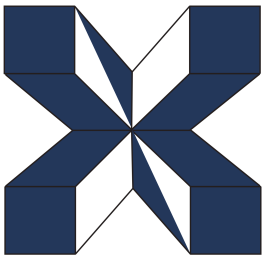


3D Printing PETG+ (pro) Filament

TECHNICAL DATA SHEET VOXELPETG+ (PRO)

TRADING NAME: VOXELPETG+ (PRO)
RAW MATERIAL: PETG
FORM: 1.75MM FILAMENT
APPLICATIONS: 3D PRINTING

The product is modified on the base PETG material to increase strength(layer adherence and toughness), reliability, and ease of printing. Our PETG+ (PRO) is excellent for rapid prototyping, cosplay, mechanical parts, models, or other applications.

MATERIAL SPECIFICATION:

PROPERTIES	TESTING METHODOLOGY	TYPICAL VALUE	UNITS
Density	**GB/T 1033**	**1.27**	**g/cm^3**
Melt Flow Index	**GB/T 3682 (240C/2.16KG)**	**20**	**g/10 min**
Tensile Strength (X-Y)	**GB/T 1040**	**52.5**	**MPa**
Tensile Strength (Z)	**GB/T 1040**	**46.8**	**MPa**
Elongation at Break	**GB/T 1040**	**83**	**%**
Flexural Strength	**GB/T 9341**	**58.5**	**MPa**
Flexural Modulus	**GB/T 9341**	**1072**	**MPa**
IZOD Impact Strength	**GB/T 1843**	**5**	**KJ/m^2**
Heat Distortion Temputure	**GB/T 1634**	**72**	**C**

RECOMMENDED PRINTING SETTING:

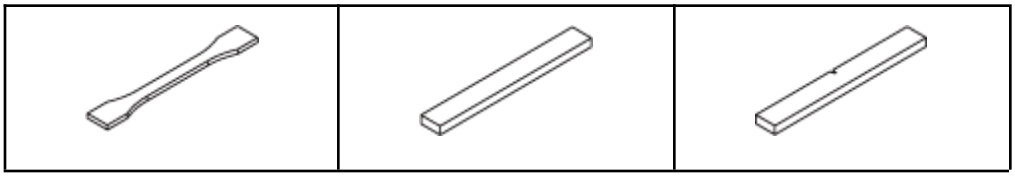
BOWDEN STYLE EXTRUDER

Extruder Temperature:	**230 - 260C**
Bed Temperature:	**60 - 80C**
Fan Speed:	**20%**
Retraction Speed:	**60mm/s**
Retraction Amount:	**6mm**

DIRECT EXTRUDER

Extruder Temperature:	**230 - 260C**
Bed Temperature:	**60 - 80C**
Fan Speed:	**20%**
Retraction Speed:	**50mm/s**
Retraction Amount:	**1mm**

TESTING SPECIFICATION:



GB/T 1040 Tensile Testing Specimen	GB/T 9341 Bending Testing Specimen	GB/T 1043 Impact Testing Specimen

PRINTING SETTING

Extruder Temperature:	**240C**
Bed Temperature:	**70 C**
Fan Speed:	**20%**
Retraction Speed:	**60mm/s**
Retraction Amount:	**1mm**
Infill Percentage:	**20%**
Perimeter:	**4**
Top/Bottom Layer:	**4**

Disclaimer:

The typical values presented in this data sheet are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary significantly with printing conditions. End-use performance of printed parts depends not only on materials, but also on part design, environmental conditions, printing conditions, etc. Product specifications are subject to change without notice. Each user is responsible for determining the safety, lawfulness, technical suitability, and disposal/ recycling practices of VOXELPLA materials for the intended application. VOXELPLA makes no warranty of any kind, unless announced separately, to the fitness for any use or application. VOXELPLA shall not be made liable for any damage, injury, or loss induced from using VOXELPLA materials in any application.