

0234 SMC Low Shrink Polyester

Technical Data Sheet

Update : February 2019

Description :

0234 is a pigmented LS SMC reinforced with chopped glass fibres (25/50 mm).
0234 has a good mechanical behaviour.

Moulding features (*) :

	Unit		Test method
Reactivity			ISO 12114
• Moulding T°C :	°C	145	
• Thickness :	mm	3	
• Cure time :	s	36	
Density		1,82	ISO 1183
Shrinkage	%	0,12	NF EN 1842

(*) Compression moulding without flow

Use recommendations :

High temperature between 145°C and 160°C.
Pressure between 80 and 100 bars

Application :

Part for truck such as front panel, bumper

COMPOSITION

Product nature	Unit	Ratio
Glass fibres content	%	33
Resins content	%	28
Fillers content	%	36
Other products content	%	3

APPEARANCE

	Unit	
Rolls :	kg	600
SMC width :	cm	149
Material support :	-	PE
Surface weight :	kg/m ²	6
Colour		Black

MECHANICAL PROPERTIES WITHOUT FLOW AT 23 °C

Moulding conditions

Temperature	°C	145
Thickness	mm	3
Curing time	sec	54
Covering	%	100
Part size	mm	250X120
Layers		1

	Unit		Test method
Flexural test (*)			ISO 178
- Breaking stress	MPa	280	
- Elastic modulus	MPa	12500	
- Deviation at break	mm	4,5	
Impact test (Charpy)(**)	kJ/m ²	110	ISO 179
Tensile test (***)			ISO 527
- Breaking stress	MPa	90	
- Elastic modulus	MPa	13000	
- Elongation at break	%	1,6	

(*) Average on the 20 latest production batches

(**) Average on the 20 latest production batches

(***) Average on 5 production batches

MECHANICAL PROPERTIES WITH FLOW AT 23 °C

Moulding conditions

Temperature	°C	150/155
Thickness	mm	2,5
Curing time	sec	70
Covering	%	36
Part size	mm	700X300
Layers		2

	Unit	Perp/Para	Test method
Flexural test(*)			ISO 178
- Breaking stress	MPa	180/350	
- Elastic modulus	MPa	10500/13500	
- Deviation at break	mm	3,3/3,5	
Tensile test (**)			ISO 527
- Breaking stress	MPa	70/150	
- Elastic modulus	MPa	12000/15000	
- Elongation at break	%	1,5/1,7	

(*) Average on 2 production batches

(**) Average on 2 production batches

Mixt Composites Recyclables

ZI les îles Féray – BP 94 07302 Tournon-sur-Rhône
Tel. : +33 4 75 07 18 18 - Fax : +33 4 75 07 11 77

OTHER PROPERTIES

	<i>Unit</i>		<i>Test method</i>
HDT-A	°C	>230	ISO 75-2
Burning Speed	mm/min	<80	ISO3795/FMVS302

Reactivity :

The reactivity datas below are given as a technical information.

