



POLYESTER RESIN, FIBERGLASS REINFORCED BULK MOLDING COMPOUND

ESB-M3D101-A

1. SCOPE

The material defined by this specification is a polyester resin fiberglass reinforced premix, bulk molding compound, having a low profile surface, suitable for high visibility painted parts.

2. APPLICATION

This specification was released originally for material used to mold body components such as extensions and lamp bodies.

3. REQUIREMENTS

3.0 STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS

Material suppliers and part producers must conform to the Company's Standard Requirements For Production Materials (WSS-M99P1111-A).

3.1 MOLDED SPECIMENS

3.1.1	Specific Gravity (ASTM D 792)	1.7 - 2.0
3.1.2	Water Absorption, max (ASTM D 570, 24 h immersion)	0.5%
3.1.3	Impact Strength, Izod, min (ASTM D 256)	
	Notched	5 ft lb/in (267 J/m)
	Unnotched	6 ft lb/in (320 J/m)
3.1.4	Flexural Strength, min (ASTM D 790)	12,000 psi (83 MPa)
3.1.5	Tensile Strength, min (ASTM D 638)	4,000 psi (27.6 MPa)
3.1.6	Hardness - Rockwell "R" (ASTM D 785)	95 - 110
3.1.7	Fiberglass Content, by weight, min	15%

Date	Action	Revisions
2004 10 25	Revised	Inserted 3.0; Deleted 3.3 & 4
1978 04 25		Metricated and Retyped CAH1-RD572066-15
1967 07 19	Released	AW1-1052





3.2 MOLDED PARTS

3.2.1 Physical Properties

Specific physical property requirements for molded parts, shall be specified on engineering drawing or performance specification.

3.2.2 Paintability

The quality of molded parts required is to be obtained with the best commercial practice to consistently meet the performance requirements of specification ESB-M2P7-A, Paint Quality, Fiberglass Body Parts - Exterior.