

0615

SMC Low Profile Polyester

Technical Data Sheet

Update : December 2019

Description :

0615 is a not pigmented SMC reinforced with chopped glass fibers (25 mm).
8762-54 is a class A general purpose SMC with good mechanical behaviour and Low VOC Level.

Moulding features (*) :

	Unit		Test method
Reactivity			ISO 12114
• Moulding T°C :	°C	165	
• Thickness :	mm	4,6	
• Cure time :	s	45	
Density		1,90	ISO 1183
Shrinkage	%	0,00	NF EN 1842

(*) Compression moulding without flow

Use recommendations :

High temperature from 160 to 165°C under high pressure 80 to 100 bars

Application :

Body part for car such hatchback: inner part

COMPOSITION

Product nature	Unit	Ratio
Glass fibres content	%	25
Resins content	%	23
Fillers content	%	49
Other products content	%	3

APPEARANCE

	Unit	
Rolls :	kg	1500
SMC width :	cm	148
Material support :	-	COEX
Surface weight :	kg/m ²	4,8
Colour		Not pigmented

MECHANICAL PROPERTIES WITHOUT FLOW AT 23°C

Moulding conditions		
Temperature	°C	165
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	205
- Elastic modulus	MPa	12500
- Deviation at break	%	4,5
Impact test (Charpy)(**)	kJ/m ²	85
Tensile test (***)		ISO 527
- Breaking stress	MPa	ND
- Elastic modulus	MPa	ND
- Elongation at break	%	ND

(*) Average on 8 industrial batches

(**)

MECHANICAL PROPERTIES WITH FLOW AT 23°C

Moulding conditions			
Temperature	°C	160/165	
Thickness	mm	3	
Curing time	sec	73	
Covering	%	40	
Part size	mm	700X400	
Layers		5	
	Unit	Perp/Para	Test method
Flexural test(*)			ISO 178
- Breaking stress	MPa	130/250	
- Elastic modulus	MPa	11000/13500	
- Deviation at break	%	2.7/2,8	
Tensile test (**)			ISO 527
- Breaking stress	MPa	35/110	
- Elastic modulus	MPa	11000/15000	
- Elongation at break	%	0,6/1,2	

(*) Average on 4 industrial batches

(**) Average on 2 industrial 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.

