Aegis® H135QP

Polyamide 6

Honeywell

Message:

Aegis® H135QP is a lubricated, 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	Lubricant
Features	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	Film extrusion Blow film cast film Thermoforming

Physical	Nominal Value	Unit	Test Method
Density	1.13	g/cm³	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
Moisture Content		%	

Films	Nominal Value	Unit	Test Method
Carbon Dioxide Transmission Rate (23°C)	72.8	cm³/m²/24 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

Thermal	Nominal Value	Unit
Melting Temperature	220	°C

Additional Information
FAV, ASTM D789: 13596% SAV: 3.75Extractible 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

Recommended distributors for this material

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