



# 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

Revision 20230725

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
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
<b>IMPACT</b>			
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
<b>THERMAL</b>			
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
<b>PHYSICAL</b>			
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/cm <sup>3</sup>	ISO 1183
<b>SHEET EXTRUSION</b>			
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	
<b>PROFILE EXTRUSION</b>			
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	

## DISCLAIMER

Any sale by SABIC, its subsidiaries and affiliates (each a "seller"), is made exclusively under seller's standard conditions of sale (available upon request) unless agreed otherwise in writing and signed on behalf of the seller. While the information contained herein is given in good faith, SELLER MAKES NO WARRANTY, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY AND NON-INFRINGEMENT OF INTELLECTUAL PROPERTY, NOR ASSUMES ANY LIABILITY, DIRECT OR INDIRECT, WITH RESPECT TO THE PERFORMANCE, SUITABILITY OR FITNESS FOR INTENDED USE OR PURPOSE OF THESE PRODUCTS IN ANY APPLICATION. Each customer must determine the suitability of seller materials for the customer's particular use through appropriate testing and analysis. No statement by seller concerning a possible use of any product, service or design is intended, or should be construed, to grant any license under any patent or other intellectual property right.