

3410

AMC Low Shrink Polyester

Technical Data Sheet

Update : January 2020

Description :

3410 is a pigmented AMC reinforced with chopped glass fibres (25 and 13 mm).

3410 is adapted for applications need good flow behaviour and high mechanical properties.

Moulding features (*) :

	Unit		Test method
Reactivity			ISO 12114
• Moulding T°C :	°C	165	
• Thickness :	mm	4	
• Cure time :	s	27	
Density		1,83	NFT 51063
Shrinkage	%	0,00	NF EN 1842

(*) Compression moulding without flow

Use recommendations :

Injection moulding.
High temperature around 165°C under high pressure 300 bars

Application :

Structural parts for automotive applications
Front panel

COMPOSITION

Product nature	Unit	Ratio
Glass fibres content	%	22
Resins content	%	21
Fillers content	%	50
Other products content	%	7

APPEARANCE

	Unit	
Drums:	kg	200 (4 drums per pallet)
Colour		Black

MECHANICAL PROPERTIES WITHOUT FLOW AT 23 °C

Moulding conditions		
Temperature	°C	165
Thickness	mm	4
Curing time	sec	40
Covering	%	~40
Part size	mm	250X120
weight	g	220
	Unit	Test method
Flexural test (*)		ISO 178
- Breaking stress	MPa	170
- Elastic modulus	MPa	12000
- Deviation at break	mm	4,4
Impact test (Charpy)(**)	kJ/m ²	50
Tensile test (***)		ISO 527
- Breaking stress	MPa	ND
- Elastic modulus	MPa	ND
- Elongation at break	%	ND

(*) 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 – injection moulding			
Temperature	°C	160/165	
Thickness	mm	4	
Curing time	sec	70	
Pressure	bar	300	
Part size	mm	700X300	
Weight	g	1480	
Injection time	s	2,3	
	Unit	Perp/Para	Test method
Flexural test(*)			ISO 178
- Breaking stress	MPa	70/200	
- Elastic modulus	MPa	10000/13000	
Tensile test (**)			ISO 527
- Breaking stress	MPa	ND	
- Elastic modulus	MPa	ND	
- Elongation at break	%	ND	

(*) Average on 1 production

(**) Average on the 10 production

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OTHER PROPERTIES

	<i>Unit</i>	<i>Test method</i>	
HDT-A	°C	ND	ISO 75-2
Burning Speed	mm/min	ND	ISO3795/FMVS302

Reactivity :

The reactivity datas below are given as a technical information.

