

# BMC 605

Thermoset Polyester

Bulk Molding Compounds, Inc.

## Message:

BMC 605 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, medium impact strength, excellent overall electrical properties and flame resistance. Typical applications include circuit breakers, transformer bobbins and motor end bells. BMC 605 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" to 2 ½". 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	Flame Retardant
	Good Electrical Properties
	Good Moldability
	Medium 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	1.95	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (Compression Molded)	0.25 to 0.40	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.14	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Barcol Hardness	40 to 50		ASTM D2583
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, Compression Molded)	41.4 to 55.2	MPa	ASTM D638
Flexural Strength (Compression Molded)	110 to 138	MPa	ASTM D790
Compressive Strength	165 to 193	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (Compression Molded)	110 to 320	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 <sup>1</sup>	14	kV/mm	ASTM D149

Arc Resistance	190	sec	ASTM D495
Comparative Tracking Index (CTI)	> 600	V	UL 746
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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