

# BMC 675

Thermoset Polyester  
Bulk Molding Compounds, Inc.

Message:

BMC 675 molding compound is a mineral filled, glass reinforced polyester molding compound suitable for compression, transfer or 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 structural components. BMC 675 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.

General Information			
Forms	Particle		
Processing Method	Extrusion		
	Compression molding		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.85	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow	0.10 - 0.30	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.25	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Barcol Hardness	55		ASTM D2583
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	14800	MPa	ASTM D638
Tensile Strength	31.0	MPa	ASTM D638
Flexural Modulus	13100	MPa	ASTM D790
Flexural Strength	86.2	MPa	ASTM D790
Compressive Strength	165	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Instrumented Dart Impact			ASTM D3763
Energy to Max Load	3.05	J	ASTM D3763
3.18 mm, Total Energy	5.02	J	ASTM D3763
Additional Information			
Density Specific Gravity, ASTM D792: 1.80 to 1.90 sp gr 23/23°C Flexural Strength, ASTM D790: 11000 to 14000 psi Flexural Modulus, ASTM D790: 1800000 to 2000000 psi Compressive Strength, ASTM D695: 23000 to 25000 psi Tensile Strength, ASTM D638: 4000 to 5000 psi Tensile Modulus, ASTM D638: 2000000 to 2300000 psi Water Absorption @ 24 hrs, ASTM D570, 23°C: 0.23 to 0.27 % Barcol Hardness, ASTM D2583: 50 to 60 Instrumented Dart Impact, ASTM D3763, 0.125 in, Total Energy: 3 to 4.4 ft-lb Instrumented Dart Impact, ASTM D3763, Energy to Max Load: 1.8 to 2.7 ft-lb Instrumented Dart Impact, ASTM D3763, Maximum Load: 170 to 200 lbs			
Injection	Nominal Value	Unit	
Processing (Melt) Temp	138 - 166	°C	

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