SENT BY:414/268-3791

BAKELITE
TRADE-MARK

Phenolic
Molding Materials

BM-261
Black
Heat-Resistant
Phenolic
SECTION VII

DESCRIPTION:

BM-261 Black is a two-step phenolic all mineral-filled material having good heat resistance. Also, because of its mineral filler, BM-261 absorbs less moisture than cellulose filled material and therefore is more stable dimensionally. It is recommended to molders desiring approval under Type MIL-H-1 (MFI) of Joint Army-Navy Specification JAN-P-14. BM-261 Black can be molded well in most molds and under the conditions normally used for general-purpose materials. For the brown counterpart of BM-261 Black, see data sheet on BM-261 Brown.

The properties listed below are obtained from standard test specimens evaluated in accordance with the procedures described in ASTM Method D48-45T and the individual ASTM methods listed for each property. These are more fully described in the Introduction. In the few instances where ASTM methods are not observed, Bakelite Corporation's Standard Testing Methods used are identified as WC Methods.

PROPERTIES:

Values relating to Fabrication

Granulation (D392-38)	12 mesh
Bulk Factor (D392-38)	2.5 max.

Tableting Quality—Can be tableted satisfactorily in the usual tableting equipment.

Pourability, secs. /s (D392-38)	21 max.
Flow Range at 500 psi 150°C. (WC-508-A/1)	50–150
Molding Shrinkage, in./in. (WC-56-F)	0.0025–0.0045

Values from Electrical Tests

Dielectric Strength (D149-44) Short time, volts/mil	300 min.
Volume Resistivity (D257-46), megohm-cms.	10 x 10⁶ min.
Dielectric Constant (D150-47T)	
60 cycles	15 max.
1,000 cycles	12 max.
1,000,000 cycles	7 max.
Power Factor (D151-47T)	
60 cycles	0.25 max.
1,000 cycles	0.20 max.
1,000,000 cycles	0.10 max.

Values from Miscellaneous Tests

Molded Specific Gravity (D792-38)	1.85–1.95
Heat Distortion Temp. (D648-45T)	290°F. min.

Heat Resistance—Molded parts ordinarily should not be exposed to temperatures in excess of 375°F–400°F.

Water Absorption (D570-42), Per Cent Gain in Wt.	0.20 max.

Values from Mechanical Tests

Izod Impact Strength (D256-47T) Ft. lb./inch of notch	0.25 min.
Compressive Strength (D695-44T), psi	18,000 min.
Tensile Strength (D651-43) (1/8"), psi	4,000 min.
Flexural Strength (D790-45T), psi	7,000 min.
Modulus of Elasticity in Flexure (D790-45T), psi	10 x 10⁶ min.

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SERIES IV

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