

Quantum QC 6500 LD

Sheet Molding Compound

PRODUCT DESCRIPTION

E-glass reinforced epoxy molding compound

GENERAL

Material Status	• Commercial: Active		
Availability	• North America	• Europe	• Asia Pacific
Filler/Reinforcement	• E-glass Fiber	• Nominal 35% w/w	• Nominal 1" (25 mm) Length
Features	• Fatigue resistance • Low Density	• High stiffness • Shelf Life 6 months @ 10°F or below	• Black or Natural Color
Processing Method	• QC 6500 LD can be molded at temperatures in the range of 250-300°F, with 280°F suggested as a starting point. Cure times will be dependent on molding temperature and part thickness and will typically be 8-10 minutes. Detailed molding suggestions are available on request. Cool molded parts at ambient temperature. A cooling fixture may be needed depending on part thickness and geometry. Matched metal die molds.		
Resin	• Epoxy Composite		

PHYSICAL	Typical	Unit	Test Method
Density	1.25	g/cm ³	ASTM D792
Shrinkage	<0.0015	in/in	cold mold to cold part
CLTE, X-Y plane		ppm/°C	ASTM E831
CLTE, Z plane		ppm/°C	ASTM E831
Poisson's Ratio	0.33		ASTM D638

MECHANICAL (Machined)	Typical	Unit	Test Method
Tensile Modulus	1.4E+6 (9,650)	psi (MPa)	ASTM D3039
Tensile Stress (Break)	11,000 (75.8)	psi (MPa)	ASTM D3039
Flexural Modulus	1.4E+6 (9,650)	psi (MPa)	ASTM D790
Flexural Stress (Break)	28,000 (193)	psi (MPa)	ASTM D790
Compression	33,000 (227)	psi (MPa)	ASTM D3410

Machined Properties are determined using specimen machined from molded 12"x12" panels with 80% mold coverage, 1000 psi pressure, 280-300°F mold temperature for 3-5 minutes

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MECHANICAL (As molded)	Typical	Unit	Test Method
Tensile Modulus	1.5E+6 (10,300)	psi (MPa)	ASTM D638
Tensile Strength	13,000 (89)	psi (MPa)	ASTM D638
Flexural Modulus (RT)	1.5E+6 (10,300)	psi (MPa)	ASTM D790
Flexural Strength	32,000 (220)	psi (MPa)	ASTM D790

IMPACT	Typical	Unit	Test Method
Izod Notched Impact Strength	14 (747)	ft-lb/in (J/m)	ASTM D256

THERMAL	Typical	Unit	Test Method
Glass Transition T_i , TanDelta	165	°C	ASTM D7028
Glass Transition T_g , Storage Modulus	130	°C	ASTM D7028

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