

**PRODUCT NAME:** 3D FILAMENT PET-G Standard 1,75mm

**PRODUCT DESCRIPTION:** PET-G Standard filament - poly(ethylene terephthalate) with addition of glycol in the form of a thread, designed for 3D printing using the FFF/FDM method. Filament coiled on spools or cardboard core (no spool), vacuum-packed with desiccant in a PA/PE bag, and then in a box.

**STORAGE:** Store in dry area. Store in a closed container.

## PRODUCT PARAMETERS

Parameter		Value			
Filament diameter [mm]		1,75			
Diameter tolerance [mm]		+/- 0,05			
Oval tolerance [mm]		+/- 0,02			
Net weight [g]	<b>800</b>	<b>1000</b>	<b>1000 (ReFill)</b>	<b>3000</b>	<b>4500</b>
Weight with packaging [g]	1200	1400	1200	4000	5500
Spool weight [g]	Transparent PC: 245	Transparent PC: 260	Cardboard core: 30	710	850
	ECO PP wood: 190	ECO PP wood: 205			
		Masterspool ROSA3D: 250			
Spool dimensions [mm] ( $\phi$ / height / hole $\phi$ )	Transp. PC: 200/55/52	Transp. PC: 200/68/52	Cardboard core: 99/57/94	300/100/52	300/100/52
	ECO PP wood: 200/57/52	ECO PP wood: 200/70/52			
		Masterspool ROSA3D: 201,7/65/52			
Box dimensions [mm]	220/210/65	220/210/75	220/210/65	325/310/110	325/310/110

## RECOMMENDED PRINTING PARAMETERS

Parameter	Value
Print temperature [°C]	220-250
Bed temperature [°C]	60-80
Cooling [%]	0-60
Closed chamber	Not required
Drying conditions: [°C/h]	60/4

## PHYSICAL PARAMETERS OF THE MATERIAL

Parameter	Value	Unit	Test method
Density	1,29	g/cm <sup>3</sup>	-
Tensile modulus	2980	MPa	ISO 527-2
Tensile strength at break	20	MPa	ISO 527-2
Izod impact strength (notched)	4,7	kJ/m <sup>2</sup>	ISO 180
HDT	78	°C	ISO 306
Flame rating	V2	-	UL94 (4,0 mm)
Food Contact Approval	YES	-	FCA declaration in separate document

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-G Standard 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. ROSA PLAST Sp. z o.o. accepts no liability for any health detriment or material losses or any other losses related to the use of the material.



