

Technical Data Sheet

**Bmc 324**

Thermoset Polyester
LyondellBasell Industries
Engineering Plastics

Product Description

BMC 324 is a low profile, automotive grade molding compound that is suitable for injection, compression or transfer molding operations. BMC 324 can be metallized directly, without an initial base-coat. BMC 324 can be supplied in logs, slugs or bulk form. Typical applications include automotive headlamp and foglamp reflectors.

General

Material Status	• Commercial: Active		
Availability	• North America		
Uses	• Automotive Applications		
Automotive Specifications	• CHRYSLER MS-DA-266 Type A CPN3923 Color: Natural		
Forms	• BMC - Bulk Molding Compound		
Processing Method	• Compression Molding	• Injection Molding	• Resin Transfer Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.90	1.90 g/cm ³	ASTM D792
Water Absorption (24 hr, 73°F (23°C))	0.20 %	0.20 %	ASTM D570
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength	6000 psi	41.4 MPa	ASTM D638
Flexural Modulus	1.50E+6 psi	10300 MPa	ASTM D790
Flexural Strength	15000 psi	103 MPa	ASTM D790
Compressive Strength	18000 psi	124 MPa	ASTM D695
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact	4.5 ft·lb/in	240 J/m	ASTM D256
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Barcol Hardness	50	50	ASTM D2583
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load 264 psi (1.8 MPa), Unannealed	463 °F	239 °C	ASTM D648
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating (0.06 in (1.6 mm))	HB	HB	UL 94

Notes

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

Processing Techniques

Specific recommendations for resin type and processing conditions can only be made when the end use, required properties and fabrication equipment are known.

Product Storage and Handling

- Product should be stored in dry conditions at temperatures below 50°C and protected from UV-light
- Improper storage may bring damage to the packaging and can negatively affects on the quality of this product
- Keep material completely dry for good processing

Company Information

For further information regarding the LyondellBasell company, please visit <http://www.lyb.com/>.

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