

LEONA™ 93G33

Asahi Kasei Corporation - Polyamide 6 + PA 66/6

General Information

General		
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight	
Features AKEP website	• Flow, High	• Good appearance
Uses	• Automotive Applications • Fabrics	• Industrial Applications • Structural Parts
Part Marking Code (ISO11469) (ISO 11469)	• >PA66/6+PA6-GF33<	

ASTM & ISO Properties ¹

Physical	Dry	Conditioned	Unit	Test Method
Density / Specific Gravity	1.39	--	g/cm ³	ASTM D792 ISO 1183
Molding Shrinkage				Internal Method
Across Flow	0.80	--	%	
Flow	0.30	--	%	
Water Absorption				ISO 62
Equilibrium, 23°C, 50% RH	--	1.9	%	



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Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	9400	5300	MPa	ISO 527-1
Tensile Stress				
Break, 23°C	174	107	MPa	ISO 527-2
--	167	108	MPa	ASTM D638
Tensile Elongation				
Break	4.0	9.0	%	ASTM D638
Break, 23°C	5.5	9.5	%	ISO 527-2
Flexural Modulus				
--	8600	4500	MPa	ASTM D790
23°C	7300	4800	MPa	ISO 178
Flexural Strength				
--	275	157	MPa	ASTM D790
23°C	233	150	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	12	23	kJ/m²	ISO 179
Charpy Unnotched Impact Strength	98	98	kJ/m²	ISO 179
Notched Izod Impact	130	240	J/m	ASTM D256
Hardness	Dry	Conditioned	Unit	Test Method
Rockwell Hardness (M-Scale)	90	--		ASTM D785 ISO 2039-2
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
0.45 MPa, Unannealed	230	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	210	--	°C	ASTM D648 ISO 75-2/A
CLTE - Flow	3.0E-5	--	cm/cm/°C	ASTM D696
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (0.75 mm)	HB	--		UL 94

Processing Information

Injection	Dry	Unit
Drying Temperature - Vacuum Dryer	80 to 90	°C
Drying Time - Vacuum Dryer	2.0 to 3.0	hr
Processing (Melt) Temp	270 to 290	°C
Mold Temperature	75 to 85	°C

Notes

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

