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Technical Sheet MEKP Ratio Chart Polyester Resin

Polyester resin cures by an exothermic (heat) reaction created by promoters (cobalt & amine) and activator Methyl Ethel Ketone Peroxide (MEKP). The reaction of polyester will occur at the thickest cross section sending out a wave of heat, which cures resin to a solid glass-like hardness. Temperature and moisture content can affect the rate of cure and the drying of part's surface. The resin's reaction starts with the addition of MEKP at 0.5% to 1.5 % (2 % for thin laminates). The ratio is dependant on air temperature, resin thickness, temperature of resin and mold. Fillers are added to help control peak exotherm, shrinkage, and cure rate. Unfilled resin can heat up to 300F resulting in cracking. Resins that create uncontrolled peak exotherm can exhibit wrinkles or alligator skin. Using lower levels of MEKP, preheating the mold surface, or both, can change this. In wet weather conditions, tacky surfaces may be exhibited by resin due to high humidity. Working in a controlled, dry-heated area should help resin to cure properly.

Available Sizes: 2oz and Pint (1 lb) Bottles Gallon—Will Call Only

Resin	MEKP 0.5%	MEKP 1%	MEKP 1.5%
1 oz	4 Drops	8 Drops	12 Drops
16 oz	64 Drops 2.25 Grams 2.5 cc	128 Drops 4.5 Grams 5 cc	6.75 Grams 7.5 cc
32 oz	4.5 Grams 5 cc	9 Grams 10 cc	13.5 Grams 15 cc
1 gallon	20 Grams 20 cc	40 Grams 40 cc	60 Grams 60 cc

Typical Properties: MEKP (RCHP-90)

Active Oxygen:	8.9 +/- .01%
Color and Form:	Colorless liquid
Specific Gravity @25C (77F):	1.155
Flash Point (SETA C.C.):	200F (93C)

THE INFORMATION AND DATA CONTAINED HEREIN ARE BASED ON INFORMATION WE BELIEVE RELIABLE. EACH USER OF THE MATERIAL SHOULD THOROUGHLY TEST ANY APPLICATION AND INDEPENDENTLY CONCLUDE SATISFACTORY PERFORMANCE BEFORE COMMERCIALIZING. SUGGESTIONS OF USES SHOULD NOT BE TAKEN AS INDUCEMENTS TO INFRINGE UPON ANY PARTICULAR PATENT.