



LubriOne™ AT-000/10T NATURAL

Acetal (POM) Copolymer

Key Characteristics

Product Description	
PTFE lubricated	
General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Additive	• PTFE Lubricant
Features	• Lubricated
Appearance	• Natural Color
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Specific Gravity	1.44	1.44	ASTM D792
Molding Shrinkage - Flow	0.019 to 0.021 in/in	1.9 to 2.1 %	ASTM D955
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength ²	7980 psi	55.0 MPa	ASTM D638
Flexural Modulus ³	326000 psi	2250 MPa	ASTM D790
Flexural Strength ³	10900 psi	75.0 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact			ASTM D256
73°F (23°C), 0.126 in (3.20 mm)	0.84 ft-lb/in	45 J/m	
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm)	194 °F	90.0 °C	
Flammability	Typical Value (English)	Typical Value (SI)	Test Method
Flame Rating (0.06 in (1.6 mm))	HB	HB	UL 94

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	176 to 194 °F	80.0 to 90.0 °C
Drying Time	2.0 to 3.0 hr	2.0 to 3.0 hr
Rear Temperature	374 to 392 °F	190 to 200 °C
Middle Temperature	374 to 392 °F	190 to 200 °C
Front Temperature	374 to 392 °F	190 to 200 °C
Mold Temperature	167 to 185 °F	75.0 to 85.0 °C

Injection Notes

Injection Pressure: MED-HIGH
Hold Pressure: MED-HIGH
Screw Speed: MODERATE
Back Pressure: LOW

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Notes

¹ Typical values are not to be construed as specifications.

² 2.0 in/min (50 mm/min)

³ 0.051 in/min (1.3 mm/min)

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