

## DESCRIPTION

Aegis® PIR-H135QP resin from AdvanSix is certified as 100% post-industrial recycled (PIR) raw materials<sup>1</sup> while providing the same top performance and processability as Aegis® H135QP, its standard, non-recycled counterpart.

Aegis® PIR-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 2011/10/EC. Aegis® PIR-H135QP 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	ASTM TEST METHOD	DRY	CONDITIONED
<b>PARAMETER</b>			
Viscosity, FAV	D-789	135	-
96% SAV		3.75	-
Melt Flow Rate, 235°C/1.0 kg (455°F/1.0 kg)	D-1238	1.2	-
<b>GAS BARRIER</b>			
Oxygen Permeability, cc/m <sup>2</sup> /day (cc/100 in <sup>2</sup> /day)		40.3 (2.600)	-
Nitrogen Permeability, cc/m <sup>2</sup> /day (cc/100 in <sup>2</sup> /day)		14.0 (0.903)	-
Carbon Dioxide Permeability, cc/m <sup>2</sup> /day (cc/100 in <sup>2</sup> /day)		72.8 (4.697)	-
<b>MOISTURE</b>			
Moisture Content, %		Max. 0.08	-
Extractable Content, %		Max 0.8	-
Water Absorption in 24 hrs, %		1.6	-
Equilibrium Moisture @ 50%, RH, %		2.7	-
Saturation Moisture Content, %		9.5	-
<b>DENSITY, g/cm<sup>3</sup></b>	D-1505	1.13	-
<b>THERMAL</b>			
Melting Point, °C (°F)	D-3418	220 °C (428°F)	-

## PROCESSING GUIDELINES

### MATERIAL HANDLING

Aegis® PIR-H135QP is supplied in sealed containers and drying prior to processing is not required. However, higher 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).

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

## 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)

### 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"



100% MASS BALANCED  
RECYCLED CONTENT  
PRE-CONSUMER

### 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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