

0614

SMC Low Profile Polyester

Technical Data Sheet

Update : February 2019

Description :

0614 is a not pigmented SMC reinforced with chopped glass fibers (25 mm).

0614 is a class A general purpose SMC with good mechanical behaviour.

Moulding features (*) :

	Unit		Test method
Reactivity			ISO 12114
• Moulding T°C :	°C	165	
• Thickness :	mm	4,6	
• Cure time :	s	43	
Density		1,88	ISO 1183
Shrinkage	%	0	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	%	24
Fillers content	%	49
Other products content	%	2

APPEARANCE

	Unit	
Rolls :	kg	1500
SMC width :	cm	148
Material support :	-	C0EX
Surface weighth :	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	65
Covering	%	100
Part size	mm	250X120
Layers		2

	Unit		Test method
Flexural test (*)			ISO 178
- Breaking stress	MPa	190	
- Elastic modulus	MPa	12000	
- Deviation at break	mm	5,5	
Impact test (Charpy)(**)	kJ/m ²	80	ISO 179
Tensile test (***)			ISO 527
- Breaking stress	MPa	80	
- Elastic modulus	MPa	13000	
- Elongation at break	%	1,6	

(*) Average on the 20 latest production batches

(**) Average on the 20 latest production batches

(***) Average on the 9 production batches

MECHANICAL PROPERTIES WITH FLOW AT 23°C

Moulding conditions

Temperature	°C	165
Thickness	mm	3
Curing time	sec	65
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	11000/13000	
- Deviation at break	mm	3,2/3,4	
Tensile test (**)			ISO 527
- Breaking stress	MPa	50/100	
- Elastic modulus	MPa	12000/14500	
- Elongation at break	%	1,1/1,4	

(*) Average 8 production batches

(**) Average 8 production 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

	Unit		Test method
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.

MCR.O4.PR.01.FO.16 Fiche Technique

