

0719

SMC Low Shrink Polyester

Technical Data Sheet

Update : February 2019

Description :

0719 is a black pigmented SMC reinforced with chopped glass fibres (25 mm).
0719 is a Low Shrink low density SMC adapted for structural parts.

Moulding features (*):

	Unit		Test method
Reactivity			ISO 12114
• Moulding T°C :	°C	145	
• Thickness :	mm	3	
• Cure time :	s	31	
Density		1,41	ISO 1183
Shrinkage	%	0,18	NF EN 1842

(*) Compression moulding without flow

Use recommendations :

Compression moulding
High temperature around 150°C under high pressure 80 to 100 bars.

Application :

Structural parts for automotive applications like rear floor.

COMPOSITION

Glass fibres content 29%

APPEARANCE

	Unit	
Rolls :	kg	1500
SMC width :	cm	150
Material support :	-	PE
Surface weight :	kg/m ²	4,6
Colour		Black

MECHANICAL PROPERTIES WITHOUT FLOW AT 23 °C

Moulding conditions		
Temperature	°C	145
Thickness	mm	3
Curing time	sec	46
Covering	%	100
Part size	mm	250X120
Layers		1

	Unit		Test method
Flexural test (*)			ISO 178
- Breaking stress	MPa	165	
- Elastic modulus	MPa	7500	
- Deviation at break	mm	4,2	
Impact test (Charpy)(**)	kJ/m ²	55	ISO 179
Tensile test (***)			ISO 527
- Breaking stress	MPa	65	
- Elastic modulus	MPa	8000	
- Elongation at break	%	1,5	

(*) Average on the 20 latest production batches

(**) Average on the 20 latest production batches

(***) Average on 5 production batches

MECHANICAL PROPERTIES WITH FLOW AT 23 °C

Moulding conditions		
Temperature	°C	150/155
Thickness	mm	3
Curing time	sec	60
Covering	%	36
Part size	mm	700X300
Layers		2

	Unit	Perp/Para	Test method
Flexural test(*)			ISO 178
- Breaking stress	MPa	120/220	
- Elastic modulus	MPa	7500/9500	
- Deviation at break	mm	4,4/4,4	
Tensile test (**)			ISO 527
- Breaking stress	MPa	50/90	
- Elastic modulus	MPa	7500/9500	
- Elongation at break	%	1,2/1,5	

(*) Average on 4 production batches

(**) Average on 4 production batches

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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.

