

EcoPaXX® Q-HGM24

Polyamide 410
DSM Engineering Plastics

Message:

EcoPaXX® Q-HGM24 is a Polyamide 410 (Nylon 410) material filled with 10% glass fiber and 20% mineral. It is available in Asia Pacific, Europe, or North America.

Important attributes of EcoPaXX® Q-HGM24 are:

Flame Rated
Eco-Friendly/Green
Heat Stabilizer

General Information				
Filler / Reinforcement		Glass Fiber,10% Filler by Weight Mineral,20% Filler by Weight		
Additive		Heat Stabilizer		
Features		Heat Stabilized Renewable Resource Content		
Forms		Granules		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.34	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	1.1	--	%	
Flow	0.65	--	%	
Water Absorption (Equilibrium, 23°C, 50% RH)	1.5	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	8000	6000	MPa	ISO 527-2
Tensile Stress (Break)	95.0	65.0	MPa	ISO 527-2
Tensile Strain (Break)	2.5	3.6	%	ISO 527-2
Flexural Modulus	6650	4400	MPa	ISO 178
Flexural Stress	175	115	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	4.0	--	kJ/m ²	
23°C	4.0	5.3	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	30	--	kJ/m ²	
23°C	35	40	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method

Heat Deflection Temperature				
0.45 MPa, Unannealed	235	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	200	--	°C	ISO 75-2/A
Melting Temperature ¹	250	--	°C	ISO 11357-3
CLTE				ISO 11359-2
Flow	4.8E-5	--	cm/cm/°C	
Transverse	7.5E-5	--	cm/cm/°C	
Flammability	Dry	Conditioned		Test Method
Flammability Classification				IEC 60695-11-10, -20
0.750 mm	HB	--		
1.50 mm	HB	--		
Additional Information	Dry	Conditioned	Unit	Test Method
Biobased Content - Carbon	70	--	%	ASTM D6866
Injection	Dry	Unit		
Drying Temperature	80.0		°C	
Drying Time	4.0 to 8.0		hr	
Rear Temperature	250 to 270		°C	
Middle Temperature	260 to 280		°C	
Front Temperature	270 to 290		°C	
Nozzle Temperature	270 to 300		°C	
Processing (Melt) Temp	275 to 310		°C	
Mold Temperature	80.0 to 140		°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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