

0698

SMC Low Shrink Polyester

Technical Data Sheet

Update : march 2019

Description :

0698 is a SMC reinforced with chopped glass fibres (25 mm).
0698 is a black mass in colour SMC with good mechanical properties and good surface aspect.

Moulding features (*) :

	Unit	Test method
Reactivity		ISO 12114
• Moulding T°C :	°C	155
• Thickness :	mm	3.0
• Cure time :	s	34
Density		1.27 ISO 1183
Shrinkage	%	0.105 NF EN 1842

(*) Compression moulding without flow

Use recommendations :

High temperature between 145°C and 155°C.
Pressure between 60 and 80 bars

Application :

Semi-structural part for automotive industry with a good aspect.
Recommended for inner and visible parts

COMPOSITION

Product nature	Unit	Ratio
Glass fibres content	%	28
Resins content	%	35
Fillers content	%	31
Other products content	%	6

APPEARANCE

	Unit	
Rolls :	kg	600/1500
SMC width :	cm	148
Material support :	-	coex
Surface weight :	kg/m ²	4.05
Colour		Deep black

MECHANICAL PROPERTIES WITHOUT FLOW AT 23°C

Moulding conditions

Temperature	°C	155
Thickness	mm	3
Curing time	sec	50
Covering	%	100
Part size	mm	250X120
Layers		1

	Unit	Test method
Flexural test (*)		ISO 178
- Breaking stress	MPa	120
- Elastic modulus	MPa	6000
- Deviation at break	mm	4.3
Impact test (Charpy)(**)	kJ/m ²	45 ISO 179
Tensile test (***)		ISO 527
- Breaking stress	MPa	50
- Elastic modulus	MPa	7000
- Elongation at break	%	1,45

(*) Average on 1 industrial production

(**) Average on 1 industrial production

(***) Average on 1 industrial production

MECHANICAL PROPERTIES WITH FLOW AT 23°C

Moulding conditions

Temperature	°C	150/155
Thickness	mm	2.2
Curing time	sec	90
Covering	%	38
Part size	mm	325X2700
Layers		2

	Unit	Perp/Para	Test method
Flexural test(*)			ISO 178
- Breaking stress	MPa	80/160	
- Elastic modulus	MPa	5700/8200	
- Deviation at break	mm	2,8/2,6	
Tensile test(*)			ISO 527
- Breaking stress	MPa	ND	
- Elastic modulus	MPa	ND	
- Deviation at break	%	ND	
Impact test Charpy (**)			ISO 179
-resilience	kJ/m ²	ND	

(*) Average on 1 industrial production

(**) Average on 1 industrial 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

Reactivity :

The reactivity datas below are given as a technical information.

