PETG

Property	Test Method	Value	Comment
Density/ gcm^{-3}	ASTM D792	1.27	Resin Manufacturer data
Glass transition temperature/ °C	ASTM D3418	80	Resin Manufacturer data
Heat Deflection Temperature/ °C *	ASTM D648 at 66 psi	65	
Tensile Strength at Yield/ psi *	ASTM D638, Type IV	10800	
Tensile Elongation/ % *	ASTM D638, Type IV	5	
Flexural Modulus/ kpsi *	ASTM D790	935	
Flexural Peak Stress / kpsi *	ASTM D790	24.7	
Notched Izod Impact/ Jm^{-1} *	ASTM D256	20	

* 3D printed test specimens using Ultimaker 2+; 100 % infill; y-axis orientation; tested in an independent lab

Recommended Printer Conditions

Nozzle temperature*	240°C
Heated bed temperature**	65°C
Speed	30-150 mm/s
Infill	As needed, up to 100 %
Bed material	Adheres to a variety of standard bed materials, for best results: Glass, PET tape

*Nozzle temperature recommendations based on achieving better print definition. The recommendations given above leave about ±15°C depending on specific printers and other print settings.

**Higher print speeds might require higher nozzle temperatures

These processing conditions are general guidelines only. Each printer will likely have a unique set of printing parameters.