

## Technical Data Sheet

# SCHULABLEND<sup>®</sup> (PET-G) M/MC 4401 LE

Copolyester  
Engineering Plastics

### Product Description

Impact modified Copolyester compound with high scratch- and chemical resistance, high transparence for brillant surfaces. (Former name: SCHULABLEND<sup>®</sup> M/MC 200)

### General

Processing Method • Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.17 g/cm <sup>3</sup>	1.17 g/cm <sup>3</sup>	ISO 1183/A
Melt Volume-Flow Rate (MVR) (265°C/2.16 kg)	10 cm <sup>3</sup> /10min	10 cm <sup>3</sup> /10min	ISO 1133
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus	232000 psi	1600 MPa	ISO 527-2/1A/1
Tensile Stress			ISO 527-2/1A/50
Yield	7250 psi	50.0 MPa	
Break	6530 psi	45.0 MPa	
Tensile Strain (Yield)	6.0 %	6.0 %	ISO 527-2/1A/50
Nominal Tensile Strain at Break	80 %	80 %	ISO 527-2/1A/50
Flexural Modulus <sup>1</sup> (73°F (23°C))	254000 psi	1750 MPa	ISO 178
Flexural Stress <sup>1</sup>			ISO 178
73°F (23°C)	10200 psi	70.0 MPa	
3.5% Strain, 73°F (23°C)	7830 psi	54.0 MPa	
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F (-30°C)	3.8 ft·lb/in <sup>2</sup>	8.0 kJ/m <sup>2</sup>	
73°F (23°C)	33 ft·lb/in <sup>2</sup>	70 kJ/m <sup>2</sup>	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F (-30°C)	No Break	No Break	
73°F (23°C)	No Break	No Break	
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Ball Indentation Hardness (H 358/30)	12200 psi	84.0 MPa	ISO 2039-1
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Heat Deflection Temperature			
66 psi (0.45 MPa), Unannealed	212 °F	100 °C	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	185 °F	85.0 °C	ISO 75-2/Af
Vicat Softening Temperature			
--	239 °F	115 °C	ISO 306/A50
--	230 °F	110 °C	ISO 306/B50
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Burning Rate			
0.0787 in (2.00 mm)	< 3.9 in/min	< 100 mm/min	ISO 3795
0.0787 in (2.00 mm)	< 3.9 in/min	< 100 mm/min	FMVSS 302
Flammability Classification			IEC 60695-11-10, -20
0.06 in (1.6 mm)	HB	HB	
0.13 in (3.2 mm)	HB	HB	

### Additional Information

- 1.) Not for use in food contact applications
- 2.) Not for use in medical or pharmaceutical applications

Technical Data Sheet

**SCHULABLEND<sup>®</sup> (PET-G) M/MC 4401 LE**

Copolyester  
Engineering Plastics



Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	194 °F	90 °C
Drying Time	4.0 hr	4.0 hr
Suggested Max Moisture	0.01 to 0.02 %	0.01 to 0.02 %
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	536 °F	280 °C
Mold Temperature	140 to 176 °F	60 to 80 °C

**Notes**

<sup>1</sup> 0.079 in/min (2.0 mm/min)

**Notes**

These are typical property values not to be construed as specification limits.