

LEONA™ SH10E M120530

Asahi Kasei Corporation - Polyamide 66 + PA 6I

General Information

General		
Filler / Reinforcement	• Glass Fiber, 55% Filler by Weight	
Additive	• Flame Retardant	
Features AKEP website	• Flame Retardant • Good appearance	• Halogenated • High Strength in Wet
Uses	• Connectors • Electrical Parts	• Electrical/Electronic Applications • Switches
Part Marking Code (ISO11469) (ISO 11469)	• >PA66+6I-GF55 FR(17)<	

ASTM & ISO Properties ²

Physical	Dry	Conditioned	Unit	Test Method
Density	1.86	--	g/cm ³	ISO 1183
Molding Shrinkage				Internal Method
Across Flow	0.60	--	%	
Flow	0.20	--	%	
Water Absorption				ISO 62
Equilibrium, 23°C, 50% RH	--	0.70	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	22600	22600	MPa	ISO 527-1
Tensile Stress (Break, 23°C)	238	209	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	1.4	1.4	%	ISO 527-2
Flexural Modulus (23°C)	22000	22000	MPa	ISO 178
Flexural Stress (23°C)	365	320	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	18	18	kJ/m ²	ISO 179



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Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load 1.8 MPa, Unannealed	233	--	°C	ISO 75-2/A
Electrical	Dry	Conditioned	Unit	Test Method
Comparative Tracking Index	300	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (1.5 mm, white)	V-0	--		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	275 to 290	°C	
Mold Temperature	110 to 130	°C	

Notes

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

