



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	°C	230-250	internal
plate temp	°C	90-110	internal
min. nozzle diameter	mm.	0,3	internal
fan	%	0-20	internal
print speed	mm/l°	60-70	internal
PROPERTY			
Physical			
Specific gravity	g/cm ³	1.27	ISO 1183
Water absorption	%	0.13	ISO 62
Mechanical at 23°C / 50% rh			
Tensile stress at break	MPa	26	ISO 527
Charpy impact (23°C)	kJ/m ²	7.9	ISO 180
Hardness	sh/R	105	ASTM D785
Thermal			
Melting point	°C	240	ISO 11357
Heat distortion temp.	°C	70	ISO 75
Vicat softening temp.	°C	78	ISO 306

Disclaimer

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ADDITIONAL INFORMATIONS

In general filaments made with GPET (petg) can be processed on conventional 3D printer using FDM / FFF technology.

GPET (petg) is a copolymer PET based developed for 3D printing and to obtain best results we recommend pre drying the filaments at 65° for 3 h. Increase drying time for spools up 1 kg.

Don't leave the filament stopped inside the nozzle more than 20 min. If that down the temperature under 210°, better stop the thermal control.

(1) Suggested print set merely represent a recommendation for general use . Every printer necessity a specific set , nozzle temp, bed temp, etc .

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