



LubriOne™ AT-000/15T-2S BLACK

Acetal (POM) Copolymer

Key Characteristics

Product Description	
PTFE and Silicone lubricated POM. HP's 4x4 code 4096-2224	
General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• PTFE Micropowder
Features	• Lubricated
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.45	1.45	ASTM D792
Molding Shrinkage	1.8 to 2.2 %	1.8 to 2.2 %	ASTM D955
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength ²	6530 psi	45.0 MPa	ASTM D638
Flexural Modulus ³	305000 psi	2100 MPa	ASTM D790
Flexural Strength ³	9430 psi	65.0 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact (Injection Molded)	0.94 ft-lb/in	50 J/m	ASTM D256A
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load 264 psi (1.8 MPa), Unannealed	185 °F	85.0 °C	ASTM D648
Electrical	Typical Value (English)	Typical Value (SI)	Test Method
Surface Resistivity	> 1.0E+13 ohms	> 1.0E+13 ohms	ASTM D257
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 to 90 °C
Drying Time	2.0 to 3.0 hr	2.0 to 3.0 hr
Processing (Melt) Temp	374 to 392 °F	190 to 200 °C
Mold Temperature	167 to 185 °F	75 to 85 °C

Injection Notes

Injection Pressure: MED-HIGH

Hold Pressure: MED-HIGH

Screw Speed: MODERATE

Back Pressure: LOW

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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