

PET-G HT100

MATERIAL PROPERTIES

Specific Gravity	1.18 g/cm ³	D 792
Mechanical Properties		
Tensile Stress at Yield	43 MPa	D 638
Tensile Stress at Break	52 MPa	D 638
Elongation at Yield	7,00%	D 638
Elongation at Break	210,00%	D 638
Flexural Modulus	1575 MPa	D 790
Flexural Strength	64 MPa	D 790
Rockwell Hardness, R Scale	111	D 785
Izod Impact Strength, Notched @ 23°C	860 J/m	D 256
Impact Strength, Unnotched @23°C	NB	D 4812
Thermal Properties		
Heat Deflection Temperature	100°C	D 648

GUIDELINE FOR PRINT SETTINGS*

Nozzle temperature	250-280°C
Bed temperature	100-110°C
Active cooling fan	0 - 30%
Layer height**	0.05 - 0.30 mm
Shell thickness**	0.40 - 2.70 mm
Print speed**	40-100 mm/s
Closed chamber	recommended for larger prints
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

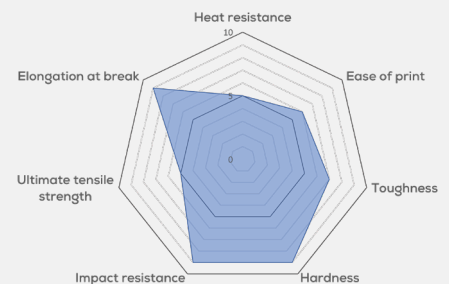
Spectrum PET-G HT100 is a co-polyester based filament designed for 3D printing in FFF / FDM technology. The material is intended for advanced users, who require excellent durability from print-outs working in real conditions. Excellent dimension stability allows printing with accurate dimensions, which is particularly important for projects consisting of many different elements.

FEAUTURES

- high dimensional stability
- high mechanical strength
- excellent toughness
- chemical resistance
- styrene-free
- FDA compliance
- clarity and gloss
- low odour

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