

BMC 615

Thermoset Polyester

Bulk Molding Compounds, Inc.

Message:

BMC 615 molding compound is a mineral filled, glass-fiber-reinforced polyester compound suitable for compression, transfer and stuffer injection molding. It is a high impact material produced in extruded form for ease of handling. Other characteristics are good overall electrical properties and flame resistance. Typical applications include circuit breaker housing, standoff insulators, bus supports and collector rings. BMC 615 molding compound is produced in extruded form in a range on 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 extrusion 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		
	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	1.88	g/cm ³	ASTM D792
Molding Shrinkage - Flow (Compression Molded)	0.20 to 0.35	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.15	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Barcol Hardness	40		ASTM D2583
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, Compression Molded)	48.3	MPa	ASTM D638
Flexural Strength (Compression Molded)	121	MPa	ASTM D790
Compressive Strength	152	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (Compression Molded)	270	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, Compression Molded)	316	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength ¹	14	kV/mm	ASTM D149

Dielectric Constant (60 Hz)	5.30		ASTM D150
Dissipation Factor (60 Hz)	0.015		ASTM D150
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	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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