



Polyester Resin Catalyst / Surfacing Wax / Styrene Gloss Additive Chart

Silmar 249B Polyester Resin Amount (oz)	ADD THIS AMOUNT OF CATALYST TO CURE RESIN				ADD SURFACING WAX TO MAKE HOTCOAT RESIN		ADD STYRENE & SURFACING WAX TO MAKE GLOSS RESIN	
	Catalyst (MEKP) 1% (oz)	Catalyst (MEKP) 1% (cc)	Catalyst (MEKP) 2% (oz)	Catalyst (MEKP) 2% (cc)	Hotcoat Resin Surfacing Wax Amount (oz)	Hotcoat Resin Surfacing Wax Amount (cc)	Gloss Resin Styrene Amount (oz)	Gloss Resin Styrene Amount (cc)
3	0.03	1	0.06	2	0.05	1	0.2	7
6	0.06	2	0.12	4	0.09	3	0.5	14
9	0.09	3	0.18	5	0.14	4	0.7	22
12	0.12	4	0.24	7	0.19	6	1.0	29
15	0.15	5	0.3	9	0.23	7	1.2	36
18	0.18	5	0.36	11	0.28	8	1.4	43
21	0.21	6	0.42	13	0.33	10	1.7	50
24	0.24	7	0.48	14	0.37	11	1.9	58
27	0.27	8	0.54	16	0.42	13	2.2	65
30	0.3	9	0.6	18	0.47	14	2.4	72
33	0.33	10	0.66	20	0.51	15	2.6	79
36	0.36	11	0.72	22	0.56	17	2.9	86
39	0.39	12	0.78	23	0.61	18	3.1	94
42	0.42	13	0.84	25	0.66	20	3.4	101
45	0.45	14	0.9	27	0.70	21	3.6	108
48	0.48	14	0.96	29	0.75	22	3.8	115
52	0.52	16	1.04	31	0.81	24	4.2	125
55	0.55	17	1.1	33	0.86	26	4.4	132
58	0.58	17	1.16	35	0.90	27	4.6	139
61	0.61	18	1.22	37	0.95	29	4.9	146
64	0.64	19	1.28	38	1.00	30	5.1	154
128	1.28	38	2.56	77	2.00	60	10.2	307
640	6.4	192	12.8	384	9.98	300	51.2	1536

Notes:

The MEKP Catalyst values are based on room temperature curing.

Use 1% MEKP Catalyst for Laminations / 2% MEKP for Hotcoats and Gloss

Temperatures above 90° F (32° C) use 1/2 recommended MEKP Catalyst amount

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