

BMC 404

Thermoset Polyester

Bulk Molding Compounds, Inc.

Message:

BMC 404 is a general purpose, mineral filled, glass fiber-reinforced polyester compound suitable for compression, transfer and stuffer injection molding. It is of medium strength and meets Ford Specification ESF-M3D121-A. This material has excellent electrical properties. As with all other BMCI compounds, this series can be supplied in logs, slugs or bulk. Typical applications are bobbins, electrical connectors, circuit breakers and as phenolic replacement.

General Information			
Filler / Reinforcement	Glass Fiber		
	Mineral		
Features	Good Electrical Properties		
	Good Strength		
Uses	Appliances		
	Bobbins		
	Electrical Parts		
Appearance	Natural Color		
Forms	Pellets		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.80 to 1.90	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.15 to 0.40	%	ASTM D955
Water Absorption (24 hr)	0.12	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Barcol Hardness	45 to 55		ASTM D2583
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	37.9 to 55.2	MPa	ASTM D638
Flexural Strength (Yield)	103 to 124	MPa	ASTM D790
Compressive Strength	124 to 145	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	270 to 480	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	14 to 15	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)	V-0		UL 94
Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	138 to 166	°C	
Cylinder Zone 2 Temp.	138 to 166	°C	
Cylinder Zone 3 Temp.	138 to 166	°C	
Cylinder Zone 4 Temp.	138 to 166	°C	
Cylinder Zone 5 Temp.	138 to 166	°C	

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