

DESCRIPTION

Aegis® PCR-H85NP resin from AdvanSix contains 100% post-consumer recycled (PCR) raw materials¹ while providing the same top performance and processability as Aegis® H85NP, its standard, non-recycled counterpart. Aegis® PCR-H85NP is a medium viscosity, nylon 6 extrusion grade homopolymer for cast or blown BOPA film. The resin itself conforms to the US FDA requirements of 21 CFR 177.1500 as well as EU Directive 2011/10/EC. In its various amended forms to date, however, and articles and films produced therefrom must independently be confirmed to conform to the requirements of food contact regulations in the pertinent markets. Aegis® PCR-H85NP homopolymer possesses the combination of strength, toughness and thermoforming properties associated with nylon 6 as well as excellent heat, chemical and abrasion resistance.

PHYSICAL AND CHEMICAL PROPERTIES

GENERAL PROPERTIES	TEST METHOD	UNIT	VALUE
Parameter			
Viscosity, FAV	ASTM D-789		85
96% SAV			3.19
Melt Flow Rate, 235°C/1.0 kg (455°F/1.0 kg)	ASTM D-1238	g/10 min	3.5
Moisture			
Moisture Content	ASTM D-6869	%	Max. 0.08
Extractable Content	SOP-702-307	%	Max. 0.6
Moisture (24 Hour)	ASTM D-570	%	1.6
Moisture (50% RH)	ASTM D-570	%	2.7
Moisture (Saturation)	ASTM D-570	%	9.5
Density	ASTM D-1505	g/cm ³	1.13
Thermal			
Melting Point	ASTM D-3418	°C (°F)	220°C (428°F)
GAS BARRIER FILM PROPERTIES	TEST METHOD	UNIT	VALUE
Oxygen Permeability @ 23°C (73°F)/0% RH	ASTM D-3985	cc.25µm/m ² /day (cc-mil/100 in ² /day)	40.3 (2.6)
Water Vapor Permeability @ 38°C (100°F)/100% RH	F-1249	gm.25µm/m ² /day (gm-mil/100 in ² /day)	992 (64)
Nitrogen Permeability @ 23°C (73°F)/80% RH	ASTM D-1434	cc.25µm/m ² /day (cc-mil/100 in ² /day)	14.0 (0.9)
Carbon Dioxide Permeability @ 23°C (73°F)/100% RH	ASTM D-1434	cc.25µm/m ² /day (cc-mil/100 in ² /day)	72.8 (4.7)

¹ 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.

PROCESSING GUIDELINES

Material Handling

Aegis® PCR-H85NP is supplied in sealed containers and drying prior to processing is typically 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](https://www.advansix.com).

EXTRUSION GUIDELINES

Melt Viscosity vs. Temperature

Melt Temperature: 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"



NOTE

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

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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