

LEXAN™ RESIN EX7681T

REGION EUROPE

DESCRIPTION

LEXAN™ 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

Revision 20230725

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 50 mm/min	63	MPa	ISO 527
Tensile Stress, break, 50 mm/min	70	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	120	%	ISO 527
Tensile Modulus, 1 mm/min	2350	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2300	MPa	ISO 178
THERMAL			
Vicat Softening Temp, Rate B/120	135	°C	ISO 306
PHYSICAL			
Density	1.2	g/cm³	ISO 1183
Melt Volume Rate, MVR at 300°C/1.2 kg	10	cm³/10 min	ISO 1133
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	
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	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Adapter Temperature	170 – 190	°C	
Die Temperature	180 – 200	°C	
Calibrator Temperature	60 – 100	°C	

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