

**Product Texts**

LNP ELCRIN 6K002XiQ compound is based on Polycarbonate / Polybutylene Terephthalate (PC/PBT) blend, utilizing ELCRIN iQ upcycling technology containing minimum 18% Post-Consumer Recycling (PCR) weight content and minerals. Added features of this grade include: good balance of Impact, Ductility and Excellent Pull-Strength.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt volume-flow rate, MVR	13	cm <sup>3</sup> /10min	ISO 1133
Temperature	265	°C	-
Load	5	kg	-
<b>ASTM Data</b>			
Melt Flow Index, MFI	7	g/10min	ASTM D 1238
Temperature	250	°C	-
Load	5	kg	-

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	3800	MPa	ISO 527
Yield stress	58	MPa	ISO 527
Yield strain	3.8	%	ISO 527
Stress at break	54	MPa	ISO 527
Strain at break	50	%	ISO 527
Flexural modulus	3450	MPa	ISO 178
Charpy notched impact strength, +23°C	23	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C, 4mm	20	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength, -30°C, 4mm	8	kJ/m <sup>2</sup>	ISO 180/1A
<b>ASTM Data</b>			
Tensile Modulus	4000	MPa	ASTM D 638
Tensile Strength at Yield	59	MPa	ASTM D 638
Tensile Strength at Break	60	MPa	ASTM D 638
Elongation at Yield	3.9	%	ASTM D 638
Elongation at Break	130	%	ASTM D 638
Flexural Modulus	3500	MPa	ASTM D 790
Izod Impact notched, 1/8 in	250	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	90	J/m	ASTM D 256
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
DTUL @ 264 psi	98	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Water absorption	0.28	%	Sim. to ISO 62
Humidity absorption	0.08	%	Sim. to ISO 62
Density	1300	kg/m <sup>3</sup>	ISO 1183
Density	1300	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	110	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.02	%	-
Melt temperature	255 - 275	°C	-
Mold temperature	40 - 90	°C	-
Zone 1	240 - 260	°C	-
Zone 2	245 - 265	°C	-
Zone 3	250 - 270	°C	-
Screw speed	40 - 80	rpm	-
Back pressure	0.3 - 0.7	MPa	-

**Characteristics**

**Processing**

Injection Molding

**Applications**

Automotive

**Certifications**

Recycled Resin Content

**Regional Availability**

North America, Europe, Asia Pacific