

BASIC INFORMATION

PRODUCT NAME:	FILAMENT 3D PETG FR V0 HF 1,75mm
PRODUCT DESCRIPTION:	PETG FR V0 HF filament - poly(ethylene terephthalate) with addition of glycol and flame retardant additives – free from halogen, and red phosphorus. Product in the form of a thread, designed for 3D printing using the FFF/FDM method. Filament coiled on spools, vacuum-packed with desiccant in a PA/PE bag, and then in a box.
STORAGE:	Store in a dry place 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]	1000±20
Weight with packaging [g]	1400±20
Spool weight [g]	ECO PP wood: 205
Spool dimensions [mm] (ø / height / hole ø)	ECO PP wood: 200/70/52
Box dimensions [mm]	220/210/75

RECOMMENDED PRINTING PARAMETERS

PARAMETER	VALUE
Print temperature [°C]	230-260
Bed temperature [°C]	60-70
Cooling [%]	0-60*
Closed chamber	Not required
Drying conditions [°C/h]	60/4

*depending on fan capacity

PHYSICAL PARAMETERS OF THE MATERIAL

Parameter	Value	Unit	Test method
Density	1,26	g/cm ³	ISO 1183
Elastic modulus	2350	MPa	ISO 527-1 (1 mm/min)
Tensile strength at yield	40	MPa	ISO 527-1 (5 mm/min)
Tensile elongation at yield	3,3	%	ISO 527-1 (5 mm/min)
Charpy impact strength, unnotched	-	kJ/m ²	ISO 179-1eU
Charpy impact strength, notched	3	kJ/m ²	ISO 179-1eA
VICAT	70	°C	ISO 306
HDT	63	°C	ISO 75; 0,45 MN/m ²
HDT	58	°C	ISO 75; 1,81 MN/m ²
Oxygen index	35	%	ASTM D 2863
Flammability rate	V0	-	UL 94
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Glow wire flammability index	960°C @ 1 mm	-	IEC 60695-2-12
Glow wire flammability index	960°C @ 2 mm	-	IEC 60695-2-12
Glow wire ignition test	775°C @ 1 mm	-	IEC 60695-2-13
Glow wire ignition test	775°C @ 2 mm	-	IEC 60695-2-13
Comparative Tracking Index	600	V	IEC 60114

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 V0 FR 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.

