Technical Data Sheet

SCHULABLEND® (PET-G) M/MC 3401 SF

Copolyester
Engineering Plastics

Product Description
Impact modified transparent Copolyester compound with high chemical resistence and high flow. Available with and without UV stabilization.

General	
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• Copolyester

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.18 g/cm³	1.18 g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (265°C/2.16 kg)	26 cm³/10min	26 cm³/10min	ISO 1133
Molding Shrinkage	0.40 to 0.60 %	0.40 to 0.60 %	ISO 294-4
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	6820 psi	47.0 MPa	
Break	6090 psi	42.0 MPa	
Tensile Strain (Yield)	6.0 %	6.0 %	ISO 527-2/1A/50
Nominal Tensile Strain at Break	130 %	130 %	ISO 527-2/1A/50
Flexural Modulus [1]	261000 psi	1800 MPa	ISO 178
Flexural Stress [1]			ISO 178
6.2% Strain	10400 psi	72.0 MPa	
3.5% Strain	8410 psi	58.0 MPa	
9.0% Strain [2]	9430 psi	65.0 MPa	
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-22°F (-30°C)	3.3 ft·lb/in²	7.0 kJ/m²	
73°F (23°C)	38 ft·lb/in²	80 kJ/m²	
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)	13200 psi	91.0 MPa	ISO 2039-1
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Heat Deflection Temperature			
66 psi (0.45 MPa), Unannealed	187 °F	86.0 °C	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	176 °F	80.0 °C	ISO 75-2/Af
Vicat Softening Temperature			
--	219 °F	104 °C	ISO 306/A50
--	208 °F	98.0 °C	ISO 306/B50
Electrical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Surface Resistivity	> 1.0E+15 ohms	> 1.0E+15 ohms	IEC 60093
Volume Resistivity	> 1.0E+13 ohms·m	> 1.0E+13 ohms·m	IEC 62631-3-1

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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 (1.5 mm)	HB	HB	
0.12 in (3.0 mm)	HB	HB	

Additional Information

1.) For food contact use please refer to food contact certificate
2.) Not for use in medical or pharmaceutical applications

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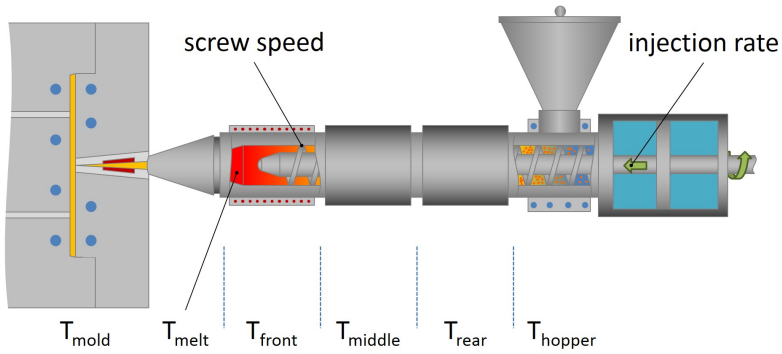

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	194 °F	90 °C
Drying Time	4.0 hr	4.0 hr
Suggested Max Moisture	0.01 to 0.02 %	0.01 to 0.02 %
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	536 °F	280 °C
Mold Temperature	140 to 176 °F	60 to 80 °C