

BMC 620

Thermoset Polyester

Bulk Molding Compounds, Inc.

Message:

BMC 620 molding compound is a mineral filled, glass-fiber-reinforced polyester compound suitable for compression, and stuffer injection molding. It is characterized by good moldability, high impact strength, excellent overall electrical properties and flame resistance. Typical applications include molded replacements for die castings, buss supports, circuit breaker housings, phase separators and contactor blocks. BMC 620 molding compound is produced in a range of industrial colors, and is supplied in bulk form.

General Information			
Filler / Reinforcement	Glass\Mineral		
Features	Flame Retardant		
	Good Electrical Properties		
	Good Moldability		
	High Impact Resistance		
Uses	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	1.73 to 1.79	g/cm ³	ASTM D792
Molding Shrinkage - Flow (Compression Molded)	0.26 to 0.38	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.14	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Barcol Hardness	22 to 42		ASTM D2583
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, Compression Molded)	34.5 to 55.2	MPa	ASTM D638
Flexural Strength (Compression Molded)	131 to 159	MPa	ASTM D790
Compressive Strength	152 to 179	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (Compression Molded)	320 to 480	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	14	kV/mm	ASTM D149

Dielectric Constant (60 Hz)	5.20		ASTM D150
Dissipation Factor (60 Hz)	0.020		ASTM D150
Arc Resistance	190	sec	ASTM D495
Comparative Tracking Index (CTI)	> 500	V	UL 746
Inclined-Plane Tracking (2.5 kV)	> 900	min	ASTM D2303
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.59 mm	V-0		
3.18 mm	V-0		
6.35 mm	V-0		
Injection	Nominal Value	Unit	
Mold Temperature	138 to 166	°C	
NOTE			

1. Method A (Short-Time)

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