



**P-19L  
POLYESTER  
LAMINATING RESIN  
SPRAYABLE  
UNFILLED, BLUE**

**PRODUCT BULLETIN**



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**DESCRIPTION**

P-19L POLYESTER LAMINATING RESIN is a rigid, low reactive, low viscosity, general purpose ORTHOPHTHALIC laminating resin system which is promoted for ambient temperature cure with the addition of Methyl Ethyl Ketone Peroxide (MEK-P). P-19L can be used in spray up or hand lay-up for fabrication and repair of marine applications, general FRP parts, splashes from models, trim skins, etc. The excellent handling properties, low viscosity (excellent wetting of the fiberglass substrate) and moderate open time with a color change after addition of catalyst that ensures proper mixing when hand mixed or sprayed. P19L also contains a surfacing agent to prevent air inhibition (tacky surface).

**APPLICATIONS BENEFITS**

Conforms to International Standards of Quality. Low exotherm which insures high production rate, SPC/SQC controlled ensuring consistent performance from batch to batch. Consistent gel times and cure at various catalyst levels. Excellent strength and toughness resulting in greater resistance to impact and thermal cracking.

**HANDLING CHARACTERISTICS @ 25°C/77°F**

Viscosity Brookfield Model LVF No. 3 Spindle @ 60 rpm (Test Method 18-021) .....	400 cps
Styrene Monomer (Test Method 18-021) .....	44.5%
Weight/Gallon, lbs (USM) (Test Method 18-030) .....	9.12 lbs/gal
Thixotropic Index, Minimum (Test Method 18-0210) .....	2.0
Gel Time, 1.25% MEK-P (by volume/minutes) (Test Method 18-050) .....	12 minutes
Time to Peak (Test Method 18-050) .....	21 minutes
Shelf Life (in original unopened containers) .....	1 year

**PHYSICAL PROPERTIES @ 25°C/77°F) CLEAR CASTING**

Hardness Barcol (ASTM D-2583-75) .....	46
Heat Distortion (ASTM D-648-72) .....	63°C/145°F
Tensile Strength (ASTM D-638-80) .....	9,000 psi
Tensile Elongation % @ break (ASTM D-638-80) .....	1.7%
Tensile Modulus (ASTM D-638-80) .....	5.9 x 10 <sup>5</sup> psi
Flexural Strength (ASTM D-790-80) .....	14,000 psi
Flexural Modulus (ASTM D-790-80) .....	5.8 x 10 <sup>5</sup> psi
Compressive Strength @ yield (ASTM D-695-80) .....	20,300 psi
Water Absorption after 24 hrs @ R.T. ....	0.11%
Water Absorption after 2 hrs @ 100°C .....	0.99%

**Note:** As with all polyesters, time and degree of cure is a function of catalyst concentration and of temperature. Therefore, usage should be maintained above 24°C (75°F) to ensure satisfactory results. Catalyst levels below 0.75% will result in extended cure and are not recommended.

**STORAGE**

To ensure maximum stability and maintain optimum resin properties, resins should be stored in closed containers maintained below 75° F (25°C) and away from heat sources and sunlight. All storage should conform to local fire and building codes. Drum stock should be stored away from all sources of flame or combustion. Inventory levels should be kept to a reasonable minimum with first-in first-out stock rotation.

**AS WITH ANY THIXOTROPIC RESIN, STRATIFICATION OF THE THIXOTROPE MAY OCCUR IN STORAGE. THEREFORE, AGITATING THE RESIN PRIOR TO USE IS RECOMMENDED.**

**CARE MUST BE TAKEN TO AVOID DIRECT MIXING OF ANY ORGANIC PEROXIDE WITH METAL SOAPS, AMINES, OR ANY OTHER POLYMERIZATION ACCELERATOR OR PROMOTOR AS VIOLENT DECOMPOSITION WILL RESULT!**

P-19L Tech/Revised 1/25/10  
Supercedes 6/7/06

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