

EcoPaXX® Q-KV

Polyamide 410
DSM Engineering Plastics

Message:

EcoPaXX® Q-KV is a Polyamide 410 (Nylon 410) material. It is available in Asia Pacific, Europe, or North America for extrusion or film extrusion. Important attributes of EcoPaXX® Q-KV are:

Flame Rated
Flame Retardant
Eco-Friendly/Green
Halogen Free

Typical applications include:

Fabrics/Fibers
Film

General Information	
Additive	Flame Retardant
Features	Flame Retardant
	Halogen Free
	Low (to None) Phosphorus Content
	Renewable Resource Content
Uses	Film
	Monofilaments
Processing Method	Extrusion
	Film Extrusion

Physical	Dry	Conditioned	Unit	Test Method
Density	1.15	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	0.80	--	%	
Flow	1.2	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	3500	2000	MPa	ISO 527-2
Tensile Stress (Break)	75.0	50.0	MPa	ISO 527-2
Tensile Strain				ISO 527-2
Yield	4.0	--	%	
Break	5.5	35	%	
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	3.2	5.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	60	--	kJ/m ²	ISO 179/1eU

Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	190	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	110	--	°C	ISO 75-2/A
Melting Temperature ¹	250	--	°C	ISO 11357-3
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	--	6.0E+13	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	7.0E+13	ohms·cm	IEC 60093
Electric Strength	32	27	kV/mm	IEC 60243-1
Comparative Tracking Index	--	600	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flammability Classification				IEC 60695-11-10, -20
0.750 mm	V-2	--		
1.50 mm	V-2	--		
Glow Wire Flammability Index (0.750 mm)	960	--	°C	IEC 60695-2-12
Glow Wire Ignition Temperature (0.750 mm)	960	--	°C	IEC 60695-2-13
Additional Information	Dry	Conditioned	Unit	Test Method
Biobased Content - Carbon	62	--	%	ASTM D6866
Injection	Dry	Unit		
Drying Temperature	80.0		°C	
Drying Time	4.0 to 8.0		hr	
Rear Temperature	255 to 265		°C	
Middle Temperature	260 to 270		°C	
Front Temperature	260 to 270		°C	
Nozzle Temperature	260 to 275		°C	
Processing (Melt) Temp	260 to 280		°C	
Mold Temperature	60.0 to 100		°C	
Injection Rate	Moderate-Fast			
Back Pressure	3.00 to 10.0		MPa	
Screw Compression Ratio	2.5:1.0			
NOTE				
1.	10°C/min			

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