

【Inquiries】

AsahiKASEI Engineering Plastics Information Comprehensive Site
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AsahiKASEI



LEONA™ FR650

Asahi Kasei Corporation - Polyamide 66/6 Copolymer

Tuesday, March 19, 2024

General Information

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • North America	
Features AKEP website	• Flame Retardant	• Glow Wire Resistant	• Halogen Free
Part Marking Code (ISO11469) (ISO 11469)	• >PA66/6+PA66-FR(30)<		

Other Documentation

- Literature
- [Molding Conditions](#)
 - [SDS](#)
 - [Technical Handbook](#)

ASTM & ISO Properties¹

Physical	Dry	Conditioned	Unit	Test Method
Density	1.26	--	g/cm ³	ISO 1183
Water Absorption				
Saturation, 23°C	--	1.4	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Stress				ISO 527-2
Yield	50.0	33.0	MPa	
Break	51.0	--	MPa	
Tensile Strain (Break)	1.0	6.0	%	ISO 527-2
Flexural Modulus	4500	2200	MPa	ISO 178
Flexural Stress	84.0	60.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	1.0	1.0	kJ/m ²	ISO 179
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ISO 75-2/A
1.8 MPa, Unannealed	110	--	°C	
Electrical	Dry	Conditioned	Unit	Test Method
Comparative Tracking Index	600	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (0.75 mm)	V-0	--		UL 94
Glow Wire Flammability Index				IEC 60695-2-12
3.0 mm	960	--	°C	

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.

LEONA™ FR650**Asahi Kasei Corporation - Polyamide 66/6 Copolymer****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	265 to 275	°C
Mold Temperature	75 to 85	°C

Notes

¹ Typical properties: these are not to be construed as specifications.

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