

TECHNICAL DATA SHEET

# EcoPaXX® Q-HGM24

Envalior  
PA410-(GF+MD)30

**Processing**

Injection molding

**Delivery Form**

Granules

**Additives**

Release agent

**Special Characteristics**

Heat stabilized or stable to heat

**Certifications**

Contains renewable resources

## Product Text

**Product Information**

10% Glass Reinforced, 20% Mineral Reinforced, Heat Stabilized

ISO 1043 PA410-(GF+MD)30

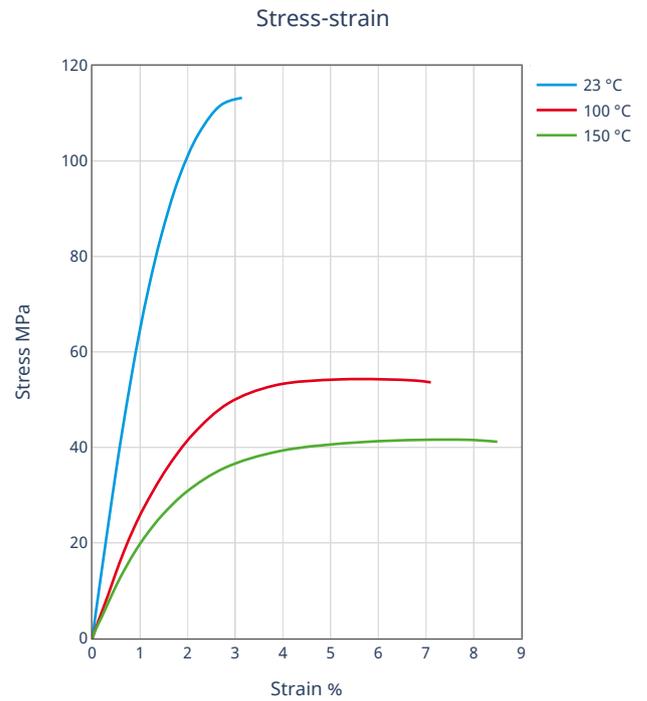
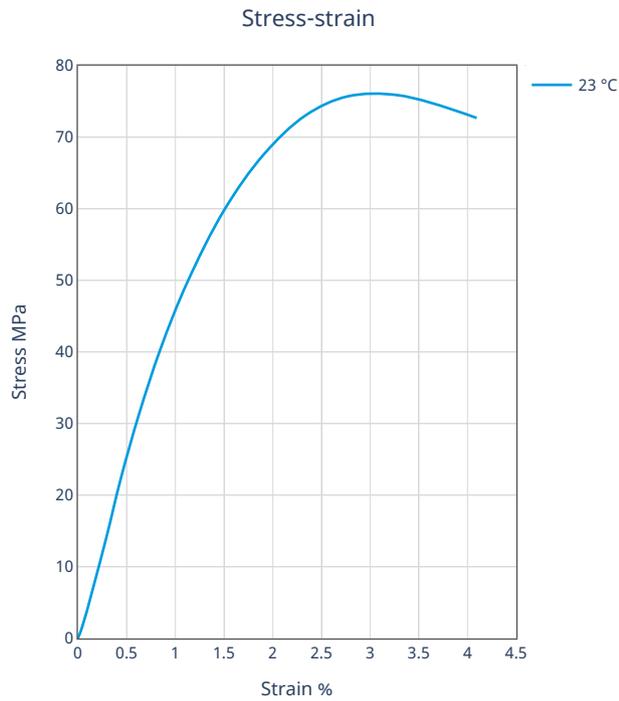
Processing/Physical Characteristics	Value	Unit	Standard
Molding shrinkage, parallel	0.65	%	ISO 294-4, 2577
Molding shrinkage, normal	1.1	%	ISO 294-4, 2577
Mechanical Properties	Value	Unit	Standard
Tensile modulus	7300	MPa	ISO 527
Stress at break	100	MPa	ISO 527
Strain at break	2.6	%	ISO 527
Poisson's ratio	0.35		ISO 527
Charpy impact strength, +23°C	35	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	30	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	4	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	4	kJ/m <sup>2</sup>	ISO 179/1eA
Thermal Properties	Value	Unit	Standard
Melting temperature, 10°C/min	250	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	200	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	235	°C	ISO 75-1/-2

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Other Properties	Value	Unit	Standard
Humidity absorption	1.5	%	Sim. to ISO 62
Density	1340	kg/m <sup>3</sup>	ISO 1183

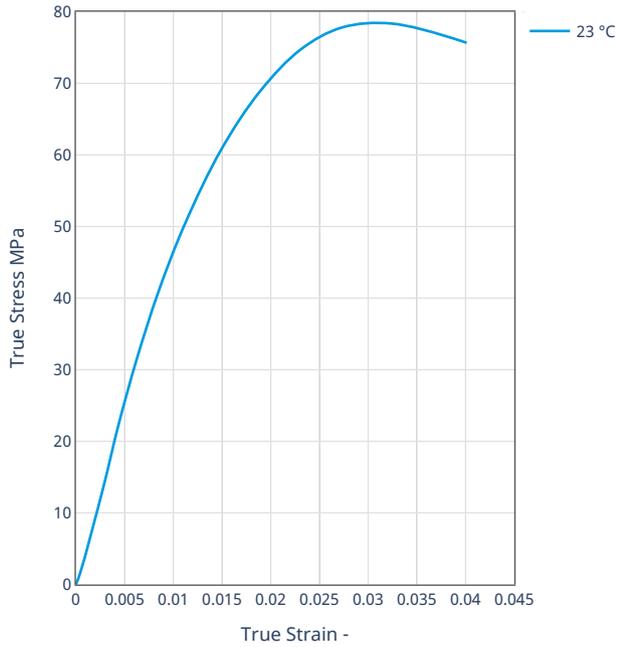
## Diagrams



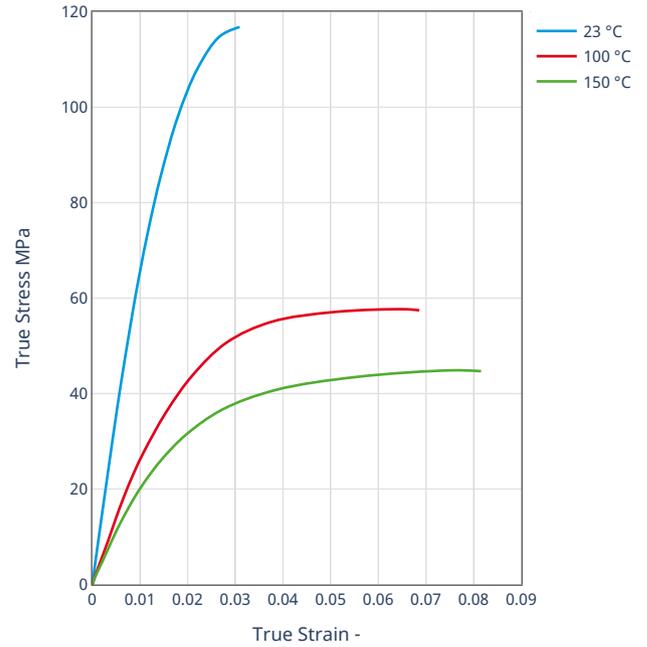
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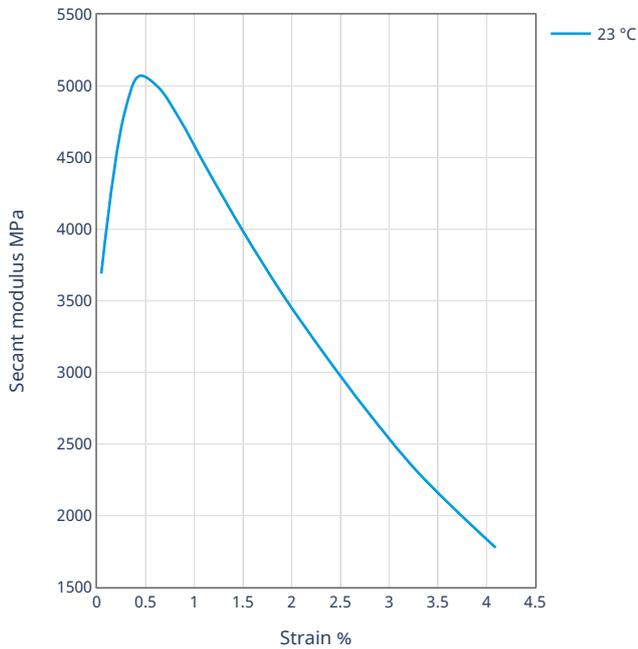
True stress-true strain



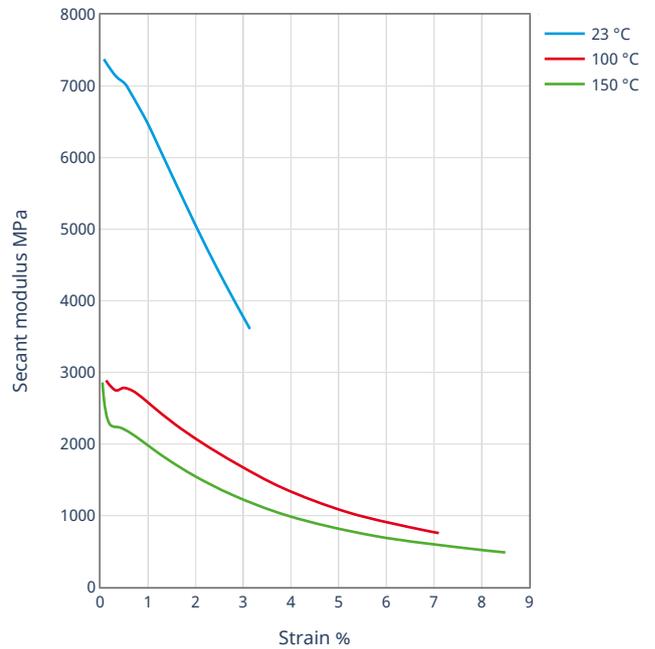
True stress-true strain



Secant modulus-strain



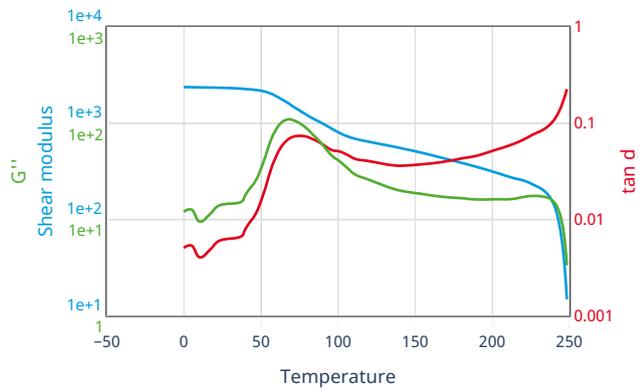
Secant modulus-strain



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Dynamic shear modulus-temperature



## Processing Information

Injection molding

Injection Molding Recommendations

Steel recommendations for molds screws and barrels

Trouble shooting guideline for injection molding