



TECHNICAL DATA SHEET

PCTG

1. DESCRIPTION

PCTG is a modified copolyester for the highest industrial requirements. The material combines high chemical and thermal resistance with mechanical properties, such as high impact resistance, scratch resistance and excellent optical brilliance. In addition, it meets numerous certifications (cosmetics approval, FDA, REACH, RoHS).

2. FEATURES

- Good mechanical properties
- Excellent transparency
- High chemical resistance
- Clear colours
- Fire retardant according to UL94V2

3. PROPERTIES

TEST	METHOD	UNIT	VALUE
Flexural modulus (E-Modulus)	ISO 178	MPa	1650
Flexural strength	ISO 178	MPa	62
Tensile strength at yield	ISO 527	MPa	43
Tensile strength at break	ISO 527	MPa	45
Elongation at yield	ISO 527	%	4,3
Elongation at break	ISO 527	%	215
Notched impact strength	ISO 180	kJ/m ²	94 @ 23 °C
HDT/B	ISO 75	°C	76
VICAT (VST)	ASTM D1525	°C	88
Shrinking	ASTM D955	%	0,2 ~ 0,5
Density	ASTM D792	-	1,21
Rockwell Hardness	ASTM D785	R-Skala	105
Flammability	UL 94	V-2	3,2 mm
Flammability	UL 94	HB	1,5 mm

*Temperature resistance tested at a minimum wall thickness of 4 mm.

Recommended settings for printers with a 0.4mm Nozzle. Max. 50% layerheight. Optimal print settings may vary between different printers and also depend on environmental factors.

PRINT SETTINGS

Nozzle	220-270°C
Heatbed	90-110°C
Adhesive	not required
Speed	20-100mm/s
Cooling	20-50%
Open Space	yes
Hardened Nozzle	no



NEED HELP?

If you have any question about the product and/or you are experiencing an issue, please contact us via:

+43 660 8810 615 (Mo–Fr | 8 am - 14 pm)

support@extrudr.com | www.extrudr.com

5. CERTIFICATIONS & ADDITIONAL INFORMATION



FDA
compliant



RoHS
compliant



REACH
compliant



FREE
of Silicone



TOY SAFE
compliant



FLAMERETARDANT
UL 94 V-2

Certifications depend on colors in final product. More info in the additional information sheet.

6. STORAGE AND SHELF LIFE

Store in a dry room at room temperature (18-27°C / 65-80°F). Keep out of direct heat and sunlight.

When stored correctly, this material has a shelf life of 2 years.

Additional info in our regulatory, additional information and chemical resistance data sheets.