



LEXANT™ RESIN EX7681T

REGION AMERICAS

DESCRIPTION

LEXANT™ EX7681T resin is a highly UV stabilized 10 MFR polycarbonate, MVR of 10. Suitable for co-extrusion / cap layers. Exhibits low plate out and improved outdoor weathering on PC sheets.

TYPICAL PROPERTY VALUES

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	70	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	60	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	5.4	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	88.1	%	ASTM D638
Tensile Modulus, 5 mm/min	2450	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	113	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2580	MPa	ASTM D790
IMPACT			
Izod Impact, notched, 23°C	77	J/m	ASTM D256
Izod Impact, notched, -30°C	73	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	72	J	ASTM D3763
THERMAL			
Vicat Softening Temp, Rate B/50	132	°C	ASTM D1525
HDT, 0.45 MPa, 3.2 mm, unannealed	127	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	116	°C	ASTM D648
CTE, -40°C to 40°C, flow	6.E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	6.5E-05	1/°C	ASTM E831
Vicat Softening Temp, Rate B/120	135	°C	ISO 306
PHYSICAL			
Specific Gravity	1.2	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm	0.96	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	10.5	g/10 min	ASTM D1238
Density	1.2	g/cm³	ISO 1183
SHEET EXTRUSION			
Drying Temperature	100 – 110	°C	
Drying Time	2 – 3	Hrs	
Melt Temperature	220 – 250	°C	
Barrel - Zone 1 Temperature	240 – 280	°C	
Barrel - Zone 2 Temperature	240 – 280	°C	
Barrel - Zone 3 Temperature	220 – 240	°C	
Barrel - Zone 4 Temperature	220 – 240	°C	
Adapter Temperature	220 – 240	°C	
Die Temperature	245 – 290	°C	
Roll Stack Temp - Top	175 – 180	°C	



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Roll Stack Temp - Middle	175 – 180	°C	
Roll Stack Temp - Bottom	175 – 180	°C	
PROFILE EXTRUSION			
Drying Temperature	100 – 110	°C	
Drying Time	2 – 3	Hrs	
Melt Temperature	180 – 200	°C	
Barrel - Zone 1 Temperature	165 – 185	°C	
Barrel - Zone 2 Temperature	170 – 190	°C	
Barrel - Zone 3 Temperature	175 – 195	°C	
Barrel - Zone 4 Temperature	180 – 200	°C	
Hopper Temperature	60 – 80	°C	
Adapter Temperature	170 – 190	°C	
Die Temperature	180 – 200	°C	
Calibrator Temperature	60 – 100	°C	