



# LubriOne™ AT-000/20T Black

## Acetal (POM) Copolymer

### Key Characteristics

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

### Technical Properties <sup>1</sup>

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Specific Gravity	1.50	1.50	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 <sup>2</sup>	6530 psi	45.0 MPa	ASTM D638
Flexural Modulus <sup>3</sup>	297000 psi	2050 MPa	ASTM D790
Flexural Strength <sup>3</sup>	9430 psi	65.0 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)	0.75 ft-lb/in	40 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			UL 94
0.06 in (1.5 mm)	HB	HB	
0.12 in (3.0 mm)	HB	HB	

### 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	

Copyright © 2016 PolyOne Corporation. PolyOne makes no representations, guarantees, or warranties of any kind with respect to the Information contained in this document about its accuracy, suitability for particular applications, or the results obtained or obtainable using the information. Some of the Information arises from laboratory work with small-scale equipment which may not provide a reliable indication of performance or properties obtained or obtainable on larger-scale equipment. Values reported as "typical" or stated without a range do not state minimum or maximum properties; consult your sales representative for property ranges and min/max specifications. Processing conditions can cause material properties to shift from the values stated in the Information. PolyOne makes no warranties or guarantees respecting suitability of either PolyOne's products or the Information for your process or end-use application. You have the responsibility to conduct full-scale end-product performance testing to determine suitability in your application, and you assume all risk and liability arising from your use of the Information and/or use or handling of any product. POLYONE MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, either with respect to the Information or products reflected by the Information. This data sheet shall NOT operate as permission, recommendation, or inducement to practice any patented invention without permission of the patent owner.

**Notes**<sup>1</sup> Typical values are not to be construed as specifications.<sup>2</sup> 2.0 in/min (50 mm/min)<sup>3</sup> 0.051 in/min (1.3 mm/min)**CONTACT INFORMATION****Americas**United States - Avon Lake  
+1 440 930 1000United States - McHenry  
+1 815 385 8500**Asia**China - Guangzhou  
+86 20 8732 7260China - Shenzhen  
+86 755 2969 2888China - Suzhou  
+86 512 6823 24 38China - Suzhou  
+86 512 6265 2600Hong Kong -  
+852 2690 5332Taiwan - Yonghe City,  
+886 9396 99740, +886 2929 1849**Europe**Germany - Gaggenau  
+49 7225 6802 0Spain - Barbastro (Huesca)  
+34 974 310 314*Beyond Polymers.**Better Business Solutions.™*[www.polyone.com](http://www.polyone.com)**PolyOne Americas**33587 Walker Road  
Avon Lake, Ohio 44012  
United States  
+1 440 930 1000  
+1 866 POLYONE**PolyOne Asia**No. 88 Guoshoujing Road  
Z.J Hi-tech Park, Pudong  
Shanghai, 201203, China  
+86 21 5080 1188**PolyOne Europe**6 Giällewee  
+352 269 050 35

Copyright ©, 2016 PolyOne Corporation. PolyOne makes no representations, guarantees, or warranties of any kind with respect to the Information contained in this document about its accuracy, suitability for particular applications, or the results obtained or obtainable using the information. Some of the Information arises from laboratory work with small-scale equipment which may not provide a reliable indication of performance or properties obtained or obtainable on larger-scale equipment. Values reported as "typical" or stated without a range do not state minimum or maximum properties; consult your sales representative for property ranges and min/max specifications. Processing conditions can cause material properties to shift from the values stated in the Information. PolyOne makes no warranties or guarantees respecting suitability of either PolyOne's products or the Information for your process or end-use application. You have the responsibility to conduct full-scale end-product performance testing to determine suitability in your application, and you assume all risk and liability arising from your use of the Information and/or use or handling of any product. POLYONE MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, either with respect to the Information or products reflected by the Information. This data sheet shall NOT operate as permission, recommendation, or inducement to practice any patented invention without permission of the patent owner.