CR-PETG Filament Technical Data Sheet

Version 1.0

1. Product introduction

CR-PETG filament has both the low shrinkage advantage of PLA and the strong impact resistance advantage of ABS.

2. Physical Performance Parameters

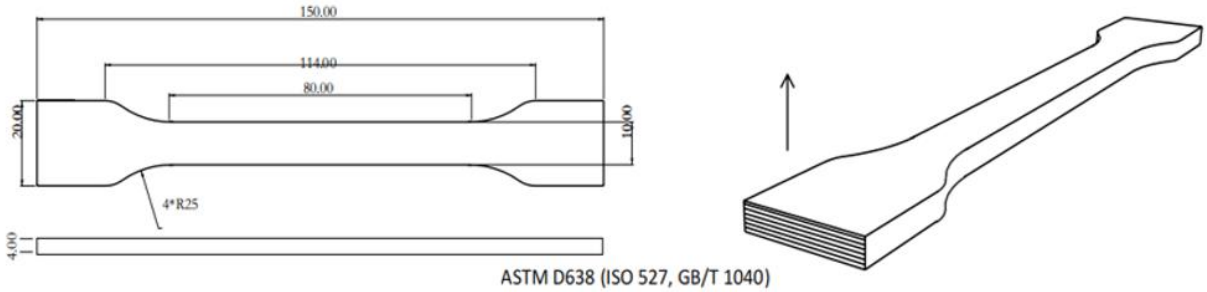
Items	Testing Criteria	Parameters
Density	ASTM D792 (ISO 1183, GB/T 1033)	1.27 ±0.1 (g/cm3 at 21.5˚C)
GTT(Glass-transition temperature)	ASTM D648(ISO 75-2, GB/T 1634)	70°C (@0.45Mpa)
Vicat Softening Temperature	210°C, 2.16 kg	18-20 (g/10 min)

3. Mechanical Performance Parameters

Items	Testing Criteria	Parameters
Tensile strength (X-Y)	ASTM D638 (ISO 527, GB/T 1040)	46.55 MPa
Tensile strength（Z）	ASTM D638 (ISO 527, GB/T 1040)	11.5MPa
Elongation at break（X-Y）	ASTM D638 (ISO 527, GB/T 1040)	10.5%
Elongation at break（Z）	ASTM D638 (ISO 527, GB/T 1040)	5.6%
Bending strength（X-Y）	ASTMD790 (ISO 178, GB/T 9341)	68MPa
Bending modulus (X-Y)	ASTMD790 (ISO 178, GB/T 9341)	1800(MPa
Charpy impact strength（X-Y）	ASTM D256 (ISO 179, GB/T 1043)	14kJ/m^2

Parameters and styles of sample printing conditions:

Print Conditions	Parameters
Nozzle Temperature	240℃
Hot Bed Temperature	70℃
Printing Speed	60mm/s
Infill	100%



ASTM D638 (ISO 527, GB/T 1040)

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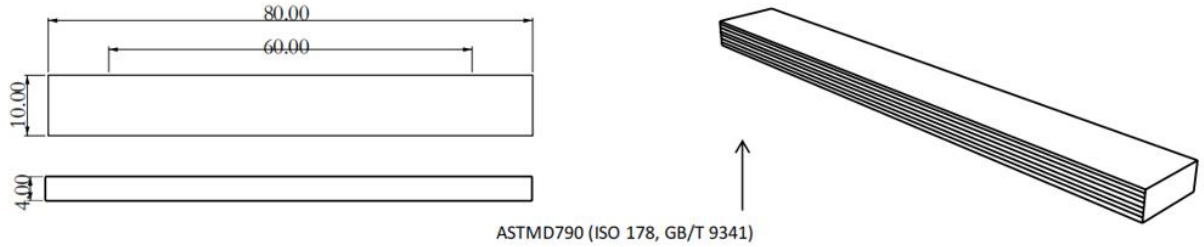

ASTMD790 (ISO 178, GB/T 9341)

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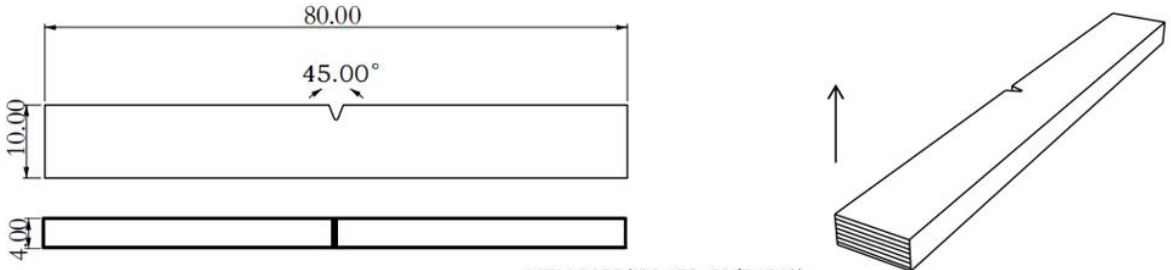

ASTM D256 (ISO 179, GB/T 1043)

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4. Recommended Printing Parameters

Print Temperature	Hotbed Temperature	Ambient Temperature	Print Speed	Pumping Distance
230-250℃	60-100℃	Normal-60℃	40-80mm/s	3-8mm

5. Compatible Models

CR-PETG wildly used in FDM 3D printers on the market.

6. Storage Condition

Please place this product in a dry and ventilated environment, not in an environment of high temperature, sunny or humid conditions. If it is not used up within a short time after opening, it is recommended to use it with a dry box when using it again.

7. Disclaimer

The values given in this data sheet are for reference and comparison only. Actual values may vary with printing conditions, and the end-use performance of printed models depends on model design, environmental conditions, printing conditions, etc.