

## 0617 SMC Low Profile Vinylester

### Temporary Technical Data Sheet

Update : October 2019

#### Description :

0617 is a not pigmented SMC reinforced with chopped glass fibres (25 mm).

0617 is a light SMC with good mechanical behaviour. Parts done with 0617 reach LOW VOC expectations after painting.

#### Moulding features (\*) :

	Unit	Test method
Reactivity		ISO 12114
• Moulding T°C :	°C	165
• Thickness :	mm	4,5
• Max exothermic time:	s	45
Density		1,50 NFT 51063
Shrinkage	%	0,01 NF EN 1842

(\*) Compression moulding without flow / Average on 2 pilot productions

#### Use recommendations :

High temperature between 160°C/165°C.

Pressure between 65 and 105 bars.

Cure time 15 sec/mm at 165°C.

#### Application :

Body parts for car such as hatchback:outer and inner part

#### COMPOSITION

Product nature	Unit	Ratio
Glass fibres content	%	31
Resins content	%	25
Fillers content	%	43
Other products content	%	1

#### APPEARANCE

	Unit	
Packaging :		Roll or cardboard box
SMC width :	cm	148
Material support :	-	COEX
Surface weight :	kg/m <sup>2</sup>	3.8
Colour		Natural

#### MECHANICAL PROPERTIES WITHOUT FLOW AT 23 °C

Moulding conditions		
Temperature	°C	165
Thickness	mm	4,5
Curing time	sec	70
Covering	%	100
Part size	mm	250X120
Layers		2
Unit		
Test method		
Flexural test (*)		ISO 178
- Breaking stress	MPa	220
- Elastic modulus	MPa	11450
- Deviation at break	mm	5,8
Impact test (Charpy)(**)	kJ/m <sup>2</sup>	80
		ISO 179
Tensile test (***)		ISO 527
- Breaking stress	MPa	75
- Elastic modulus	MPa	11700
- Elongation at break	%	1,5

(\*) Average on 2 pilot productions

(\*\*)Average on 2 pilot productions

(\*\*\*)Average on 2 pilot productions

#### MECHANICAL PROPERTIES WITH FLOW AT 23 °C

Moulding conditions		
Temperature	°C	160/165
Thickness	mm	2.5
Curing time	sec	90
Covering	%	38
Part size	mm	700X300
Layers		3
Unit		
Perp/Para		
Test method		
Flexural test(*)		ISO 178
- Breaking stress	MPa	140/260
- Elastic modulus	MPa	9600/12700
- Deviation at break	mm	2.7/3.4
Tensile test (**)		ISO 527
- Breaking stress	MPa	44/92
- Elastic modulus	MPa	12400/13900
- Elongation at break	%	0.5/1,2

(\*) Average on 1 pilot production

(\*\*)Average on 1 pilot production

#### Mixt Composites Recyclables

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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
CLTE	10 <sup>-6</sup> K	10 - 30	

### **Reactivity :**

**The reactivity datas below are given as a technical information.**

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