

PETG Refilament

Technical Data Sheet

The spoolless PETG work with eSpool, saving cost, eliminating the empty spool plastic waste and being environmentally friendly.

Material Status	Mass Production
Characteristics	<ul style="list-style-type: none"> environment-friendly
Applications	<ul style="list-style-type: none"> Advertisement Waterproof application Snap-in parts Flower pot
Form	<ul style="list-style-type: none"> Filament
Processing method	<ul style="list-style-type: none"> 3D Print, FDM Print

	testing method	Typical value	
Physical Properties			
Density	GB/T 1033	1.27	g/cm ³
Melt Flow Index	GB/T 3682	20	(190°C/2.16kg)
Mechanical Properties			
Tensile Strength	GB/T 1040	52.2	MPa
Elongation at Break	GB/T 1040	83	%
Flexural Strength	GB/T 9341	58.1	MPa
Flexural Modulus	GB/T 9341	1073	MPa
IZOD Impact Strength	GB/T 1843	4.7	kJ/m ²
Thermal Properties			
Heat distortion Temperature	GB/T 1634	64	°C
Continuous Service Temperature	IEC 60216	N/A	
Maximum (short term) Use Temperature		N/A	
Electrical Properties			
Insulation Resistance	DIN IEC 60167	N/A	
Surface Resistance	DIN IEC 60093	N/A	

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Recommended printing parameters

Extruder Temperature	230- 250°C
Build Platform Temperature	75-90°C
Fan Speed	100%
Printing Speed	40 - 100mm/s

Based on 0.4 mm nozzle and Simplify 3D v.4.1.2. Printing conditions may vary with different nozzle diameters

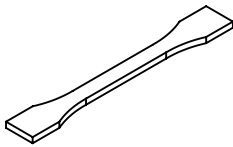
Drying Recommendations

N/A

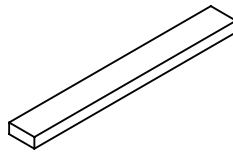
Precautions:

Turn on the Z seam alignment . Turn off the Z-axis lifting with drawing.
Slower the printing speed.

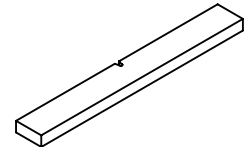
Mechanical Properties



Tensile testing specimen GB/T 1040



Flexural testing specimen GB/T 9341



Impact testing specimen GB/T 1043

The physical properties, mechanical properties, thermal properties, and electrical properties of the line are obtained based on the injection molding spline test.

Print test condition:

Extruder Temperature	230-250°C
Build Platform Temperature	75°C
Outline/Perimeter Shells	4
Top/Bottom Layers	4
Infill Percentage	20%
Fan speed	100%
Printing speed	40mm/s

Based on 0.4 mm nozzle and Simplify 3D v.4.1.2.

Notice

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