

BMC 610

Thermoset Polyester

Bulk Molding Compounds, Inc.

Message:

BMC 610 molding compound is a mineral filled, glass-fiber-reinforced polyester compound suitable for compression, transfer and stuffer injection molding. It is set a part form other medium impact electrical grade materials by its very high arc resistance and outstanding flame resistance in thin sections. Typical applications include transformer bobbins, terminal boards, arc chutes and contactors. BMC 610 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		
Additive	UV Stabilizer		
Features	Arc Resistant		
	Flame Retardant		
	Good Electrical Properties		
	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	1.89 to 1.95	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.25 to 0.46	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.10	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Barcol Hardness	28 to 43		ASTM D2583
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	41.4 to 55.2	MPa	ASTM D638
Flexural Strength	96.5 to 124	MPa	ASTM D790
Compressive Strength	165 to 193	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	110 to 210	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	kV/mm	ASTM D149

Dielectric Constant (60 Hz)	5.50		ASTM D150
Dissipation Factor (60 Hz)	0.015		ASTM D150
Arc Resistance	> 210	sec	ASTM D495
Comparative Tracking Index (CTI)	> 600	V	UL 746
Inclined-Plane Tracking (2.5 kV)	> 900	min	ASTM D2303
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.794 mm	V-0		
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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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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