

BMC 685

Thermoset Polyester

Bulk Molding Compounds, Inc.

Message:

BMC 685 molding compound is a mineral filled, glass fiber reinforced polyester compound suitable for compression, transfer and stuffer injection molding. It is characterized by good moldability, oil and solvent resistance and creep resistance at elevated temperatures. Typical applications include replacements for die castings and sheet molding compounds, valve covers, intake manifolds, oil pans and circuit breakers.

BMC 685 molding compound is produced in extruded form in a range of industrial colors. It is available in logs up to 12 inches in length or as precut slugs, of specific weight, in diameters 1 in to 2.5 in. Within this range, smaller diameters are supplied as multiple extrusions and weight tolerances are plus or minus 5 %, up to a maximum of plus or minus 15 grams.

General Information			
Filler / Reinforcement	Glass\Mineral		
Features	Good Creep Resistance		
	Good Moldability		
	Oil Resistant		
	Solvent Resistant		
Uses	Automotive Applications		
	Automotive Under the Hood		
Appearance	Colors Available		
Forms	BMC - Bulk Molding Compound		
Processing Method	Compression Molding		
	Injection Molding		
	Resin Transfer Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.75	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.15 to 0.25	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.11	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Barcol Hardness	60		ASTM D2583
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	72.4	MPa	ASTM D638
Flexural Strength	197	MPa	ASTM D790
Compressive Strength	197	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	880	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	260	°C	ASTM D648

Electrical	Nominal Value	Unit	Test Method
Dielectric Strength ¹	16	kV/mm	ASTM D149
Arc Resistance	190	sec	ASTM D495
Comparative Tracking Index (CTI)	500	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.59 mm	HB		
3.18 mm	V-0		
6.35 mm	V-0		
NOTE			
1.	Method A (Short-Time)		

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