LEONA™ 91G60

PA66-GF — Asahi Kasei

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Tensile Modulus	**17500 / 16400**	MPa	ISO 527
[C] Stress at break	**173 / 142**	MPa	ISO 527
[C] Strain at break	**3 / 5.4**	%	ISO 527
Flexural modulus, 23°C	**16400 / 15700**	MPa	ISO 178
Flexural strength	**255 / 235**	MPa	ISO 178
[C] Charpy notched impact strength, +23°C	**6 / 6**	kJ/m²	ISO 179/1eA
Rockwell hardness	**R 120**	-	ISO 2039-2
ASTM Data			
Tensile Strength	**183 / 150**	MPa	ASTM D 638
Elongation at Break	**3.3 / 7.6**	%	ASTM D 638
Flexural Modulus	**16200 / 15500**	MPa	ASTM D 790
Flexural Strength	**267 / 246**	MPa	ASTM D 790
Rockwell Hardness	**M 95 / M 88**	-	ASTM D 785
Izod Impact notched, 1/8 in	**63 / 64**	J/m	ASTM D 256

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**200 / ***	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**217 / ***	°C	ISO 75-1/-2
[C] Burning Behav. at thickness h	**HB / ***	class	IEC 60695-11-10
Thickness tested	**0.8 / ***	mm	-
Yellow Card available	**yes / ***	-	-
ASTM Data			
UL 94 Flame rating	**HB**	-	UL 94
Thickness tested	**0.75**	mm	-
Coefficient of Thermal Expansion, MD	**20**	E-6/K	ASTM D 696

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
[C] Humidity absorption	**1 / ***	%	Sim. to ISO 62
[C] Density	**1720 / -**	kg/m³	ISO 1183
Density	**1720**	kg/m³	ASTM D 792

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**80 - 90**	°C	-
Pre-drying - Time	**2 - 3**	h	-
Melt temperature	**275 - 295**	°C	-
Mold temperature	**85 - 95**	°C	-

Characteristics

Processing

Injection Molding

Delivery form

Pellets

Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa