

0681

SMC Low Profile Polyester

Technical Data Sheet

Update: October 2019

Description :

0681 is a SMC reinforced with chopped glass fibres (25 mm).
0681 is a pigmented SMC with high mechanical properties and good surface aspect.

Moulding features (*) :

	Unit		Test method
Reactivity			ISO 12114
• Moulding T°C :	°C	145	
• Thickness :	mm	3,4	
• Cure time :	s	57	
Density		1,86	ISO 1183
Shrinkage	%	-0,07	NF EN 1842

(*) Compression moulding without flow

Use recommendations :

High temperature between 145°C and 160°C.
Pressure between 60 and 120 bars

Application :

Class A - Outer part for truck and automotive applications

COMPOSITION

Product nature	Unit	Ratio
Glass fibres content	%	31
Resins content	%	24
Fillers content	%	42
Other products content	%	3

APPEARANCE

	Unit	
Rolls :	kg	600/1500
SMC width :	cm	150
Material support :	-	PE
Surface weight :	kg/m ²	3,5
Colour		Grey

MECHANICAL PROPERTIES WITHOUT FLOW AT 23 °C

Moulding conditions			
Temperature	°C		145
Thickness	mm		3,4
Curing time	sec		85
Covering	%		100
Part size	mm	250X120	
Layers			2
		Unit	Test method
Flexural test (*)			
- Breaking stress	MPa		210
- Elastic modulus	MPa		11000
- Deviation at break	%		3,1
Impact test (Charpy)(**)			
	kJ/m ²		90
Tensile test (***)			
- Breaking stress	MPa		90
- Elastic modulus	MPa		10800
- Elongation at break	%		1,5

(*) 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		3,1	
Curing time	sec		90	
Covering	%		40	
Part size	mm	700X300		
Layers			6	
		Unit	Perp/Para	Test method
Flexural test(*)				
- Breaking stress	MPa		130/270	ISO 178
- Elastic modulus	MPa		8000/12000	
- Deviation at break	mm		3,5/3,9	
Tensile test (**)				
- Breaking stress	MPa		40/145	ISO 527
- Elastic modulus	GPa		8,0/14,0	
- Elongation at break	%		0,75/1,4	

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

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OTHER PROPERTIES

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

Reactivity : The reactivity datas below are given as a technical information



