

## DESCRIPTION

Aegis® PCR-H135MP resin from AdvanSix is certified as 100% post-consumer recycled (PCR) raw materials<sup>1</sup> while providing the same top performance and processability as Aegis® H135MP, its standard, non-recycled counterpart.

Aegis® PCR-H135MP 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 2011/10/EC. Aegis® PCR-H135MP homopolymer possesses the combination of strength, toughness and thermoforming properties associated with nylon 6 as well as excellent heat, chemical and abrasion resistance.

## PERFORMANCE OVERVIEW

TYPICAL PROPERTIES	TEST METHOD	UNIT	VALUE
<b>PARAMETER</b>			
Viscosity, FAV	ASTM D-789		135
RV @ 96% Sulfuric Acid			3.75
Extractable Content	SOP-702-307	%	Max. 0.8
Density	ASTM D-792	g/cm <sup>3</sup>	1.13
Melt Flow Rate, 235°C/1.0 kg (455°F/1.0 kg)	ASTM D-1238	g/10 min	1.2
<b>MOISTURE</b>			
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
Melting Point	ASTM D-3418	°C (°F)	220 °C (428°F)

FILM PROPERTIES	TEST METHOD	UNIT	VALUE
<b>GAS BARRIER @ 23°C (73°F)/0% RH</b>			
Oxygen Permeability	D-3958	cc/m <sup>2</sup> /day	40.3
Water Vapor Permeability @ 38°C (100°F)/100% RH	F-1249	gm-mil/m <sup>2</sup> /day	992
Nitrogen Permeability		cc/m <sup>2</sup> /day	14.0
Carbon Dioxide Permeability		cc/m <sup>2</sup> /day	72.8

<sup>1</sup> Using an industry-accepted mass balance method, AdvanSix allocates recycled material into 100% PCR Aegis® resins. PCR grades are certified by an independent third-party organization (SCS Global Services) for recycled content, with annual audits.

FILM PROPERTIES	TEST METHOD	UNIT	VALUE (MD)*	VALUE (TD)*
<b>MECHANICAL</b>				
Tensile Modulus, 23°C (73°F)	ASTM D-882	MPa	640	610
Tensile Yield, 23°C (73°F)	ASTM D-882	MPa	30	30
Tensile Strength, 23°C (73°F)	ASTM D-882	MPa	100	100
Elongation, 23°C (73°F)	ASTM D-882	%	350	360
Graves Tear, 23°C (73°F)	ASTM D-1004	N	2540	2230
Elmendorf Tear Strength, 23°C (73°F)	ASTM D-1922	N	840	1140
Puncture Strength, 23°C (73°F)	ASTM D-5478	grams	940	-
Puncture Index, 23°C (73°F)	ASTM D-5478	gm/mil	480	-

MOLDED PROPERTIES	TEST METHOD	UNIT	VALUE
<b>MECHANICAL</b>			
Tensile Modulus, 23°C (73°F)	ASTM D-882	MPa	3,130
Tensile Strength, 23°C (73°F)	ASTM D-882	MPa	80
Yield Elongation, 23°C (73°F)	ASTM D-882	%	3.7
Flexural Modulus, 23°C (73°F)	ASTM D-790	MPa	2,690
Flexural Strength, 23°C (73°F)	ASTM D-790	MPa	100
Notched Izod, 23°C (73°F)	ASTM D-256	J/m	60
Heat Deflection Temperature, 23°C (73°F)	ASTM D-648	°C (°F)	57 (135)

\* Note: MD = Machine Direction and TD = Transverse Direction. Test samples obtained from 2-mil thick unoriented cast film. Processing conditions for test specimens: melt temperature = 240°C (464°F); mold temperature = 80°C (176°F).

## PROCESSING GUIDELINES

### MATERIAL HANDLING

Aegis® PCR-H135MP is supplied in sealed containers and drying prior to processing is not required. However, high moisture is the primary cause of processing issues. If drying becomes necessary, a dehumidifying or desiccant dryer operating at 80°C (176°F) is recommended. Drying time is dependent on moisture level. More information about safe handling procedures can be obtained by requesting the Safety Data Sheet on [AdvanSix.com](http://AdvanSix.com).

## EXTRUSION GUIDELINES

### MELT VISCOSITY VS. TEMPERATURE

Melting point: 220°C (428°F)

Melt Temperature Range: 232°C (450°F) to 271°C (520°F)

Two key 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.

### 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)

## EXTRUSION GUIDELINES (CONTINUED)

### 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.*

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

### CONTACT ADVANSIX

Contact AdvanSix to learn more about the benefits of Aegis® Nylon Resins.

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