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MEK/P POLYESTER RESIN CATALYST INFO

On the chart below catalyzing 500 ml of Polyester Resin at 1.5% at 20 C or 68 F will give you a pot life of approximately 15 min, with a gel time of about 45 min. For Gelcoat use about .25 % more MEKP.

The reaction can be sped up or slowed down by using more or less catalyst, but do not use less than .75% or more than 2.5%. For higher temperatures use less catalyst, and more at lower temperatures. Do not work below 10 C or 50F as the resin may not gel at all.

Actual pot life and gel time will also depend on humidity and resin volume as well as temperature. Larger volumes will kick faster and 2 oz or less may not gel at all.

A good rule of thumb is mix what you plan on using within 15 Min and get it out of the mixing container into a tray or onto the fiberglass within 5 minutes.

Catalyst Chart

Volume of Catalyst to Be Used with Polyester Resins
 Methyl Ethyl Ketone Peroxide-Percent by Weight

Resin ⁽¹⁾ Volume	1%			1.25%			1.5%			1.75%		
	Drop	cc	oz	Drop	cc	oz	Drop	cc	oz	Drop	cc	oz
4 ounce	32	1-1/4	1/32	40	1-1/2	3/64	48	1-3/4	1/16	56	2	1/16+
8 ounce	64	2-1/2	1/16	80	3	3/32	96	3-1/2	1/4	112	4	1/8+
1 Pint (16 oz.)	128	5	1/8	160	6	3/16	192	7	1/4	225	8	1/4+
1 Quart (32 oz.)		9	1/3		12	3/8		14	1/2		16	1/2+
1/2 Gal. (64 oz.)		18	2/3		24	3/4		28	1		32	1-1/8
1 Gal. (128 oz.)		37	1-1/4		47	1-1/2		56	2		65	2-1/8
5 Qt. (156 oz.)		46	1 5/8		58	2-7/8		70	2-1/2		81	2-3/4