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			
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/cm³	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			ASTM D648
264 Psi (1.8 Mpa), Unannealed	463 °F	239 °C	
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.