Technical Data Sheet

Bmc 600

Thermoset Polyester
LyondellBasell Industries
Engineering Plastics

Product Description
BMC 600 molding compound is a mineral filled, glass-fiber-reinforced polyester compound suitable for compression, transfer and stuffer injection molding. It is a general purpose material with medium impact strength and good overall electrical properties. Typical applications include slip rings, commutators and brush holders. BMC 600 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 from 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			
Filler / Reinforcement	• Glass\Mineral		
Features	• General Purpose	• Good Electrical Properties	• Medium Impact Resistance
Uses	• Communication Applications	• General Purpose	
Automotive Specifications	• DELCO PROD DPM 4200	• DELPHI M-2259	
Forms	• BMC - Bulk Molding Compound		
Processing Method	• Compression Molding	• Injection Molding	

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	2.02	2.01 g/cm³	ASTM D792
Water Absorption (24 Hr, 73°f (23°c))	0.13 %	0.13 %	ASTM D570
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Strength (Yield, Compression Molded)	5000 to 7000 psi	34.5 to 48.3 MPa	ASTM D638
Flexural Strength (Compression Molded)	16000 to 20000 psi	110 to 138 MPa	ASTM D790
Compressive Strength	22000 to 26000 psi	152 to 179 MPa	ASTM D695
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Notched Izod Impact (Compression Molded)	2.0 to 4.0 ft·lb/in	110 to 210 J/m	ASTM D256
Hardness	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Barcol Hardness	40 to 50	40 to 50	ASTM D2583
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			ASTM D648
264 Psi (1.8 Mpa), Unannealed, Compression Molded	> 500 °F	> 260 °C	
Electrical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Dielectric Strength (Method A (short-time))	330 V/mil	13 kV/mm	ASTM D149
Dielectric Constant (60 Hz)	6.10	6.10	ASTM D150
Dissipation Factor (60 Hz)	7.0E-3	7.0E-3	ASTM D150
Arc Resistance	> 180 sec	> 180 sec	ASTM D495
Comparative Tracking Index (CTI)	> 600 V	> 600 V	UL 746A
Flammability	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Flame Rating			UL 94
0.06 In (1.6 Mm)	HB	HB	
0.13 In (3.2 Mm)	HB	HB	
0.25 In (6.4 Mm)	HB	HB	

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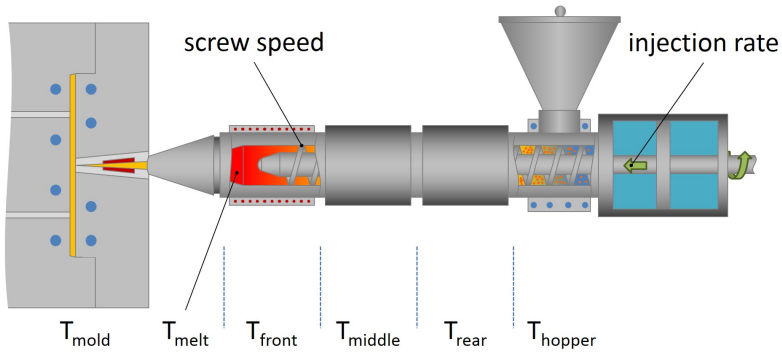

Injection	Nominal Value (English)	Nominal Value (SI)
Mold Temperature	280 to 330 °F	138 to 166 °C

Notes

These are typical property values not to be construed as specification limits.