

【Inquiries】

AsahiKASEI Engineering Plastics Information Comprehensive Site
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AsahiKASEI



LEONA™ 91G60

Asahi Kasei Corporation - Polyamide 66/6I Copolymer

Wednesday, March 20, 2024

General Information

General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Asia Pacific • Europe • North America
Filler / Reinforcement	• Glass Fiber\Mineral, 60% Filler by Weight
Features AKEP website	• Flow, High • Good appearance • Weather & UV Resistant
Uses	• Automotive Applications • Automotive Exterior Parts • Industrial Applications • Windows & Doors
Automotive Specifications	• GM GMW15702 ¹
Part Marking Code (ISO11469) (ISO 11469)	• >PA66/6I-(GF+MD)60<

Other Documentation

Literature	• Moldflow Data • Molding Conditions • SDS • Technical Handbook
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ASTM & ISO Properties²

Physical	Dry	Conditioned	Unit	Test Method
Density / Specific Gravity	1.72	--	g/cm ³	ASTM D792 ISO 1183
Molding Shrinkage				Internal Method
Across Flow	0.60	--	%	
Flow	0.20	--	%	
Water Absorption				ISO 62
Equilibrium, 23°C, 50% RH	--	1.0	%	

Disclaimer:

- Data shown are typical values obtained by proper testing methods and should not be used for specification purpose. Please use these data for selecting the most appropriate grade suitable for specific usage.

These data may be changed because of improvement in properties.

- Be sure to read the relevant SDS before handling and use, and always follow the Important Precautions.

- Do not use plastics in any of the following orally- or medically-related applications.

- Orally-related applications: any part, device or component which may come into direct oral contact or into direct contact with drinking foods or beverages.

For drinking water application, please consult Asahi Kasei Corporation.

- Medically-related applications: any part, device or component which may be used intracorporeally or which may in dialysis or other processes come into direct or indirect contact with body tissue, body fluids or transfusion fluids.

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Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	17500	16400	MPa	ISO 527-1
Tensile Stress				
Break, 23°C	173	142	MPa	ISO 527-2
--	183	150	MPa	ASTM D638
Tensile Elongation				
Break	3.3	7.6	%	ASTM D638
Break, 23°C	3.0	5.4	%	ISO 527-2
Flexural Modulus				
--	16200	15500	MPa	ASTM D790
23°C	16400	15700	MPa	ISO 178
Flexural Strength				
--	267	246	MPa	ASTM D790
23°C	255	235	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	6.0	6.1	kJ/m ²	ISO 179
Notched Izod Impact	63	64	J/m	ASTM D256
Hardness	Dry	Conditioned	Unit	Test Method
Rockwell Hardness				ASTM D785 ISO 2039-2
M-Scale	95	88		
R-Scale	120	117		
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
0.45 MPa, Unannealed	217	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	200	--	°C	ISO 75-2/A
CLTE - Flow	2.0E-5	--	cm/cm/°C	ASTM D696
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (0.75 mm)	HB	--		UL 94

Processing Information

Injection	Dry	Unit
Drying Temperature - Vacuum Dryer	80 to 90	°C
Drying Time - Vacuum Dryer	2.0 to 3.0	hr
Processing (Melt) Temp	275 to 295	°C
Mold Temperature	85 to 95	°C

Notes

¹ GMW15702-110047

² Typical properties: these are not to be construed as specifications.

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