

# Aegis® H120MP

Polyamide 6

Honeywell

## Message:

Aegis® H120MP is a lubricated and nucleated high viscosity nylon 6 extrusion grade homopolymer for cast or blown film applications. It conforms to FDA requirements of 21 CFR 177.1500 as well as EU Directive 2002/72/EC. It possesses the combination of strength, toughness and thermoforming properties associated with nylon 6 as well as excellent heat, chemical, and abrasion resistance.

General Information	
Additive	Nucleating agent Lubricant
Features	Nucleated Homopolymer Good strength Good wear resistance Good chemical resistance Heat resistance, high Good toughness Lubrication Medium viscosity
Uses	Packaging cast film
Agency Ratings	FDA 21 CFR 177.1500 European 2002/72/EC
Forms	Particle
Processing Method	Blow film Extrusion cast film

Physical	Nominal Value	Unit	Test Method
Density	1.13	g/cm <sup>3</sup>	ASTM D1505
Melt Mass-Flow Rate (MFR) (235°C/1.0 kg)	1.9	g/10 min	ASTM D1238
Water Absorption			ASTM D570
24 hr	1.6	%	ASTM D570
Saturation	9.5	%	ASTM D570
Balance	2.7	%	ASTM D570
Moisture Content		%	

Relative viscosity-@ 96% Sulfuric Acid	3.60		
Viscosity-FAV	120		ASTM D789
Films	Nominal Value	Unit	Test Method
Carbon Dioxide Transmission Rate (23°C)	72.8	cm <sup>3</sup> /m <sup>2</sup> /24 hr	ASTM D1434
Nitrogen Transmission Rate (23°C)	14.0	cm <sup>3</sup> /m <sup>2</sup> /24 hr	ASTM D1434
Oxygen Transmission Rate (23°C)	40	cm <sup>3</sup> /m <sup>2</sup> /24 hr	ASTM D3985
Water Vapor Transmission Rate (38°C, 100% RH)	990	g/m <sup>2</sup> /24 hr	ASTM F1249
Thermal	Nominal Value	Unit	
Melting Temperature	220	°C	
Additional Information			
Extractible Content: <0.8 %			
Extrusion	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Cylinder Zone 1 Temp.	230 - 260	°C	
Cylinder Zone 2 Temp.	230 - 260	°C	
Cylinder Zone 3 Temp.	230 - 260	°C	
Cylinder Zone 4 Temp.	230 - 260	°C	
Cylinder Zone 5 Temp.	230 - 260	°C	
Adapter Temperature	260 - 266	°C	
Melt Temperature	260 - 270	°C	
Die Temperature	260	°C	
Extrusion instructions			

The values listed above in Extrusion are for cast film. Typical Barrel Profile for Tubular (Blown) Films:

Barrel Temperature: 246 to 254°C (474 to 490°F)

Adapter Temperature: 260°C (500°F)

Die Temperature: 254°C (490°F)

Processing Melt Temperature: 254 to 260°C (490 to 500°F)

Screw Parameters:

Metering section: 40%

Transition section: 3 to 4 flights

Feed section balance of screw length

Compression ratio: 3.5:1 to 4.0:1

L/D ratio: 24:1

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### Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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