

Technical Data Sheet

# SCHULABLEND® (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® M/MC 200)

## General

Processing Method • Injection Molding

| Physical                                    | Nominal Value (English) | Nominal Value (SI) | Test Method          |
|---------------------------------------------|-------------------------|--------------------|----------------------|
| Density                                     | 1.17 g/cm³              | 1.17 g/cm³         | ISO 1183/A           |
| Melt Volume-Flow Rate (MVR) (265°C/2.16 kg) | 10 cm³/10min            | 10 cm³/10min       | 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/in²           | 8.0 kJ/m²          |                      |
| 73°F (23°C)                                 | 33 ft·lb/in²            | 70 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)        | 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

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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        |

## 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.