

## UBE NYLON 6434MT1

### Technical Product Information: AIR-BLOWN – PA monolayer film properties

UBE NYLON 6434MT1 (TERPALEX®) is a soft Polyamide 6/6.6/12 terpolymer. This material has the following features:

- Outstanding processability
- Outstanding flexibility
- Outstanding puncture resistance
- Outstanding pin hole resistance

Basic Properties <sup>(1)</sup>	Method	Unit	Value
<b>Polymer</b>	-	-	PA6/6.6/12
<b>Melting Point</b>	ISO 11357	°C	188
<b>Relative Viscosity (96% H<sub>2</sub>SO<sub>4</sub>)</b>	JIS K6810	-	3,93
<b>Density</b>	DIN 53479	g/cm <sup>3</sup>	1,14

Mechanical Properties <sup>(2)</sup>	Method	Unit	Value
<b>Tensile strength at yield</b>	ISO 527-3	MPa	21 - 25
<b>Tensile strength at break</b>		MPa	115 - 135
<b>Tensile elongation at break</b>		%	495 - 515
<b>Tensile modulus</b>		MPa	400 - 500
<b>Tear resistance</b>	ASTM D 1922	N	2,2 - 2,4
<b>Puncture energy</b>	JAS P-1019	mJ	33 - 35
<b>Puncture deformation</b>		mm	10,5 - 11,5
<b>Spencer impact resistance</b>	ASTM D 3420	mJ	850 - 950
<b>Flex crack (23°C, 1000 cycles / 5°C, 100 cycles)</b>	Mil B-131C	Holes/0,04m <sup>2</sup>	< 5 / 0

Optical Properties <sup>(2)</sup>	Method	Unit	Value
<b>Haze</b>	ASTM D 1003	%	4 - 6
<b>Gloss</b>	ASTM D 523	%	110 - 130

Gas Barrier <sup>(2)</sup>	Method	Unit	Value
<b>Oxygen (T=23°C, RH=0%)</b>	ASTM D 3985	ml/m <sup>2</sup> .day	54 - 56
<b>Water Vapour (T=40°C, RH=90%)</b>	JIS Z-0208	g/m <sup>2</sup> .day	150 - 170



Slip Properties <sup>(2)</sup>		Method	Unit	Value
Coefficient of friction (static)	ASTM D 1894	-		0,84 - 0,88
Coefficient of friction (dynamic)		-		0,84 - 0,88

Thermoforming Properties <sup>(2)</sup>		Method	Unit	Value
Max. Thermoforming depth	UBE METHOD		mm	90 - 100

Regulation	Method	Unit	Value
FDA / EC	-	-	- / -

I: Approved for indirect food contact D: Approved for direct food contact

(1) Measured on base resin

(2) All tests carried out with a 5 layers airblown line, Die diameter = 90 mm · Die gap=1,4 mm

Structure: PE (outer) / PE / PA (medium) / PE / PE (inner), PA layer delaminated for the tests

Layer thickness distribution: PE = 50 µm, PA = 50 µm, PE = 50 µm (Total film thickness = 150 µm) · Cooling conditions: Chiller temp. = 13 °C · Take off rolls = 35 °C

Film orientation: Blow-up ratio = 2,1 · Take-off speed = 6m min-1 · Sample conditioning and testing conditions: T = 23°C, RH =50%

## Processing conditions

	Extruder					Adaptor	Die
	Hopper	Zone 1	Zone 2	Zone 3	Zone 4		
Temperature (°C)	40 - 120	180 - 200	220 - 240	230 - 250	225 - 245	230 - 250	230 - 250

## Drying conditions

UBE NYLON is supplied dry (moisture content < 0,1%) and packed in high barrier films. However, as polyamide is a hygroscopic material, the user should take a special care of the possible moisture absorption once the bag or liner box has been opened. In case of moisture absorption, the material should be dried with dehumidified air at 80°C for more than 4 hours.

## Storage

Well-sealed packages could be stored in cool and dry conditions over long periods of time. Protect the packages from heat and direct sunlight to prevent possible damages.

