BMC 680

Thermoset Polyester

Bulk Molding Compounds, Inc.

Message:

BMC 680 molding compound is a mineral filled, glass-fiber-reinforced polyester compound suitable for compression and stuffer injection mold ing It is characterized by good moldability, very high impact strength, 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 680 molding compound is produced in a range of industrial colors and is supplied in bulk form.

General Information	
Filler / Reinforcement	Glass\Mineral
Features	Good Creep Resistance Good Moldability Oil Resistant Solvent Resistant Ultra High Impact Resistance
Uses	Automotive Applications Electrical/Electronic Applications
Appearance	Colors Available
Forms	BMC - Bulk Molding Compound
Processing Method	Compression Molding Injection Molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.71	g/cm³	ASTM D792
Molding Shrinkage - Flow (Compression Molded)	0.10 to 0.20	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.15	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Barcol Hardness	55		ASTM D2583
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield, Compression Molded)	107	MPa	ASTM D638
Flexural Strength (Compression Molded)	224	MPa	ASTM D790
Compressive Strength	148	MPa	ASTM D695
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (Compression Molded)	1300	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**

Deflection Temperature Under Load (1.8 MPa, Unannealed, Compression Molded)	260	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength [1]	15	kV/mm	ASTM D149
Arc Resistance	180	sec	ASTM D495
Comparative Tracking Index (CTI)	600	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.59 mm	HB		
3.18 mm	HB		
6.35 mm	V-0		
Injection	Nominal Value	Unit	
Mold Temperature	138 to 166	°C	
NOTE			
1.	Method A (Short-Time)		

Recommended distributors for this material

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