

rPETG

MATERIAL PROPERTIES

Specific Gravity	1.23 g/cm ³	ISO D1505
Moisture Absorption	<0.2 %	ISO D792

Mechanical Properties

Tensile Strength at Yield	52 MPa	ISO D882
Tensile Strength at Break	59 MPa	ISO D882
Elongation at Yield	4%	ISO D882
Elongation at Break	400%	ISO D882
Flexural Strength	68 MPa	ISO 178
Flexural Modulus	2000 Mpa	ISO 178
Izod Impact Strength Notched @ 23°C	101 J/m	ISO D256

Thermal Properties

Heat Deflection Temperature	70°C	ISO D648
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GUIDELINE FOR PRINT SETTINGS*

Nozzle temperature	230-255°C
Bed temperature	60-80°C
Active cooling fan	YES (up to 100%)
Layer height**	0.05 - 0.30 mm
Shell thickness**	0.40 - 2.70 mm
Print speed**	40-120 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

Disclaimer

The product- and technical data provided in this datasheet is correct to the best of Spectrum Group Sp. z o.o. knowledge and are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary according to printing conditions, model complexity, environmental conditions, etc. The user assumes all responsibility for the use of all information provided and shall verify quality and other properties or any consequence from the use of all such information. Typical values are indicative only and are not to be construed as being binding specifications. Spectrum Group Sp. z o.o. shall not be made liable for any damage, injury or loss induced from the use of Spectrum Group Sp. z o.o. materials in any particular application.

DESCRIPTION

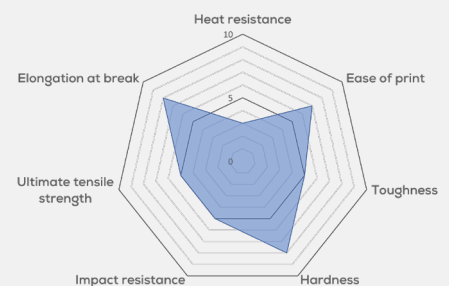
Spectrum r-PETG is an environmentally-friendly 3D printing material that fits into a sustainability initiative. The filament is created by reusing the recycled extrusion residual waste stream. The raw material is collected, shredded, re-mixed and homogenised into a high-grade and easy-to-print recycled PETG filament with much less environmental impact. Spectrum r-PETG retains the properties of classic PETG.

FEAUTURES

- manufactured from recycled materials
- lower environmental impact by reusing waste
- environmentally-friendly, cardboard spool
- easy printing, similar to standard PETG
- no shrinkage after cooling

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