

## PETG+ 3D PRINTING FILAMENT

PETG+ Printing Parameters	
Nozzle Temperature	210c – 230c
Bed Temperature	25c – 70c
Print Surface	Most print surfaces ie. Glass, Meta Flex etc
Model Cooling Fan	0% - 50%
Layer Height	0.12mm – 0.3mm
Print Speed	40mm/s – 60mm/s
Idle Speed	60mm/s – 120mm/s
Printing Environment Temperature	Room Temperature – 50c
Retraction Distance	1mm – 2mm
Retraction Speed	30mm/s – 50mm/s
Support Materials	Itself

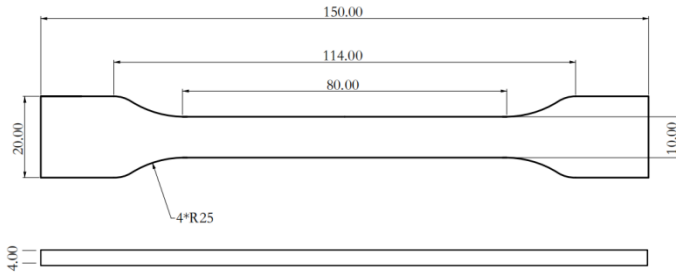
PETG+ Technical Specifications		
Physical Properties	Test	
Density	ISO 1183	1.27g/cm <sup>3</sup> – 1.28g/cm <sup>3</sup>
MFR (250c/2.16kg)	ISO 1133	8g/10min – 12g/10min
Moisture Absorption	ISO 62	<0.2%
Mechanical Properties		
Tensile Strength	ISO 527	41Mpa – 45Mpa
Elongation at Break	ISO 527	10% - 12%
Flexural Modulus	ISO 527	1400Mpa – 1500Mpa
Flexural Strength	ISO 178	64Mpa – 66Mpa
Impact Strength	ISO 179	5KJ/m <sup>2</sup> – 6KJ/m <sup>2</sup>
Thermodynamic Properties		
HDT @ 0.455MPa (66psi)	ISO 75	68c
Continuous Use Temperature	IEC 60216	65c
Weights and Dimensions		
Spool Dimensions	Outside Diameter: 200mm   Width: 65mm   Internal Hub: 52mm	
Spool Weight (without filament)	150g	
Spool Weight (with filament)	1.15kg	
Package Dimension (LxWxH)	210mm x 210mm x 75mm	
Package Weight	1.3kg	

### Storage and Drying:

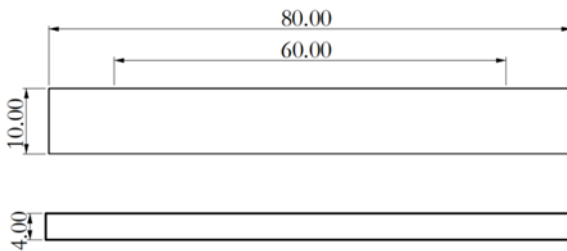
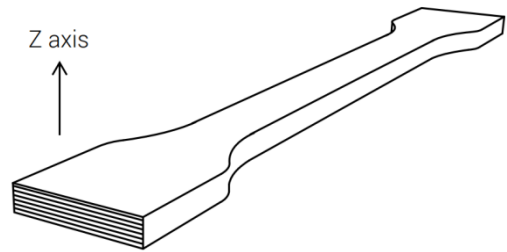
To prevent moisture absorption, it is recommended to keep your filament in a cool, dark, dry area, preferable sealed in an airtight bag.

Filament can be dried with various methods including a dedicated filament drying machine, food dehydrator, oven, or even your printer if it's fully enclosed. For PETG and PETG+ filaments we recommend a drying temperature of 70c for a minimum of 5 hours.

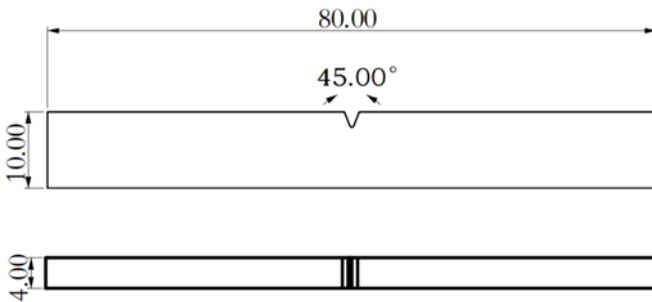
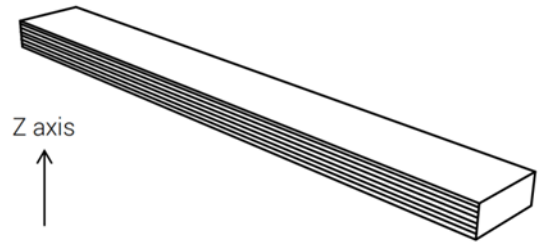
Test Sample Printing Conditions	
3D Printer	Flashforge Guider IIs
Nozzle Diameter	0.4mm
Nozzle Temperature	220c
Printing Speed	50mm/s
Layer Height	1.2mm
Infill	100%



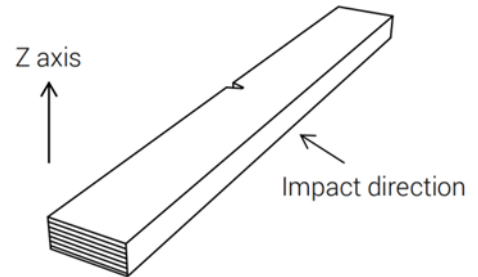
Tensile testing specimen; ASTM D638 (ISO 527, GB/T 1040)



Flexural testing specimen; ASTM D790 (ISO 178, GB/T 9341)



Impact testing specimen; ASTM D256 (ISO 179, GB/T 1043)



## Disclaimer:

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