

LEONA™ 90G33

Asahi Kasei Corporation - Polyamide 66/6I Copolymer

General Information

General	
Material Status	Commercial: Active
Availability	- Africa & Middle East - Asia Pacific - Europe - North America
Filler / Reinforcement	Glass Fiber, 33% Filler by Weight
Features	- High Flow - Pleasing Surface Appearance
Uses	- Automotive Applications - Automotive Interior Parts - Industrial Applications - Structural Parts
Part Marking Code (ISO 11469)	>PA66/6I-GF33<

Properties ¹

Physical	Dry	Conditioned	Unit	Test Method
Density / Specific Gravity	1.39	--		ASTM D792
Density	1.39	--	g/cm ³	ISO 1183
Molding Shrinkage				Internal Method
Across Flow	0.90	--	%	
Flow	0.40	--	%	
Water Absorption (Equilibrium, 73°F, 50% RH)	--	1.4	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (73°F)	1.48E+6	1.35E+6	psi	ISO 527-1
Tensile Strength	28100	22800	psi	ASTM D638
Tensile Stress (Break, 73°F)	26100	21800	psi	ISO 527-2
Tensile Elongation (Break)	3.0	4.0	%	ASTM D638
Tensile Strain (Break, 73°F)	2.5	3.0	%	ISO 527-2
Flexural Modulus	1.39E+6	1.10E+6	psi	ASTM D790
Flexural Modulus (73°F)	1.45E+6	1.17E+6	psi	ISO 178
Flexural Strength	42600	35500	psi	ASTM D790
Flexural Stress (73°F)	34500	31300	psi	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	2.9	5.7	ft·lb/in ²	ISO 179
Charpy Unnotched Impact Strength	26	26	ft·lb/in ²	ISO 179
Notched Izod Impact	1.8	2.2	ft·lb/in	ASTM D256
Hardness	Dry	Conditioned	Unit	Test Method
Rockwell Hardness				ASTM D785
M-Scale	90	--		
R-Scale	120	--		
Rockwell Hardness				ISO 2039-2
M-Scale	90	--		
R-Scale	120	--		
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	455	--	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	428	--	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	428	--	°F	ISO 75-2/A
CLTE - Flow	1.7E-5	--	in/in/°F	ASTM D696

Processing Information



Injection	Dry Unit
Drying Temperature - Vacuum Dryer	176 to 194 °F
Drying Time - Vacuum Dryer	2.0 to 3.0 hr
Processing (Melt) Temp	527 to 563 °F
Mold Temperature	185 to 203 °F

Notes

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

