

Aegis® H155ZP Nylon 6 Extrusion Grade Homopolymer

Description

Aegis® H155ZP is a 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 2011/10/EC. Aegis® H155ZP possesses the combination of strength, toughness and thermoforming properties associated with nylon 6 as well as excellent heat, chemical and abrasion resistance.

General Properties	Test Method	Unit	Value
Parameter			
Viscosity, FAV	ASTM D-789		155
SAV @ 96% Sulfuric Acid			4.0
Extractable Content	SOP-702-307	%	Max. 0.8
Specific Gravity, 23°C (73.4°F)	ASTM D-792		1.13
Melt Flow Rate, 235°C, 1.0 kg (455°F, 1.0 kg)	ASTM D-1238	g/10 min	1.1
Moisture			
Moisture Content	ASTM D-6869	%	Max. 0.08
Moisture (24 Hour)	ASTM D-570	%	1.6
Moisture (50% RH)	ASTM D-570	%	2.7
Moisture (Saturation)	ASTM D-570	%	9.5
Thermal			
Melting Point	ASTM D-3418	°C (°F)	220°C (428°F)

Film Properties	Test Method	Unit	Value
Gas Barrier @ 23°C (73°F)/0% RH			
Oxygen Permeability	D-3958	cc-mil/m ² /day	40.3
Water Vapor Permeability @ 38°C (100°F)/100% RH	F-1249	gm-mil/m ² /day	992
Nitrogen Permeability		cc-mil/m ² /day	14.0
Carbon Dioxide Permeability		cc-mil/m ² /day	72.8

The values presented in this data sheet are typical values and are not to be interpreted as product specifications.

Page 1 of 3

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Film Properties	Test Method	Unit	Value (MD)*	Value (TD)*
Mechanical				
Tensile Modulus, 23°C (73°F)	ASTM D-882	MPa	650	590
Tensile Yield, 23°C (73°F)	ASTM D-882	MPa	30	30
Tensile Strength, 23°C (73°F)	ASTM D-882	MPa	80	60
Elongation, 23°C (73°F)	ASTM D-882	%	310	280
Graves Tear, 23°C (73°F)	ASTM D-1004	N	2,760	2,520
Elmendorf Tear Strength, 23°C (73°F)	ASTM D-1922	N	1,130	750
Puncture Strength, 23°C (73°F)	ASTM D-5478	grams	940	-
Puncture Index, 23°C (73°F)	ASTM D-5478	gm/mil	500	-

*Note: MD = Machine Direction and TD = Traverse Direction. Test specimens were obtained from 2-mil thick unoriented cast film and tested as is.

Molded Properties	Test Method	Unit	Value
Mechanical			
Tensile Modulus, 23°C (73°F)	ASTM D-882	MPa	2,680
Tensile Strength, 23°C (73°F)	ASTM D-882	MPa	80
Yield Elongation 23°C (73°F)	ASTM D-882	%	4.1
Flexural Modulus, 23°C (73°F)	ASTM D790	MPa	2,580
Flexural Strength, 23°C (73°F)	ASTM D-790	MPa	100
Notched Izod, 23°C (73°F)	ASTM D-256	J/m	70
Heat Deflection Temperature, 23°C (73°F)	ASTM D-648	°C	55

Processing conditions for test specimens: melt temperature = 240°C (464°F); mold temperature = 80°C (176°F).

Processing Guidelines

Material Handling

This product is supplied in sealed containers and drying prior to processing is not required. However, high moisture is the primary cause of processing problems. If drying becomes necessary, a dehumidifying or desiccant dryer operating at 80°C (176°F) is recommended. Drying time is dependent on moisture level. Further information concerning safe handling procedures can be obtained from the Safety Data Sheet. Alternatively, please contact your AdvanSix representative.

Extrusion Guidelines

Melt Viscosity vs. Temperature

Melt Temperature: 220°C (428°F)

Two main factors affect the melt viscosity (stiffness or fluidity of the melt):

1. The molecular weight (MW) of the resin: Higher MW resins will have a higher melt viscosity than lower MW resins.
2. Temperature of the melt for any given MW resin: Higher process temperatures will provide a more fluid melt viscosity than lower process temperatures.

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Page 2 of 3

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Typical Barrel Profile for Cast Films

Barrel: 230-260°C (446-500°F)

Adapter: 260-266°C (500-510°F)

Die: 260°C (500°F)

Process Melt Temperature: 260-270°C (500-518°F)

Typical Barrel Profile for Tubular (Blown) Films

Barrel: 246-254°C (474-490°F)

Adapter: 260°C (500°F)

Die: 254°C (490°F)

Process Melt Temperature: 254-260°C (490-500°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

Metering Section Flight Depth

Screw Diameter	Recommended Depth
1"	0.055"
1.5"	0.060"
2"	0.070"
2.5"	0.080"
3.5"	0.100"
4.5"	0.115"
6"	0.135"

Note: The values in this data sheet are for natural color resins only. Colorants or other additives may alter some or all of these properties. The data listed here fall within the normal range of product properties, but should not be used to establish specification limits nor used alone as the basis of design.

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Page 3 of 3

Contact AdvanSix

To learn more about the benefits of
of Aegis® Nylon Resins, visit

[AdvanSix.com/NylonSolutions](https://www.advan-six.com/NylonSolutions) or call:

1-844-890-8949 (toll free, U.S./Can.)

+1-973-526-1800 (international)

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AdvanSix

300 Kimball Drive, Suite 101
Parsippany, NJ 07054



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