



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	°C	235-250	internal
plate temp	°C	90-100	internal
min. nozzle diameter	mm.	0,2	internal
fan	%	0-20	internal
Max print speed	mm/ sec	530	internal
PROPERTY			
Physical			
Specific gravity	g/cm3	1.28	ISO 1183
Mechanical at 23°C / 50% rh			
Hardness	Sh/r	101	ASTM D785
Tensile stress at break	MPa	28	ISO 527
Charpy impact	kJ/m ²	8,6	ISO 179
Thermal			
H.D.T.	°C	72	ISO 75-2
Vicat softening temp.	°C	77	ISO 306

Disclaimer

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ADDITIONAL INFORMATIONS

In General filaments made with PET G FF can be processed on conventional 3D printer using FDM / FFF technology.

PET G FF is a special PET G developed for 3D printing and to obtain best results we recommend pre drying the filaments at 60° for 3 h. Increase drying time for spools up 1 kg.

Don't leave the filament stopped inside the nozzle more than 20 min. If that down the temperature under 190°, better stop the thermal control.

(1) Suggested print set merely represent a recommendation for general use . Every printer necessity a specific set , nozzle temp, bed temp, etc .

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