

EcoPaXX® Q-HXGM24

Polyamide 410
DSM Engineering Plastics

Message:

EcoPaXX® Q-HXGM24 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. Primary attribute of EcoPaXX® Q-HXGM24: Heat Stabilizer.

General Information				
Filler / Reinforcement		Glass Fiber,10% Filler by Weight Mineral,20% Filler by Weight		
Additive		Heat Stabilizer		
Features		Heat Stabilized		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.34	--	g/cm ³	ISO 1183
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
Nominal Tensile Strain at Break	2.5	3.6	%	ISO 527-2
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	225	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	190	--	°C	ISO 75-2/A
Melting Temperature ¹	250	--	°C	ISO 11357-3
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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Recommended distributors for this material

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