

## 0612

### SMC Low Profile Polyester

#### Technical Data Sheet

Update : February 2019

#### Description :

0612 is a not pigmented SMC reinforced with chopped glass fibres (25 mm).

0612 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	
• Max exothermic time:	s	45	
Density		1,89	NFT 51063
Shrinkage	%	-0,02	NF EN 1842

(\*) Compression moulding without flow

#### Use recommendations :

High temperature between 145°C and 160°C.

Pressure between 80 and 100 bars.

Cure time 15 sec/mm at 145°C.

#### Application :

Body parts for car such as hatchback:outer and inner part

Body parts for truck such as front panel, deflector,...

#### COMPOSITION

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

#### APPEARANCE

	Unit	
Packaging :		Roll or cardboard box
SMC width :	cm	148
Material support :	-	COEX
Surface weight :	kg/m <sup>2</sup>	4,8
Colour		Natural

#### MECHANICAL PROPERTIES WITHOUT FLOW AT 23°C

##### Moulding conditions

Temperature	°C	145
Thickness	mm	4,6
Curing time	sec	70
Covering	%	100
Part size	mm	250X120
Layers		2

	Unit		Test method
Flexural test (*)			ISO 178
- Breaking stress	MPa	210	
- Elastic modulus	MPa	12000	
- Deviation at break	mm	5,6	
Impact test (Charpy)(**)	kJ/m <sup>2</sup>	80	ISO 179
Tensile test (***)			ISO 527
- Breaking stress	MPa	80	
- Elastic modulus	MPa	13000	
- Elongation at break	%	1,7	

(\*) Average on 20 industrial production

(\*\*) Average on 20 industrial production

(\*\*\*) Average on 5 industrial production

#### MECHANICAL PROPERTIES WITH FLOW AT 23°C

##### Moulding conditions

Temperature	°C	145/150
Thickness	mm	3
Curing time	sec	90
Covering	%	36
Part size	mm	700X300
Layers		3

	Unit	Perp/Para	Test method
Flexural test(*)			ISO 178
- Breaking stress	MPa	140/250	
- Elastic modulus	MPa	11000/13500	
- Deviation at break	mm	3,5/3,7	
Tensile test (**)			ISO 527
- Breaking stress	MPa	50/100	
- Elastic modulus	MPa	12000/14500	
- Elongation at break	%	1,0/1,3	

(\*) Average on 7 industrial production

(\*\*) Average on 7 industrial production

#### 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

	Unit		Test method
HDT-A	°C	>230	ISO 75-2
Burning Speed	mm/min	<80	ISO3795/FMVS302
CLTE	10 <sup>-6</sup> K	10 - 30	

### Reactivity :

The reactivity datas below are given as a technical information.

