

LEONA™ 93G33

Asahi Kasei Corporation - Polyamide 6 + PA 66/6

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 - Fabrics - Industrial Applications - Structural Parts
Part Marking Code (ISO 11469)	>PA66/6+PA6-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	0.80	--	%	
Flow	0.30	--	%	
Water Absorption (Equilibrium, 73°F, 50% RH)	--	1.9	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (73°F)	1.36E+6	769000	psi	ISO 527-1
Tensile Strength	24200	15700	psi	ASTM D638
Tensile Stress (Break, 73°F)	25200	15500	psi	ISO 527-2
Tensile Elongation (Break)	4.0	9.0	%	ASTM D638
Tensile Strain (Break, 73°F)	5.5	9.5	%	ISO 527-2
Flexural Modulus	1.25E+6	653000	psi	ASTM D790
Flexural Modulus (73°F)	1.06E+6	696000	psi	ISO 178
Flexural Strength	39900	22800	psi	ASTM D790
Flexural Stress (73°F)	33800	21800	psi	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	5.7	11	ft·lb/in ²	ISO 179
Charpy Unnotched Impact Strength	47	47	ft·lb/in ²	ISO 179
Notched Izod Impact	2.5	4.5	ft·lb/in	ASTM D256
Hardness	Dry	Conditioned	Unit	Test Method
Rockwell Hardness (M-Scale)	90	--		ASTM D785
Rockwell Hardness (M-Scale)	90	--		ISO 2039-2
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	446	--	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	410	--	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	410	--	°F	ISO 75-2/A
CLTE - Flow	1.7E-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	518 to 554 °F
Mold Temperature	167 to 185 °F

Notes

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

