



LubriOne™ AT-000/15T NATURAL

Acetal (POM) Copolymer

Key Characteristics

Product Description	
PTFE lubricated POM	
General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• PTFE Micropowder
Features	• Lubricated
Appearance	• Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.48	1.48	ASTM D792
Molding Shrinkage	1.9 to 2.1 %	1.9 to 2.1 %	ASTM D955
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength ²	7250 psi	50.0 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 (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	194 °F	90.0 °C	ASTM D648
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

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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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