

LubriOne™ AT-000/20T Black

Acetal (POM) Copolymer
PolyOne Corporation

Message:
PTFE lubricated POM compound

General Information			
Additive	PTFE lubricant		
Features	Lubrication		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.50	g/cm ³	ASTM D792
Molding Shrinkage - Flow	1.9 - 2.1	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	45.0	MPa	ASTM D638
Flexural Modulus ²	2050	MPa	ASTM D790
Flexural Strength ³	65.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	40	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	90.0	°C	ASTM D648
Flammability	Nominal Value	Test Method	
Flame Rating		UL 94	
1.50 mm	HB	UL 94	
3.00 mm	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 90.0	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	190 - 200	°C	
Middle Temperature	190 - 200	°C	
Front Temperature	190 - 200	°C	
Mold Temperature	75.0 - 85.0	°C	
Injection instructions			
Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW			
NOTE			
1.	50 mm/min		
2.	1.3 mm/min		
3.	1.3 mm/min		

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