LubriOne™ AT-000/20T NC004 ROHS

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
Density / Specific Gravity	1.50	1.50	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	6.5 g/10 min	6.5 g/10 min	ASTM D1238
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]	6530 psi	45.0 MPa	ASTM D638
Flexural Modulus [3]	297000 psi	2050 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			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 (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 to 90 °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 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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