

# 3DP PET-G

PET-G is a strong, high clarity, odor neutral, and easy-to-print filament for 3D printing. These characteristics, together with the high impact strength, excellent flexibility, and low/no shrinkage make PET-G an excellent material, while combining the advantages of both PLA and ABS. The filament is also hydrophobic and therefore does not absorb water.

## Features:

- High Clarity
- Strong and Flexible
- Almost No Warping
- Hydrophobic (Won't Absorb Water)
- Food Contact Acceptable
- Odor Neutral Printing

## Normal Stock:

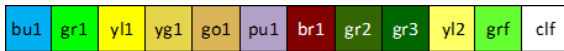
- 2.85 dia (+/- 0.10mm)
  - Roundness  $\geq 95\%$
  - 2.2 kg (5 lb.) spools
- Contact 3DP for other spool sizes and diameter filaments: Diameters available - 1.75mm, 4.5mm, 6mm



Colors normally in stock:



Check stock on these colors prior to order:



Material Properties		
Description	Test Method	Typical Value
Specific Gravity	ISO 1183	1.27 g/cc
MFR 190°C/2.16 kg	ISO 1133	6.4 gr/10 min
Tensile Strength at Yield	ISO 527	50.4 mpa
Strain at Yield	ISO 527	5.9%
Strain at Break	ISO 527	22.7%
Tensile Modulus	ISO 527	2020 mpa
Flexural Modulus	ISO 178	2050 mpa
Flexural Strength	ISO 178	69 mpa
Impact Strength - Charpy Method 23°C	ISO 179	8.1 kJ/m <sup>2</sup>
Rockwell Hardness	ASTM D785	105
Moisture Absorption	ISO 62	1104 ppm
Printing Temp. Range	DF	195-220°C
Heat Deflection Temp.	ASTM 648	70°C
Transparency	ASTM D1003	90%

3DP WorkSeries Machine Settings	
Description	Setting
Volcano Extruder Default Print Speed	80 mm/s
HFA Extruder Default Print Speed	100 mm/s
Unspecified Machine Default Print Speed	60 mm/s
Extruder Temp. (Starting Point)	240°C
Heated build Platform Temp.	80°C
Bed Prep.	Beer Hairspray
Extrusion Multiplier/Flow Rate	100%
Fan Speed	100%
Active Cooling (Fan)	Y
Retraction Distance	1.10 mm

## Additional info:

Adhesion is possible on different surfaces. PET-G can be used on all common desktop FFF technology 3D printers. Storage: Cool and dry (15 - 25°C) and away from UV light. This enhances the shelf life significantly.