

Aegis® H135MP

Polyamide 6

Honeywell

Message:

Aegis® H135MP is a lubricated and nucleated high viscosity nylon 6 extrusion grade homopolymer for cast or blown film. 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
	Viscosity, High
Uses	Packaging
	cast film
Agency Ratings	FDA 21 CFR 177.1500
	European 2002/72/EC
Forms	Particle
Processing Method	Blow film
	Extrusion
	cast film
	Thermoforming

Physical	Nominal Value	Unit	Test Method
Density	1.13	g/cm ³	ASTM D1505
Melt Mass-Flow Rate (MFR) (235°C/1.0 kg)	1.2	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

Relative viscosity-@ 96% Sulfuric Acid	3.75		
Viscosity-FAV	135		ASTM D789
Elmendorf Tear Strength			ASTM D1922
MD : 23°C	840	N	ASTM D1922
TD : 23°C	1140	N	ASTM D1922
Graves Tear			ASTM D1004
MD : 23°C	2540	N	ASTM D1004
TD : 23°C	2230	N	ASTM D1004
Puncture Index ¹	480.000	g/cm ³	
Puncture Resistance (23°C) ²	940	g	
Films	Nominal Value	Unit	Test Method
Elastic Modulus - MD ³	640	MPa	ASTM D882
Elastic Modulus - TD ⁴	610	MPa	ASTM D882
Tensile Strength ⁵			ASTM D882
MD: Yield	30.0	MPa	ASTM D882
TD: Yield	30.0	MPa	ASTM D882
MD: Fracture	100	MPa	ASTM D882
TD: Fracture	100	MPa	ASTM D882
Tensile Elongation ⁶			ASTM D882
MD: Fracture	350	%	ASTM D882
TD: Fracture	360	%	ASTM D882
Carbon Dioxide Transmission Rate (23°C)	72.8	cm ³ /m ² /24 hr	ASTM D1434
Nitrogen Transmission Rate (23°C)	14.0	cm ³ /m ² /24 hr	ASTM D1434
Oxygen Transmission Rate (23°C)	40	cm ³ /m ² /24 hr	ASTM D3985
Water Vapor Transmission Rate (38°C, 100% RH)	990	g/m ² /24 hr	ASTM F1249
Thermal	Nominal Value	Unit	
Melting Temperature	220	°C	
Additional Information	Nominal Value	Unit	
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

NOTE	
1.	ASTM D1306
2.	ASTM D1306
3.	23°C
4.	23°C
5.	23°C
6.	23°C

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