

# BMC 665

## Bulk Molding Compound

### PRODUCT DESCRIPTION

Glass fiber reinforced Polyester BMC suitable for include replacements for die castings and sheet molding compounds, valve covers, intake manifolds, oil pans and structural components.

### GENERAL

<b>Material Status</b>	• Commercial: Active		
<b>Availability</b>	• North America • Asia Pacific	• Europe • South America	
<b>Filler/Reinforcement</b>	• Glass Fiber and mineral filler		
<b>Features</b>	• Good oil and solvent resistance	• Good creep resistance	• Good moldability
<b>Processing Method</b>	• This BMC product is generally intended to be compression, injection or transfer molded in matched metal die molds, typically at 300°F (150°C) and 500 to 1,000 psi (35-65 BAR) molding pressure. Strength values may be affected by the molding process.		
<b>Resin</b>	• Unsaturated Polyester Composite		

PHYSICAL	Typical	Unit	Test Method
Density	1.68-1.73	g/cm <sup>3</sup>	ASTM D792
Mold Shrinkage (RT mold/RT part)	0.003-0.009	in/in	ASTM D955
Water Absorption, 24 hrs, 23°C	0.12-0.18	%	ASTM D570
Hardness, Barcol	35-45	Barcol Units	ASTM D2583
Poisson's Ratio	0.36		ASTM D638

MECHANICAL (As molded)	Typical	Unit	Test Method
Tensile Strength	7,000-9,000 (48-62)	psi (MPa)	ASTM D638
Flexural Modulus (RT)	1.3-1.5 x 10 <sup>6</sup> (8.9-10.3)	psi (GPa)	ASTM D790
Flexural Strength	18,000-22,000 (124-151)	psi (MPa)	ASTM D790
Compressive Strength	23,000-26,000 (158-179)	psi (MPa)	ASTM D695

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<b>IMPACT</b>	<b>Typical</b>	<b>Unit</b>	<b>Test Method</b>
Izod Notched Impact Strength	8-11 (425-585)	ft-lb/in (J/m)	ASTM D256
<b>THERMAL</b>	<b>Typical</b>	<b>Unit</b>	<b>Test Method</b>
Heat Deflection Temperature	>500 (>260)	°F (°C)	ASTM D648
Glass Transition T <sub>g</sub>	180-190	°C	ASTM D4065

For additional information, please contact:

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