

Technical Data Sheet

Bmc 680

Thermoset Polyester
LyondellBasell Industries
Engineering Plastics

Product Description

BMC 680 molding compound is a mineral filled, glass-fiber-reinforced polyester compound suitable for compression and stuffer injection molding. It is characterized by good moldability, very high impact strength, oil and solvent resistance and creep resistance at elevated temperatures. Typical applications include replacements for die castings and sheet molding compounds, valve covers, intake manifolds, oil pans and circuit breakers. BMC 680 molding compound is produced in a range of industrial colors and is supplied in bulk form.

General

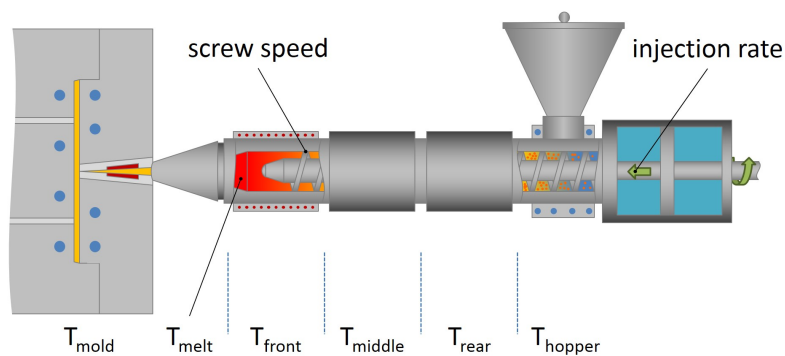
Filler / Reinforcement	• Glass\Mineral		
Features	• Creep Resistant • Good Moldability	• Oil Resistant • Solvent Resistant	• Ultra High Impact Resistance
Uses	• Automotive Applications	• Electrical/Electronic Applications	
Appearance	• Colors Available		
Forms	• BMC - Bulk Molding Compound		
Processing Method	• Compression Molding	• Injection Molding	

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.71	1.71 g/cm ³	ASTM D792
Water Absorption (24 Hr, 73°F (23°C))	0.15 %	0.15 %	ASTM D570
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield, Compression Molded)	15500 psi	107 MPa	ASTM D638
Flexural Strength (Compression Molded)	32500 psi	224 MPa	ASTM D790
Compressive Strength	21500 psi	148 MPa	ASTM D695
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact (Compression Molded)	24 ft·lb/in	1300 J/m	ASTM D256
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Barcol Hardness	55	55	ASTM D2583
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load 264 Psi (1.8 Mpa), Unannealed, Compression Molded	500 °F	260 °C	ASTM D648
Electrical	Nominal Value (English)	Nominal Value (SI)	Test Method
Dielectric Strength (Method A (short-time))	390 V/mil	15 kV/mm	ASTM D149
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)	V-0	V-0	

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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.