

## PET-G 3D Filament

Material is specifically developed for 3D printing applications where easy processing and high toughness are crucial. The self-bonding ability will improve the strength and the durability of your creations

### Material properties

| Description                  | Method           | Typical value          |
|------------------------------|------------------|------------------------|
| Density                      | ASTM D792        | 1.29 g/cm <sup>3</sup> |
| Glass transition temperature | ASTM D3418       | 80°C                   |
| Melting temperature          | DSC              | 180°C                  |
| Heat deflection temperature  | ISO 75 (0.45MPa) | 68°C                   |
| Tensile strength at yield    | ISO 527          | 46 MPa                 |

### Printing properties

|                      |  |
|----------------------|--|
| Hotend temperature   | 245 - 255°C                                |
| Heatbed temperature  | 70 - 90°C                                  |
| Cooling print object | 0 - 30% fan speed                          |
| Nozzle diameter      | commonly used                              |
| Printing environment | open space or inside of box                |
| Bed surface          | commonly used (glassbed, PEI, steel etc..) |
| Bed adhesive         | glue stick for easy removal                |
| Drying               | 6 - 8 hours at 65°C                        |

| Type of spool      | Weight of empty spool |
|--------------------|-----------------------|
| 750 gr transparent | 230gr                 |
| 1 kg transparent   | 250gr                 |
| 1 kg black         | 220gr                 |
| 2,5kg black        | 500gr                 |