

BASIC INFORMATION

PRODUCT NAME:	FILAMENT 3D PET-G Structure HS 1,75mm
PRODUCT DESCRIPTION:	PET-G Structure HS filament is a poly(ethylene terephthalate) glycol-infused filament for FFF/FDM 3D printing. The supplied filament is wound on a cardboard coil (no spool), vacuum sealed in a moisture absorber bag and packed in a cardboard 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[ReFill]
Weight with packaging [g]	1200
Spool weight [g]	Cardboard core: 30
Spool dimensions [mm] (ϕ / height / hole ϕ)	Cardboard core: 99/57/94
Box dimensions [mm]	220/210/65

RECOMMENDED PRINTING PARAMETERS

PARAMETER	VALUE
Print temperature[°C]	230-260
Bed temperature [°C]	70-90
Cooling [%]	20-60*
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	1,15-1,20	g/cm ³	-
Odour	odourless	-	-
Tensile modulus	2980	MPa	ISO 527-1
Tensile Stress	48	MPa	ISO 527-2
Tensile Strain	3,8	%	ISO 527-2
Tensile Strain at Break	≤26	%	ISO 527-2
Flexural Modulus	1980	MPa	ISO 178
Flexural Stress	66	MPa	ISO 178
Izod impact strength (notched)	≤ 4,1	kJ/m ²	ISO 180/A (-30°C)
Izod impact strength	≤ 120	kJ/m ²	ISO 180 (-30°C)
HDT	68	°C	ISO 75-2/B (0,45 MPa)
HDT	62	°C	ISO 75-2/A (1,80 MPa)
VICAT	78	°C	ISO 306/A50
Flame rating	V2	-	PN-EN 60695 (4mm)

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 Structure HS 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.



ROSA PLAST Sp. z o.o.

ul. Hipolitowska 102B, 05-074 Hipolitów

tel.: +48 22 783 62 62, www.rosa3d.pl