

CELEX™ 3600-20

Polycarbonate Resin

Trinseo

Message:

CELEX 3600-20 contains non-chlorinated, non-brominated & phosphate flame retardant and suitable for use by injection molding applications in the computer, electronics, electrical, and information technology equipment markets.

General Information			
UL YellowCard	E132010-534512		
Features	Bromine Free		
	Chlorine Free		
	Flame Retardant		
Uses	Electrical/Electronic Applications		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	20	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 to 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (3.20 mm, Injection Molded)	2300	MPa	ASTM D638
Tensile Strength (Yield, 3.20 mm, Injection Molded)	60.0	MPa	ASTM D638
Tensile Elongation (Break, 3.20 mm, Injection Molded)	110	%	ASTM D638
Flexural Modulus (3.20 mm, Injection Molded)	2400	MPa	ASTM D790
Flexural Strength (3.20 mm, Injection Molded)	93.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm, Injection Molded)	680	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm, Injection Molded)	127	°C	ASTM D648
CLTE - Flow	1.2E-4	cm/cm/°C	ASTM D696
RTI Elec	125	°C	UL 746
RTI Imp	125	°C	UL 746
RTI Str	125	°C	UL 746
Flammability	Nominal Value	Test Method	

Flame Rating ¹		UL 94
1.50 mm	V-0	
2.50 mm	5VA	
3.00 mm	5VA	
Injection	Nominal Value	Unit
Drying Temperature	120	°C
Drying Time	3.0 to 4.0	hr
Rear Temperature	260 to 280	°C
Middle Temperature	270 to 290	°C
Front Temperature	270 to 290	°C
Nozzle Temperature	280 to 300	°C
Mold Temperature	80.0 to 120	°C
NOTE		

1.

This rating not intended to reflect hazards presented by this or any other material under actual fire conditions.

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