

LEONA™ SG104

Asahi Kasei Corporation - Polyamide 66 + PA 6I

General Information

General			
Filler / Reinforcement	• Glass Fiber, 40% Filler by Weight		
Features AKEP website	• Good appearance	• High Strength in Wet	
Uses	• Automotive Applications	• Automotive Interior Parts	• Industrial Applications
Part Marking Code (ISO11469) (ISO 11469)	• >PA66+6I-GF40<		

ASTM & ISO Properties ²

Physical	Dry	Conditioned	Unit	Test Method
Density	1.46	--	g/cm ³	ISO 1183
Molding Shrinkage				Internal Method
Across Flow	0.70	--	%	
Flow	0.20	--	%	
Water Absorption				ISO 62
Equilibrium, 23°C, 50% RH	--	1.5	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	13000	13000	MPa	ISO 527-1
Tensile Stress (Break, 23°C)	230	200	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	3.0	3.0	%	ISO 527-2
Flexural Modulus (23°C)	13000	12000	MPa	ISO 178
Flexural Stress (23°C)	320	310	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	15	14	kJ/m ²	ISO 179
Hardness	Dry	Conditioned	Unit	Test Method
Rockwell Hardness (M-Scale)	102	98		ISO 2039-2



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Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
0.45 MPa, Unannealed	250	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	235	--	°C	ISO 75-2/A
CLTE				ASTM D696
Flow : -30 to 130°C	1.2E-5	--	cm/cm/°C	
Transverse : -30 to 130°C	9.0E-5	--	cm/cm/°C	
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+16	--	ohms	IEC 60093
Volume Resistivity	1.0E+15	--	ohms·cm	IEC 60093
Electric Strength	40	--	kV/mm	IEC 60243-1
Comparative Tracking Index	575	--	V	IEC 60112

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	280 to 300	°C	
Mold Temperature	100 to 120	°C	

Notes

- ¹ All data is provisional.
- ² Typical properties: these are not to be construed as specifications.

