



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	PRINT SETTINGS
Flexural modulus (E-Modulus)	ISO 178	MPa	1650	Nozzle 230-270°C
Flexural strength	ISO 178	MPa	62	Heatbed 90-110°C
Tensile strength at yield	ISO 527	MPa	43	Adhesive not required
Tensile strength at break	ISO 527	MPa	45	Speed 20-200mm/s
Elongation at yield	ISO 527	%	4,3	Cooling 20-50%
Elongation at break	ISO 527	%	215	Enclosed Space for larger components
Notched impact strength	ISO 180	kJ/m ²	94 @ 23 °C	Hardened Nozzle no
HDT/B	ISO 75	°C	76	Max. Volumetric Speed 9 mm ³ /s
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	

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.

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

4. 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.

5. 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.