

TECHNICAL DATA SHEET

PET-G

Description

Recreus PET-G is a highly modified PET copolymer amorphous, which belongs to the family of PET products commonly known as “PETG” (PET Glycol modified). Has been specially designed for 3D printing extrusions. With the excellent melt strength, makes ideally suitable for extrusion in FDM 3D printers.

Physical properties	Value	Unit	Test method according to
Material density	1.29	g/cm ³	DIN EN ISO 1183-1-A

Mechanical properties	Value	Unit	Test method according to
Hardness	76	Shore D	ASTM D2240 (2010)
Elongation at break	31	%	ISO 527-2
Tensile Modulus	3020	MPa	ISO 527-2
Flexural Modulus	2040	MPa	ISO 527-2
Flexural Strength	68	MPa	ISO 178
Vicat Softening temp.	82	°C	ISO 306
Izod Impact Resistance	4.4	kJ/m ²	ISO 180

Printing properties	Recommended
Printing temperatures	230 - 260°C
Printing speed	20 - 100 mm/s
Hot-bed temperature	40-70°C
Optimal layer height	0.2 mm
Minimal nozzle diameter	0.1-0.4 mm or higher
Retraction parameters	3.5 - 6.5 mm (speed 20 - 160 mm/s)