

0653

SMC Low Profile Polyester

Technical Data Sheet

Update : October 2019

Description :

0653 is a not pigmented Class A SMC reinforced with chopped glass fibers (25 mm).
This material has a good flow behaviour under low pressure.

Moulding features (*) :

	Unit		Test method
Reactivity			ISO 12114
• Moulding T°C :	°C	145	
• Thickness :	mm	4,6	
• Cure time :	s	76	
Density		1,87	ISO 1183
Shrinkage	%	-0,07	NF EN 1842

(*) Compression moulding without flow

Use recommendations :

High temperature around 145/150°C under 50 bars

Application :

Outer part for truck applications

COMPOSITION

Product nature	Unit	Ratio
Glass fibres content	%	28
Resins content	%	25
Fillers content	%	45
Other products content	%	2

APPEARANCE

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

MECHANICAL PROPERTIES WITHOUT FLOW AT 23 °C

Moulding conditions			
Temperature	°C	145	
Thickness	mm	4,6	
Curing time	sec	110	
Covering	%	100	
Part size	mm	250X120	
Layers		2	
		Unit	Test method
Flexural test (*)			ISO 178
- Breaking stress	MPa	190	
- Elastic modulus	MPa	9500	
- Deviation at break	mm	5,6	
Impact test (Charpy)(**)	kJ/m ²	90	ISO 179
Tensile test (***)			ISO 527
- Breaking stress	MPa	89	
- Elastic modulus	MPa	11500	
- Elongation at break	%	1,6	

(*) Average on the 20 latest production

(**) Average on the 20 latest production

(***) Average on the 3 production

MECHANICAL PROPERTIES WITH FLOW AT 23 °C

Moulding conditions				
Temperature	°C	150/155		
Thickness	mm	3		
Curing time	sec	120		
Covering	%	36		
Part size	mm	700X300		
Layers		3		
		Unit	Perp/Para	Test method
Flexural test(*)				ISO 178
- Breaking stress	MPa	160/260		
- Elastic modulus	MPa	9000/12000		
- Deviation at break	mm	3,7/3,8		
Tensile test (**)				ISO 527
- Breaking stress	MPa	65/120		
- Elastic modulus	MPa	11000/12500		
- Elongation at break	%	1,1/1,3		

(*) Average on 1 production

(**) Average on 1 production

Mixt Composites Recyclables

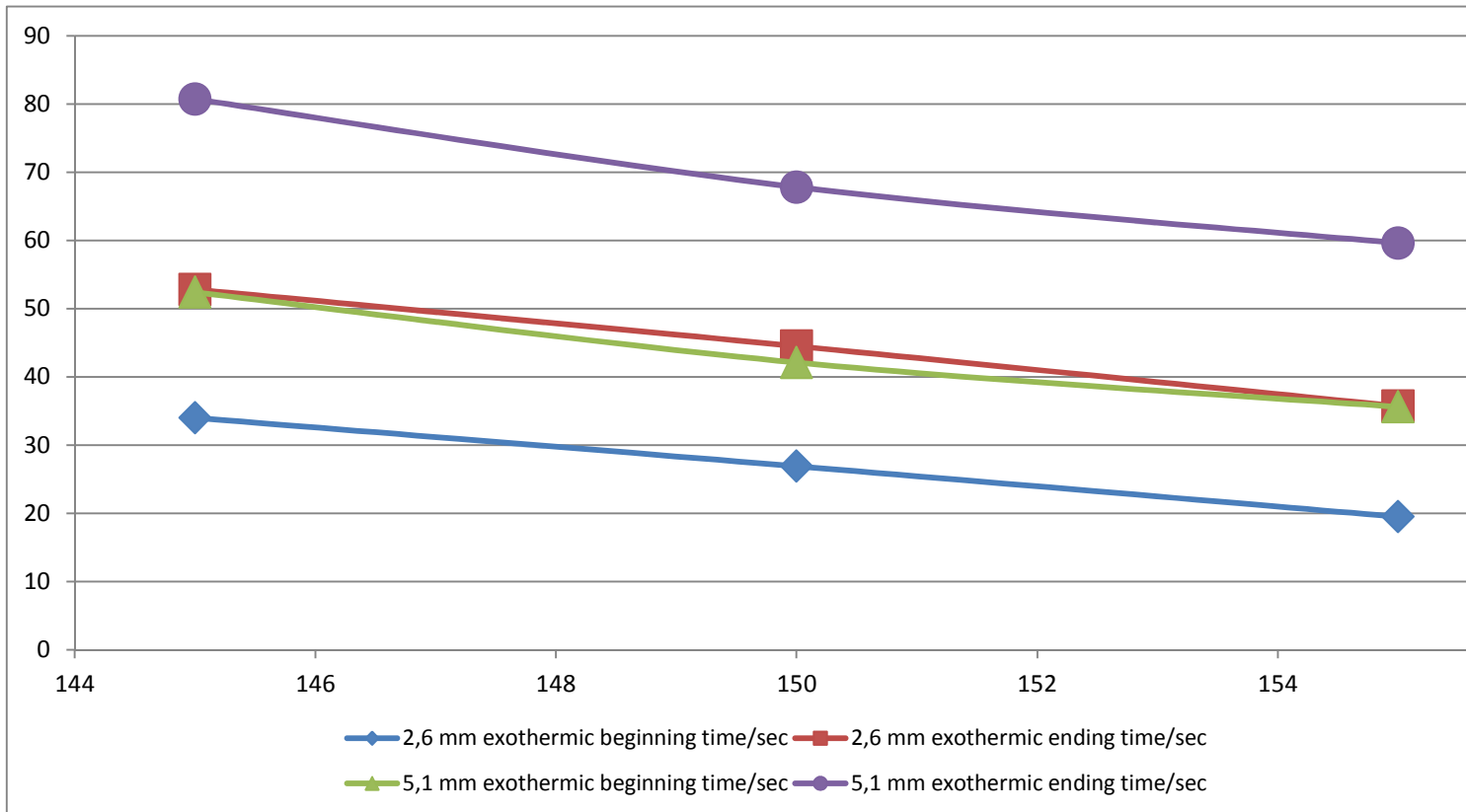
ZI les îles Féray – BP 94 07302 Tournon-sur-Rhône
Tel. : +33 4 75 07 18 18 - Fax : +33 4 75 07 11 77

OTHER PROPERTIES

	<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.



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