

BMC 400

Thermoset Polyester
Bulk Molding Compounds, Inc.

Message:

BMC 400 is a high strength, low shrink molding compound. It can be supplied in bulk or extruded in pre-weighted slugs. Typical applications are HVAC condensation drain pans, power tool housings, insulators and circuit breakers.

General Information			
Features	High Strength		
	Low Shrinkage		
Uses	Appliances		
	Electrical Housing		
Appearance	Natural Color		
Forms	Pellets		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.75 to 1.95	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.10 to 0.30	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.12 to 0.20	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Barcol Hardness	40 to 50		ASTM D2583
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	34.5 to 55.2	MPa	ASTM D638
Flexural Modulus	11700 to 13100	MPa	ASTM D790
Flexural Strength (Yield)	96.5 to 138	MPa	ASTM D790
Compressive Strength	124 to 159	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	160 to 430	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	> 260	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength ¹	14 to 16	kV/mm	ASTM D149
Arc Resistance (1.59 mm)	> 180	sec	ASTM D495
Comparative Tracking Index (CTI) (1.59 mm)	500	V	UL 746
Flammability	Nominal Value	Unit	Test Method

Flame Rating (1.59 mm)

5V

UL 94

Injection	Nominal Value	Unit
Rear Temperature	138 to 166	°C
Middle Temperature	138 to 166	°C
Front Temperature	138 to 166	°C
Mold Temperature	138 to 166	°C
NOTE		

1. Method A (Short-Time)

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