

# ESTOPLAST SR 2020NN01

Acrylonitrile Butadiene Styrene  
Ester Industries Ltd.

Message:

Acrylonitrile Butadiene styrene - 20% Glass filled, Natural  
Appliances: Air conditioner Parts

| General Information                                     |                                                       |                   |             |
|---------------------------------------------------------|-------------------------------------------------------|-------------------|-------------|
| Filler / Reinforcement                                  | Glass fiber reinforced material, 20% filler by weight |                   |             |
| Additive                                                | demoulding                                            |                   |             |
| Features                                                | Good demoulding performance                           |                   |             |
| Uses                                                    | Home appliance components                             |                   |             |
| RoHS Compliance                                         | RoHS compliance                                       |                   |             |
| Appearance                                              | Natural color                                         |                   |             |
| Forms                                                   | Particle                                              |                   |             |
| Processing Method                                       | Injection molding                                     |                   |             |
| Physical                                                | Nominal Value                                         | Unit              | Test Method |
| Specific Gravity                                        | 1.18                                                  | g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)               | 6.0                                                   | g/10 min          | ASTM D1238  |
| Water Absorption (Equilibrium, 23°C, 50% RH)            | 0.40                                                  | %                 | ISO 62      |
| Mechanical                                              | Nominal Value                                         | Unit              | Test Method |
| Tensile Strength (Break)                                | 70.0                                                  | MPa               | ASTM D638   |
| Tensile Elongation (Break)                              | 3.0                                                   | %                 | ASTM D638   |
| Flexural Strength                                       | 105                                                   | MPa               | ASTM D790   |
| Impact                                                  | Nominal Value                                         | Unit              | Test Method |
| Notched Izod Impact (23°C)                              | 60                                                    | J/m               | ASTM D256   |
| Thermal                                                 | Nominal Value                                         | Unit              | Test Method |
| Deflection Temperature Under Load (1.8 MPa, Unannealed) | 95.0                                                  | °C                | ASTM D648   |
| Flammability                                            | Nominal Value                                         |                   | Test Method |
| Flame Rating (1.5 mm)                                   | HB                                                    |                   | UL 94       |
| Injection                                               | Nominal Value                                         | Unit              |             |
| Drying Temperature                                      | 80 - 90                                               | °C                |             |
| Drying Time                                             | 3.0 - 4.0                                             | hr                |             |
| Rear Temperature                                        | 200 - 210                                             | °C                |             |
| Middle Temperature                                      | 230 - 240                                             | °C                |             |
| Nozzle Temperature                                      | 235 - 245                                             | °C                |             |
| Processing (Melt) Temp                                  | 230 - 240                                             | °C                |             |
| Mold Temperature                                        | 80 - 90                                               | °C                |             |

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