TRINSEO CELEX™ 3600-10
Polycarbonate Resin

Overview

Trinseo CELEX™ 3600 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.

Physical	Nominal Value	(English)	Nominal Value	(SI)	Test Method
Density	1.20	g/cm³	1.20	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	10	g/10 min	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow	5.0E-3 to 7.0E-3	in/in	0.50 to 0.70	%	ASTM D955
Mechanical	**Nominal Value**	**(English)**	**Nominal Value**	**(SI)**	**Test Method**
Tensile Modulus [1]	319000	psi	2200	MPa	ASTM D638
Tensile Strength [2]					ASTM D638
Yield	8700	psi	60.0	MPa	
Break	8560	psi	59.0	MPa	
Tensile Elongation [2]					ASTM D638
Yield	5.0	%	5.0	%	
Break	110	%	110	%	
Flexural Modulus	348000	psi	2400	MPa	ASTM D790
Flexural Strength	13600	psi	94.0	MPa	ASTM D790
Impact	**Nominal Value**	**(English)**	**Nominal Value**	**(SI)**	**Test Method**
Notched Izod Impact (73°F (23°C))	14	ft·lb/in	750	J/m	ASTM D256
Thermal	**Nominal Value**	**(English)**	**Nominal Value**	**(SI)**	**Test Method**
Deflection Temperature Under Load					ASTM D648
264 psi (1.8 MPa), Unannealed	252	°F	122	°C	
Vicat Softening Temperature	300	°F	149	°C	ASTM D1525 [3]
RTI Elec	257	°F	125	°C	UL 746B
RTI Imp	257	°F	125	°C	UL 746B
RTI Str	257	°F	125	°C	UL 746B
Electrical	**Nominal Value**	**(English)**	**Nominal Value**	**(SI)**	**Test Method**
Volume Resistivity	1.0E+19	ohms·cm	1.0E+19	ohms·cm	ASTM D257 IEC 60093
Dielectric Strength	640	V/mil	25	kV/mm	ASTM D149
Comparative Tracking Index (CTI)	PLC 3		PLC 3		UL 746A
Flammability	**Nominal Value**	**(English)**	**Nominal Value**	**(SI)**	**Test Method**
Flame Rating [4] (0.06 in (1.5 mm), All Colors)	V-0		V-0		UL 94

Injection	Nominal Value	(English)	Nominal Value	(SI)
Drying Temperature	248	°F	120	°C
Drying Time	3.0 to 4.0	hr	3.0 to 4.0	hr
Rear Temperature	518 to 536	°F	270 to 280	°C
Middle Temperature	518 to 554	°F	270 to 290	°C
Front Temperature	518 to 554	°F	270 to 290	°C
Nozzle Temperature	536 to 572	°F	280 to 300	°C
Processing (Melt) Temp	518 to 572	°F	270 to 300	°C
Mold Temperature	176 to 248	°F	80 to 120	°C