

LEONA™ 91G60

Asahi Kasei Corporation - Polyamide 66/6I Copolymer

General Information

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

Properties ²

Physical	Dry	Conditioned	Unit	Test Method
Density / Specific Gravity	1.72	--		ASTM D792
Density	1.72	--	g/cm ³	ISO 1183
Molding Shrinkage				Internal Method
Across Flow	0.60	--	%	
Flow	0.20	--	%	
Water Absorption (Equilibrium, 73°F, 50% RH)	--	1.0	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (73°F)	2.54E+6	2.38E+6	psi	ISO 527-1
Tensile Strength	26500	21800	psi	ASTM D638
Tensile Stress (Break, 73°F)	25100	20600	psi	ISO 527-2
Tensile Elongation (Break)	3.3	7.6	%	ASTM D638
Tensile Strain (Break, 73°F)	3.0	5.4	%	ISO 527-2
Flexural Modulus	2.35E+6	2.25E+6	psi	ASTM D790
Flexural Modulus (73°F)	2.38E+6	2.28E+6	psi	ISO 178
Flexural Strength	38700	35700	psi	ASTM D790
Flexural Stress (73°F)	37000	34100	psi	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	2.9	2.9	ft·lb/in ²	ISO 179
Notched Izod Impact	1.2	1.2	ft·lb/in	ASTM D256
Hardness	Dry	Conditioned	Unit	Test Method
Rockwell Hardness				ASTM D785
M-Scale	95	88		
R-Scale	120	117		
Rockwell Hardness				ISO 2039-2
M-Scale	95	88		
R-Scale	120	117		
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	423	--	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	392	--	°F	ISO 75-2/A
CLTE - Flow	1.1E-5	--	in/in/°F	ASTM D696
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (0.030 in)	HB	--		UL 94

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 GMW15702-110047

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

