

LubriOne™ AT-000/15T BLACK

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	1.7 - 2.2	%	ASTM D955

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	45.0	MPa	ASTM D638
Flexural Modulus ²	2100	MPa	ASTM D790
Flexural Strength ³	74.0	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (Injection Molded)	53	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-HIGH Hold Pressure: MED-HIGH Screw Speed: MODERATE Back Pressure: LOW

NOTE
1. 50 mm/min
2. 1.3 mm/min
3. 1.3 mm/min

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