

# 0610

## SMC Low Profile Polyester

### Technical Data Sheet

Update : January 2020

### Description :

0610 is a not pigmented SMC reinforced with chopped glass fibers (25 mm).

0610 is a class A general purpose SMC with good mechanical behaviour.

### Moulding features (\*) :

	Unit		Test method
Reactivity			ISO 12114
• Moulding T°C :	°C	145	
• Thickness :	mm	4,6	
• Cure time :	s	64	
Density		1,88	ISO 1183
Shrinkage	%	-0,04	NF EN 1842

(\*) Compression moulding without flow

### Use recommendations :

High temperature around from 145 to 160°C  
Pressure between 80 and 100 bars

### Application :

Body part for car such hatchback: outer and inner part

### COMPOSITION

Product nature	Unit	Ratio
Glass fibres content	%	25
Resins content	%	24
Fillers content	%	49
Other products content	%	2

### APPEARANCE

	Unit	
Rolls :	kg	600/1500
SMC width :	cm	150
Material support :	-	COEX
Surface weight :	kg/m <sup>2</sup>	4,8
Colour		Not pigmented

### MECHANICAL PROPERTIES WITHOUT FLOW AT 23 °C

Moulding conditions			
Temperature	°C	145	
Thickness	mm	4,7	
Curing time	sec	65	
Covering	%	100	
Part size	mm	250X120	
Layers		2	
	Unit		Test method
Flexural test (*)			
- Breaking stress	MPa	190	ISO 178
- Elastic modulus	MPa	11500	
- Deviation at break	mm	5,8	
Impact test (Charpy)(**)	kJ/m <sup>2</sup>	80	ISO 179
Tensile test (***)			
- Breaking stress	MPa	65	
- Elastic modulus	MPa	12000	
- Elongation at break	%	1,6	

(\*) Average on the 20 latest production

(\*\*) Average on the 20 latest production

(\*\*\*) Average on the 10 production

### MECHANICAL PROPERTIES WITH FLOW AT 23 °C

Moulding conditions			
Temperature	°C	150/155	
Thickness	mm	3	
Curing time	sec	100	
Covering	%	36	
Part size	mm	700X300	
Layers		4	
	Unit	Perp/Para	Test method
Flexural test(*)			
- Breaking stress	MPa	110/220	ISO 178
- Elastic modulus	MPa	10000/11500	
- Deviation at break	mm	2,3/3	
Tensile test (**)			
- Breaking stress	MPa	40/110	ISO 527
- Elastic modulus	MPa	11000/12500	
- Elongation at break	%	0,9/1,5	

(\*) Average on 1 production

(\*\*) Average on 1 production

#### Mixt Composites Recyclables

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**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.**

