

# PETG/PTFE

## MATERIAL PROPERTIES

Density	1.32 g/cm <sup>3</sup>	ISO 1183
<b>Mechanical properties</b>		
Charpy impact strength*		
unnotched (at 23°C)	NB kJ/m <sup>2</sup>	ISO 179-1eU
notched (at 23°C)	6 kJ/m <sup>2</sup>	ISO 179-1eA
Tensile Elongation*		
At yield	3.70%	ISO 527 (1)
At break	>100%	ISO 527 (1)
Tensile Strength*		
At yield	40 MPa	ISO 527 (1)
At break	25 MPa	ISO 527 (1)
Elastic modulus tensile* (speed 1mm/min)	1850 MPa	ISO 527 (1)
<b>Thermal properties</b>		
VICAT Softening point	70°C	ISO 306

\*injection moulding

## GUIDELINE FOR PRINT SETTINGS\*

Nozzle temperature	230-255°C
Bed temperature	60-80°C
Active cooling fan	75-100%
Layer height**	0.05 - 0.30 mm
Shell thickness**	0.40 - 2.70 mm
Print speed**	30-70 mm/s
Closed chamber	not necessary
Dry box	not necessary
Ruby or hardened nozzle	not necessary

\* settings are based on a 0.4 mm nozzle.

\*\* depending on the geometrical complexity

## DESCRIPTION

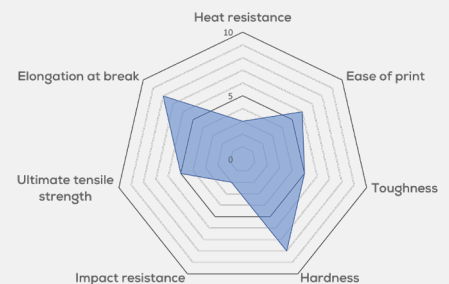
As the basis for the material, we used PETG, well-known for its excellent mechanical properties, supplemented by adding 10% PTFE, commonly known as Teflon, with self-lubricating properties. Thanks to the meticulous selection of components while reducing the coefficient of friction, the filament retains the ease of printing, interlayer adhesion, impact strength and thermal properties typical of PETG.

## FEAUTURES

- 10% PTFE content
- reduced coefficient of friction in comparison to conventional PETG
- thermal resistance up to 70°C
- ease of printing
- good chemical resistance
- perfect bonding of the layers

## STORAGE AND SHELF LIFE

Filament should be stored in a dry room at room temperature. Recommended storage temperature is ca. 18-25°C (64.4 -77.0°F). Keep out of moisture, sunlight and direct heat. When stored properly, product has a shelf life of 24 months.



## SUPPORT

If you have any questions or experience any issues, please do not hesitate to contact us at [support@spectrumfilaments.com](mailto:support@spectrumfilaments.com)