

EcoPaXX® Q210E-H

Polyamide 410

DSM Engineering Plastics

Message:

EcoPaXX® Q210E-H is a Polyamide 410 (Nylon 410) material. This product is available in North America, Europe or Asia Pacific.

EcoPaXX® The main features of the Q210E-H are:

high viscosity

environmental protection/green

heat stabilizer

General Information				
Additive	heat stabilizer			
Features	Updatable resources			
	Thermal Stability			
	Viscosity, High			

Physical	Dry	Conditioned	Unit	Test Method
Density	1.09	--	g/cm ³	ISO 1183
Water Absorption				ISO 62
Saturated, 23°C	5.8	--	%	ISO 62
Equilibrium, 23°C, 50% RH	1.9	--	%	ISO 62
Viscosity Number	210	--	cm ³ /g	ISO 307
Biomass Content-Bio C/Total C ¹	70	--	%	ASTM D6866

Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	3000	1600	MPa	ISO 527-2
Tensile Stress				ISO 527-2
Yield	80.0	55.0	MPa	ISO 527-2
Fracture	55.0	40.0	MPa	ISO 527-2
Tensile Strain				ISO 527-2
Yield	4.4	15	%	ISO 527-2
Fracture	30	> 50	%	ISO 527-2
Flexural Modulus	2850	1400	MPa	ISO 178
Flexural Stress	115	55.0	MPa	ISO 178

Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.0	13	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break	No Break		ISO 179/1eU

Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				

0.45 MPa, not annealed	175	--	°C	ISO 75-2/B
1.8 MPa, not annealed	77.0	--	°C	ISO 75-2/A
Melting Temperature ²	250	--	°C	ISO 11357-3
Injection	Dry	Unit		
Drying Temperature	80		°C	
Drying Time	4.0 - 8.0		hr	
Rear Temperature	250 - 270		°C	
Middle Temperature	260 - 280		°C	
Front Temperature	270 - 290		°C	
Nozzle Temperature	270 - 300		°C	
Processing (Melt) Temp	270 - 300		°C	
Mold Temperature	60 - 100		°C	
Injection Rate	Moderate-Fast			
Back Pressure	3.00 - 10.0		MPa	
Screw Compression Ratio	2.5:1.0			

NOTE

1. Method B
2. 10°C/min

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