



# TECHNICAL DATA SHEET XPETG CF

## DESCRIPTION

Polyethylene Terephthalate Glycol (PETG) is one of the world's most common thermoplastic polymers. Extruder XPETG CF was developed for a wide range of applications where the main requirement is a good balance between mechanical and optical material properties. The raw material is approved according to the REACH- and RoHS-Standards. PETG is flame retardant according to UL 94 at a wall thickness of 3.2 mm.

## FEATURES

- Good mechanical properties
- High chemical resistance
- Low warping tendency
- Low shrinking

## PROPERTIES <sup>1</sup>

TEST	METHOD	UNIT	VALUE
Tensile modulus (E-Modulus)	ISO 527	MPa	3350 ± 50
Yield stress	ISO 527	MPa	59 ± 0,4
Elongation at yield	ISO 527	%	3,8 ± 0,1
Strength	ISO 527	MPa	59 ± 0,4
Elongation at break	ISO 527-2	%	9,4 ± 1,5
Notched impact strength	ISO 180	kJ/m <sup>2</sup>	1,7 ± 0,4
Unnotched impact strength	ISO 180	kJ/m <sup>2</sup>	67 ± 7
Heat Deflection Temperature HDT/B	ISO 75	°C	69
VICAT A (VST)	ISO 206	°C	85
Density	ISO 1183-1XA	g/cm <sup>3</sup>	1,41
Flammability	UL 94	V-2	-

\*Temperature resistance tested at a minimum wall thickness of 4 mm.

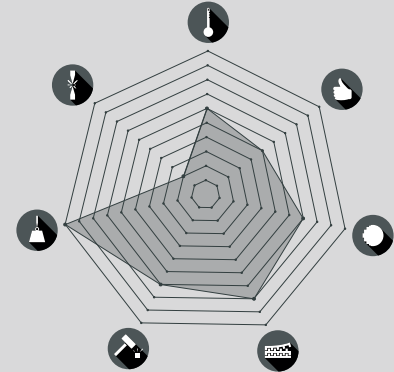
## CERTIFICATIONS & ADDITIONAL INFORMATION <sup>2</sup>



## STORAGE AND SHELF LIFE

Store in a dry room at room temperature (18-27°C / 65-80°F). Keep out of direct heat and sunlight. When stored correctly, this material has a shelf life of 2 years.

1. Additional info in our regulatory, additional information and chemical resistance data sheets.  
2. Certifications depend on colors in final product. More info in the additional information sheet.



TEMPERATURE RESISTANCE 6

EASE OF PRINTING 5

VISUAL QUALITY 6

LAYER ADHESION 8

IMPACT RESISTANCE 7

MAXIMUM STRESS 10

ELONGATION AT BREAK 2

## PRINT SETTINGS

Nozzle	210-230°C
Heatbed	60-70°C
Adhesive	not required
Speed	40-60mm/s
Cooling	20-50%

Recommended settings for printers with a 0.5mm Nozzle. Max. 50% layerheight. Optimal print settings may vary between different printers and also depend on environmental factors.

## NEED HELP?

If you have any question about the product and/or you are experiencing an issue, please contact us via [support@extruder.com](mailto:support@extruder.com)

