



LEXAN™ Resin EX7631T
Americas: COMMERCIAL

EX7631T is a high UVA content homopolymer polycarbonate product intended for use as a cap layer for polycarbonate sheet extrusion.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	710	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	610	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5.4	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	88.1	%	ASTM D 638
Tensile Modulus, 5 mm/min	24900	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1150	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	26300	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	7	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	7	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	734	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	132	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	127	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	116	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.5E-05	1/°C	ASTM E 831
Vicat Softening Temp, Rate B/120	135	°C	ISO 306
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.96	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	10.5	g/10 min	ASTM D 1238
Density	1.2	g/cm ³	ISO 1183



(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

Source GMD, last updated:

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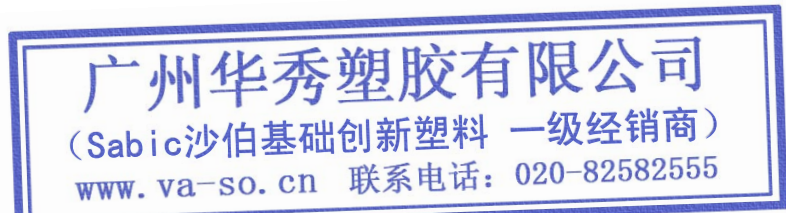
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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Extrusion		
Drying Temperature	75 - 90	°C
Drying Time	2 - 4	hrs
Minimum Moisture Content	0.04	%
Melt Temperature	180 - 200	°C
Barrel - Zone 1 Temperature	165	°C
Barrel - Zone 2 Temperature	170	°C
Barrel - Zone 3 Temperature	175	°C
Barrel - Zone 4 Temperature	180	°C
Roll Stack Temperature - Top	175 - 180	°C
Roll Stack Temperature - Middle	175 - 180	°C
Roll Stack Temperature - Bottom	175 - 180	°C



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