

LEONA™ 91G55

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\Mineral, 55% Filler by Weight
Features	- High Flow - Pleasing Surface Appearance
Uses	- Automotive Applications - Automotive Exterior Parts - Industrial Applications - Windows & Doors
Part Marking Code (ISO 11469)	>PA66/6I-(GF+MD)55<

Properties ¹

Physical	Dry	Conditioned	Unit	Test Method
Density / Specific Gravity	1.68	--		ASTM D792
Density	1.68	--	g/cm ³	ISO 1183
Molding Shrinkage				Internal Method
Across Flow	1.0	--	%	
Flow	0.20	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (73°F)	2.18E+6	2.03E+6	psi	ISO 527-1
Tensile Strength	27700	23100	psi	ASTM D638
Tensile Stress (Break, 73°F)	26100	21800	psi	ISO 527-2
Tensile Elongation (Break)	4.0	6.0	%	ASTM D638
Tensile Strain (Break, 73°F)	3.0	4.0	%	ISO 527-2
Flexural Modulus	2.02E+6	1.73E+6	psi	ASTM D790
Flexural Modulus (73°F)	2.03E+6	1.74E+6	psi	ISO 178
Flexural Strength	38000	33500	psi	ASTM D790
Flexural Stress (73°F)	36300	31900	psi	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	2.4	2.9	ft·lb/in ²	ISO 179
Notched Izod Impact	1.0	1.2	ft·lb/in	ASTM D256
Hardness	Dry	Conditioned	Unit	Test Method
Rockwell Hardness				ASTM D785
M-Scale	102	--		
R-Scale	120	--		
Rockwell Hardness				ISO 2039-2
M-Scale	102	--		
R-Scale	120	--		
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	428	--	°F	ISO 75-2/A

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

