

LubriOne™ AT-000/15T NATURAL

Acetal (POM) Copolymer

PolyOne Corporation

Message:

PTFE lubricated POM

General Information			
UL YellowCard	E76261-101413482		
Filler / Reinforcement	PTFE ultra fine powder		
Features	Lubrication		
Appearance	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.48	g/cm ³	ASTM D792
Molding Shrinkage	1.9 - 2.1	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	50.0	MPa	ASTM D638
Flexural Modulus ²	2250	MPa	ASTM D790
Flexural Strength ³	75.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (Injection Molded)	50	J/m	ASTM D256A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	90.0	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.5 mm	HB		UL 94
3.0 mm	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80 - 90	°C	
Drying Time	2.0 - 3.0	hr	
Processing (Melt) Temp	190 - 200	°C	
Mold Temperature	75 - 85	°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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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519
Phone: +86 13424755533
Email: sales@su-jiao.com
No. 215, Lianhe North Road, Fengxian District, Shanghai, China

