TECHNICAL DATA SHEET

D3D High Temperature PETG

Characteristic: toughness| High deformation Temp | Lower shrinkage

Identification of Material

Trade Name: D3D Hight Temperature PETG

Chemical Name: cylclohexylenedimethylene terephthalate

GUIDELINE FOR PRINT SETTINGS

Nozzle Temperature:260±10℃

Bed temperature: 70~90℃

Active cooling fan: ON

Layer height: 0.2mm

Shell thickness ≥0.8mm

Print speed: 40~80mm/s

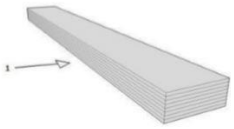
Settings are based on a 0.4mm Nozzle

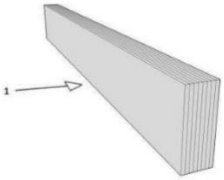
Material Properties

Melt temperature	~220℃	ISO 11357
Melt flow rate (MFR) [1]	8~12 g/10min	ISO 1133
Heat deflection temperature(HDT)[2]	95 ℃	ISO 75
Vicat softening temperature(VST)[3]	105 ℃	ISO 306
density	1.27 g/cm^3	ISO 1183
Odor	Odorless	/
Solubility	Insoluble in water	/

1. test conditions: T= 240℃; m= 2.16kg.
2. test conditions:0.45MPa;120℃/h.
3. test conditions:10N; 120℃/h.

MECHANICAL PROPERTIES|TENSILE TEST	Test Method ISO 527
All test specimens were printed using an Mankati E180，under the following conditions： Printing temperature: 270℃ Heated bed temperature：80℃ Print speed：30mm/s Shell thickness：0.8mm Infill under 45°	
Infill	100%
Tensile strength（Mpa）	40~47
Elongation at break（%）	2~4

MECHANICAL PROPERTIES|IMPACT TEST	Test Method ISO 179
The same conditions as tensile test. 1→impact direction	
Infill	100%
Impact strength（KJ/m²）	40~50
Notch impact strength[1]（KJ/m²）	3~5

MECHANICAL PROPERTIES |FLEXURAL TEST	Test Method ISO 178
The same conditions as tensile test. 1→bending direction	
Infill	100%
Maximum force（Mpa）	65~80
Flexural modulus（Mpa）	1800~2200

1. notch type: type A