

## Product Information

# Polyester Resin for SMC Compression Molding

### TYPICAL LIQUID RESIN PROPERTIES\*

	Nominal
Viscosity @ 77°F/25°C, Brookfield cps, LVT#3 @ 60 RPM.	900
RVT#3 @50 RPM	
Percent Volatiles	36.5
Acid Number, mg KOH/g	14
Weight Per Gallon @ 77°F/25°C	9.1

### TYPICAL CURING PROPERTIES\*

180°F SPI Gel Exotherm Test (1.0% BPO)	
150°F - 190°F, min.	5.0
150°F - Peak, min.	6.5
Peak Temperature, °F/°C	480/248

### TYPICAL MECHANICAL PROPERTIES\* (1) see back page

		Test Method
Tensile Strength, MPa	54	ASTM D 638
Tensile Modulus, GPa	3.6	ASTM D 638
Tensile Elongation, %	1.8	ASTM D 638
Flexural Strength, MPa	96	ASTM D 790
Flexural Modulus, GPa	3.7	ASTM D 790

\*Typical properties are not to be construed as specifications.



### DESCRIPTION

S335-63G is designed to produce SMC Class A Automotive and Truck parts with excellent surface quality.

### FEATURES

- Contains renewable and/or recycled content.
- Consistent thickening for SMC applications
- Paintable, coatable and bondable

### APPLICATIONS

- Class A Automotive Parts
- Class A Truck Parts



EcoTek®  
S335-63G  
Class A Polyester Resin



**STORAGE STABILITY**

Resins are stable for three months from date of production when stored in the original containers away from sunlight at no more than 70°F/21°C.

During the hot summer months, no more than two months stability at 86°F/30°C should be anticipated.

**SAFETY**

See appropriate Material Safety Data Sheet for guidelines.

**APPLICATION GUIDELINES**

Contact your AOC sales representative for formulation recommendations.

Low profile or Class A resins have reduced short and long term waviness and provide excellent shrinkage and dimensional control in SMC parts. It is important to realize, however, that secondary bonding characteristics of the products manufactured, whether they are adhered FRP to FRP or FRP to metals, and to other materials must be checked by the molder for all applications.

The test method should reflect adhesion failure mode on actual application, peel vs. shear, etc. The following parameters may also affect bonding performance: type of adhesive and adhesion application, type and amount of texture, substrate formulation and cure, part molding conditions, in-mold coating conditions, shop environmental conditions (humidity, temperature, dirt, grease and oil), interlaminar strength of substrate and other variables.

**ISO 9001:2008 CERTIFIED**

The Quality Management Systems at every AOC manufacturing facility have been certified as meeting ISO 9001:2008 standards. This certification recognizes that each AOC facility has an internationally accepted model in place for managing and assuring quality. We follow the practices set forth in this model to add value to the resins we make for our customers.

**FOOTNOTES**

**(1)**

Molding conditions:  
300°F for 2 min. @ 1,000 psi



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The information contained in this data sheet is based on laboratory data and field experience. We believe this information to be reliable, but do not guarantee its applicability to the user's process or assume any liability for occurrences arising out of its use. The user, by accepting the products described herein, agrees to be responsible for thoroughly testing each such product before committing to production.

Our recommendations should not be taken as inducements to infringe any patent or violate any law, safety code or insurance regulation.

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