

**Technical Data Sheet**  
**Dura-BMC 304 24540**  
 Engineered Composites  
 (Injection Molded, Machined Specimens)



**Product Description**

Dura-BMC 304-24540 is a glass fiber reinforced polyester BMC which contains recycled content that is fully based on material diverted from the waste stream during the manufacturing process. This material is suitable for automotive headlamp brackets, frames and other structural components.

**General**

Material Status	• Commercial: Active		
Availability	• North America • Asia Pacific	• Europe • South America	
Filler / Reinforcement	• Glass Fiber and Mineral filler		
Features	• Excellent Dimensional stability	• Can be coated using traditional or Electrostatic coating systems	• Excellent adhesion characteristics
Resin	• Unsaturated Polyester		

**Recommended Processing**

**Startup Parameters**

Mold Temperature	300 – 380	°F
Cure Time (3.0 mm thick)	15 – 30	seconds
Recommend Press Tonnage	1-2	Tons/in <sup>2</sup> on Projected Area
Recommend Injection Pressure	500-1000	psi

Physical	Typical Lot Average	Unit	Test Method
----------	---------------------	------	-------------

Density	1.96	g/cm <sup>3</sup>	ASTM D792
Mold Shrinkage (RT mold/RT part)	-.0001	in/in	ASTM D955
Hardness, Barcol		Barcol Units	ASTM D2583

Mechanical (Machined Specimens)	Typical Lot Average	Unit	Test Method
---------------------------------	---------------------	------	-------------

Tensile Strength	37.39 – (5,423)	MPa – (psi)	ASTM D638
Flexural Modulus (RT)	10425 – (1,512,018)	MPa – (psi)	ASTM D790
Flexural Strength	66 – (9,573)	MPa – (psi)	ASTM D790
Compressive Strength	145.3 – (21,074)	MPa – (psi)	ASTM D695

Impact	Typical Lot Average	Unit	Test Method
--------	---------------------	------	-------------

Notched Impact Strength	114.8 – (2.15)	J/m – (ft-lb/in)	ASTM D256
-------------------------	----------------	------------------	-----------

Thermal	Typical	Unit	Test Method
---------	---------	------	-------------

Glass Transition T <sub>g</sub>	358 (181)	°F (°C)	ASTM D4065
---------------------------------	-----------	---------	------------

(Note: Above values are nominal reference points. Specific formulations and molding conditions will influence results)

Heat Deflection Temperature, 254psi	>450 (>230)	°F (°C)	ASTM D648
-------------------------------------	-------------	---------	-----------

Flammability,	Typical	Unit	Test Method
---------------	---------	------	-------------

Flammability, UL 94	HB		UL94 HB (not UL Listed)
---------------------	----	--	-------------------------

**Notes**

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

**Technical Data Sheet**  
***Dura-BMC 304 24540***  
Engineered Composites  
(Injection Molded, Machined Specimens)



**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.

**Company Information**

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

© LyondellBasell Industries Holdings, B.V. 2019

**Disclaimer**

Information in this document is accurate to the best of our knowledge at the date of publication. The document is designed to provide users general information for safe handling, use, processing, storage, transportation, disposal and release does not constitute any warranty or quality specification, either express or implied, including any warranty of merchantability or fitness for any particular purpose. Users shall determine whether the product is suitable for their use and can be used safely and legally.

In addition to any prohibitions of use specifically noted in this document, LyondellBasell may further prohibit or restrict the sale of its products into certain applications. For further information, please contact a LyondellBasell representative.

**Trademarks**

The Trademark referenced within the product name is owned or used by the LyondellBasell family of companies.