSION® 193 and 197 Series gel coats (gel time less than 9.0 minutes) have a shelf life of 60 days. 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

PATCHAID® 970XJ037 – Resin based aids for spray patching
FC PATCHAID® 970C961 SPRAYCURE™ - Overspray to improve patch cure

SAFETY & WARRANTY

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