TECHNICAL DATA SHEET

FILAMENT 3D PET-G HT

Date: 14/02/2025

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. The product is designed for use with 3D printers using FDM technology. It should be used in a well ventilated room to avoid exposure to fume emissions during printing. It is important to avoid direct contact with hot printer components , which can lead to burns. Filament should be stored in a dry place, in a closed container and away from children. It is recommended to use the filament within the recommended printing temperature range for optimum results. Dispose of waste filament in accordance with local regulations. The product has been designed with safety in mind and meets all relevant standards for consumer use.

STORAGE: Store in dry area. Store in a closed container.

PRODUCT PARAMETERS

PARAMETER	VALUE
Filament diameter [mm]	1.75
Diameter tolerance [mm]	+/-0,05
Oval tolerance [mm]	+/-0,02

RECOMMENDED PRINTING PARAMETERS

PARAMETER	VALUE
3D printing temperature [C]	240-270
Heated bed [C]	70-90
Cooling fan [%]	0-40
Closed chamber	not required
Drying conditions [C/h]	70/6-8, drying required before each print

* Recommended to pre-dry the filament before each print.

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PHYSICAL PARAMETERS OF THE MATERIAL

PARAMETER	VALUE	UNIT	TEST METHOD
Density	1,25 -1,29	g/cm3	-
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	-	-

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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.

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