



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 ¹

| 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 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 | | | UL 94 |
| 0.0591 in (1.50 mm) | HB | HB | |
| 0.118 in (3.00 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 | |

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Notes¹ 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)**CONTACT INFORMATION****Americas**United States - Avon Lake
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