PRODUCT BULLETIN

September 2025

POLYCOR® 998 Series Enamels

Enamel Topcoats

DESCRIPTION

POLYCOR® 998 Series enamels are formulated to be used as topcoats on fiberglass laminates. POLYCOR® 998 enamels seal the laminate surface and provide a durable, cosmetically appealing finish.

POLYCOR® 998 Series enamels were primarily developed for marine applications; however, they can be used in many FRP application where high performance characteristics are desired. Applications for POLYCOR® 998 enamels include marine hatch covers, bilge and storage areas, exterior of filament-wound parts such as tanks and booms, and camper shells.

POLYCOR® 998 Series enamels are available in clear, white, or any of the colors on the Polynt Gel Coat Color Card. Other colors are available upon request.

POLYCOR® 998 Series enamels meet the EPA National Emission Standards for Hazardous Air Pollutants (NESHAP) for both Marine Manufacturing and Reinforced Composites Production.

BENEFITS & FEATURES

- Reduced laminate maintenance by sealing with a hard, tough, durable coating
- Improved laminate appearance with a cosmetically appealing flat finish
- Superior weathering properties
- Good water resistance characteristics
- Smoother sprayed film; less orange peel
- Tack-free cure
- Reduced emissions due to lower HAP content and monomer suppression

Enamels cannot be used in-mold like gel coats, because they contain surfacing agents that may interfere with adhesion.

Standard enamels should not be used for constant water immersion service due to potential water spotting and water blistering.

PROPERTIES – LIQUID

Property[1]	Unit	POLYCOR 998 Series Colors	POLYCOR 998 Series Whites	POLYCOR 998 Series Brushables
Viscosity[2]	cps	3,550	4,750	20,500
Thix Index	-	5.0 – 7.0	4.5 – 6.5	5.2 – 7.6
Gel Time[3]	minutes	10.5 – 16.5	11.0 – 14.0	15 – 20
Sag Resistance	-	Good @ 20 mils	Good @ 20 mils	Good @ 20 mils
Hide	-	Typically complete @ 10 mils	Typically complete @ 10 mils	Typically complete @ 10 mils
Tack Free/Dull Gloss Time	minutes	45 – 60	45 – 60	45 – 60
Adhesion Time	hours	4	4	4
Solvent Wipe Time	-	After overnight cure, slight color may be removed but surface will remain tack free	After overnight cure, slight color may be removed but surface will remain tack free	After overnight cure, slight color may be removed but surface will remain tack free
Weight per Gallon	lbs/gal	9.97 – 0.27	11.31 – 11.61	11.32 – 11.62
Flash Point (Seta Closed Cup)	°C/°F	31/88	31/88	31/88

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

POLYCOR® 998 Series enamels are available in various colors and cure rates. Ask a Polynt representative about a specific formulation.

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

APPLICATION

POLYCOR® 998 Series enamels should be sprayed after the laminate has cured and while it still has a tacky surface. Glossy/resin rich laminates may cause the enamel to separate, sag, and have poor adhesion. Ensure that glossy areas are well sanded, then blow off the area and clean with solvent.

Tack-free laminates or laminates fabricated with resins containing a “wax surface” or “mold release” should be sanded before coating with POLYCOR® 998 Series enamel. Sand with rough sandpaper to remove all indications of wax or mold release, and then wash with solvent.

If a fleck coat or cobwebbing of POLYCOR® 998 Series enamel is desired over the base coat of enamel, it should be applied while the base coat is wet.

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 POLYCOR® 998 Series 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

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.

SAFETY & WARRANTY

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