

### Product description:

PET HD (Polyethylene Terephthalate Glycol) filament is a brilliantly clear, durable, and resilient thermoplastic that combines the best properties of PLA and ABS. It offers high impact resistance, excellent layer adhesion, and good chemical resistance, with a slight flexibility. It is ideal for functional parts, prototypes, and applications requiring good mechanical strength and dimensional stability.

### Storage:

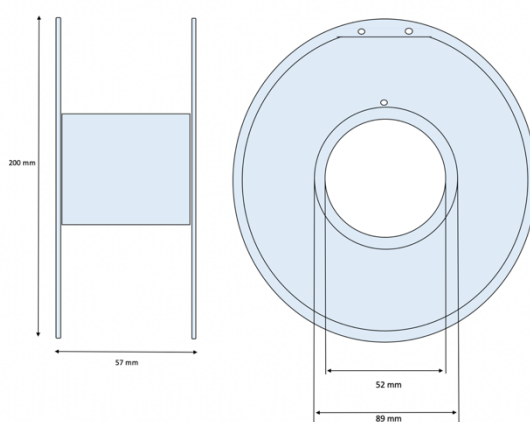
Store in dry area, in a closed container away from moisture.

Use desiccant bags to prevent moisture absorption, as PETG is slightly hygroscopic.

### PRODUCT PARAMETERS

Parameter	Value
Filament diameter [mm]	1.75
Diameter tolerance [mm]	+/- 0,005
Oval tolerance [mm]	+/- 0,002

Spool dimensions [mm] (ø / height / hole ø)	200/57/52
Spool weight [g]	325
Spool material	Transparent PC
Weight with packaging [g]	1 550
Net weight [g]	1 000
Box dimensions [mm]	203/207/70



### RECOMMENDED PRINTING PARAMETERS

Parameter	Value
Print temperature [°C]	240-270
Bed temperature [°C]	70-90
Cooling [%]	Medium or low to avoid overheating
Closed chamber	Not required, but may improve print
Chamber temperature [°C]	30-60
Printing Speed [mm/s]	40-70
Nozzle type	-

### PHYSICAL PARAMETERS OF THE MATERIAL

Parameter	Value	Unit	Test method
Density	1,23	g/cc	ISO 1183
Melt flow rate	10-30	g/10min	ISO 1133 220°C/10Kg
Vicat softening temp.	75-80	°C	ISO 306 VST/A/50 (50°C/h,10N)
Tensile modulus	1900-2200	MPa	ISO 527 1mm/min
Tensile strength	66	MPa	ISO 527 @Yield 50mm/min (2inch/min)
Elongation at break	330	%	ISO 527 @Break 50 mm/min (2inch/min)
Impact strength	46	J/m2	ISO 179 Charpy Notched @23°C (73°F)

The values above have been measured using standard test specimens made of non-colored material at room temperature. The figures should be considered as indicative values only. Actual properties of PET HD parts can be affected by the printing parameters, design of the model, ambient conditions, application of the printout etc. It is essential that users test our products to determine whether they are suitable for their intended use.