

BASIC INFORMATION

PRODUCT NAME:	FILAMENT 3D PET-G HT 1,75mm
PRODUCT DESCRIPTION:	PET-G HT filament is poly(ethylene terephthalate) with glycol in the form of a filament, designed for FFF/FDM 3D printing. The supplied filament is wound on a spool or on a cardboard coil (without spool), vacuum sealed in a bag with moisture absorber and packaged 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
Weight with packaging [g]	1200
Spool weight [g]	Cardboard core: 30
Spool dimensions [mm] (\varnothing / height / hole \varnothing)	Cardboard core: 99/57/94
Box dimensions [mm]	220/210/65

RECOMMENDED PRINTING PARAMETERS

PARAMETER	VALUE
Print temperature[°C]	240-270
Bed temperature [°C]	70-90
Cooling [%]	0-40*
Closed chamber	Not required
Drying conditions [°C/h]	70/6-8, drying required before each printing

*depending on fan capacity

PHYSICAL PARAMETERS OF THE MATERIAL

Parameter	Value	Unit	Test method
Density	1,25 -1,29	g/cm ³	-
Flexural strength at yield	90	MPa	ASTM D790
Elongation at break	199	%	ASTM D638
Flexural modulus	2495	MPa	ASTM D790
Izod impact strength (notched)	24	J/m	ASTM D256
Glass Transition Temperature Tg	100	°C	ASTM D7426
HDT B	85	°C	ASTM D648, 0,455MPa
Flame rating	B	-	PN-EN 13501
Certificates	EFSA, FDA	-	

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 HT 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. Additional documents, certificates and detailed technical information can be provided on special request.

