

Technical Information



CALIBRE™ 603-6

Polycarbonate Resin

Overview

CALIBRE™ 603-6 is a tinted branched polycarbonate resin specially designed for multi-wall sheet extrusion. CALIBRE 603-6 offers a high melt strength for effective calibration of a wide range of multi-wall sheet structures from low to high complexity. CALIBRE 603-6 offers a wider processing window than CALIBRE 503-5 and is likewise specially designed to give excellent sheet surface quality at high line speeds with a reduced tendency to display chatter marks. CALIBRE 603-6 is UV stabilized but sheets for outdoor applications require a protective UV-absorbing cap layer. It is recommended to coextrude a 50 micron thick cap layer from CALIBRE 320UV.

Govt. and Industry Standards:

- Underwriters Laboratory, Inc. (UL)

Main Characteristics:

- Wide processing window
- High surface quality
- Minimizes chatter marks

Applications:

- Low to high complexity multi-wall sheets

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.20 g/cm ³	1.20 g/cm ³	ASTM D792 ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	6.0 g/10 min	6.0 g/10 min	ASTM D1238 ISO 1133
Molding Shrinkage - Flow	5.0E-3 to 7.0E-3 in/in	0.50 to 0.70 %	ISO 294-4
Water Absorption			ISO 62
Saturation, 73°F (23°C)	0.32 %	0.32 %	
Equilibrium, 73°F (23°C), 50% RH	0.12 %	0.12 %	
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus			
-- 1	334000 psi	2300 MPa	ASTM D638
--	334000 psi	2300 MPa	ISO 527-1/1
Tensile Strength			
Yield ²	8990 psi	62.0 MPa	ASTM D638
Yield	8990 psi	62.0 MPa	ISO 527-2/50
Break ²	10200 psi	70.0 MPa	ASTM D638
Break	10200 psi	70.0 MPa	ISO 527-2/50
Tensile Elongation			
Yield ²	6.0 %	6.0 %	ASTM D638
Yield	6.0 %	6.0 %	ISO 527-2/50
Break ²	120 %	120 %	ASTM D638
Break	120 %	120 %	ISO 527-2/50
Flexural Modulus			
--	350000 psi	2410 MPa	ASTM D790
-- 3	348000 psi	2400 MPa	ISO 178
Flexural Strength			
--	14000 psi	96.5 MPa	ASTM D790
-- 3	14100 psi	97.0 MPa	ISO 178

Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F (-30°C)	6.7 ft-lb/in ²	14 kJ/m ²	
73°F (23°C)	36 ft-lb/in ²	75 kJ/m ²	
Notched Izod Impact			
73°F (23°C)	16 ft-lb/in	850 J/m	ASTM D256
73°F (23°C)	33 ft-lb/in ²	70 kJ/m ²	ISO 180/1A
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Rockwell Hardness			ASTM D785
M-Scale	73	73	
R-Scale	118	118	
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			
66 psi (0.45 MPa), Annealed	295 °F	146 °C	ASTM D648 ISO 75-2/B
264 psi (1.8 MPa), Unannealed	261 °F	127 °C	ASTM D648
264 psi (1.8 MPa), Unannealed	259 °F	126 °C	ISO 75-2/A
264 psi (1.8 MPa), Annealed	289 °F	143 °C	ASTM D648 ISO 75-2/A
Vicat Softening Temperature	304 °F	151 °C	ISO 306/B50 ASTM D1525 ⁴
CLTE - Flow (-40 to 176°F (-40 to 80°C))	3.8E-5 in/in/°F	6.8E-5 cm/cm/°C	ISO 11359-2
Electrical	Nominal Value (English)	Nominal Value (SI)	Test Method
Dielectric Strength	430 V/mil	17 kV/mm	ASTM D149
Dissipation Factor			ASTM D150
50 Hz	1.0E-3	1.0E-3	
1 MHz	2.0E-3	2.0E-3	
Comparative Tracking Index			IEC 60112
0.0787 in (2.00 mm), Solution A	250 V	250 V	
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating ⁵			UL 94
0.06 in (1.5 mm)	HB	HB	
0.12 in (3.0 mm)	HB	HB	
Glow Wire Flammability Index ⁵			IEC 60695-2-12
0.04 in (1.0 mm)	1650 °F	900 °C	
0.08 in (2.0 mm)	1610 °F	875 °C	
0.12 in (3.0 mm)	1610 °F	875 °C	
Glow Wire Ignition Temperature ⁵			IEC 60695-2-13
0.04 in (1.0 mm)	1470 °F	800 °C	
0.08 in (2.0 mm)	1430 °F	775 °C	
0.12 in (3.0 mm)	1430 °F	775 °C	
Oxygen Index ⁵	26 %	26 %	ISO 4589-2
Optical	Nominal Value (English)	Nominal Value (SI)	Test Method
Refractive Index	1.586	1.586	ISO 489
Light Transmittance	87.0 to 91.0 %	87.0 to 91.0 %	ASTM D1003
Haze	< 1.00 %	< 1.00 %	ASTM D1003
Injection	Nominal Value (English)	Nominal Value (SI)	
Drying Temperature	248 °F	120 °C	
Drying Time	4.0 hr	4.0 hr	

Notes

These are typical properties only and are not to be construed as specifications. Users should confirm results by their own tests.

¹ 0.039 in/min (1.0 mm/min)

² 2.0 in/min (50 mm/min)

³ 0.079 in/min (2.0 mm/min)

⁴ Rate A (50°C/h), Loading 2 (50 N)

⁵ This rating not intended to reflect hazards presented by this or any other material under actual fire conditions.

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