TECHNICAL DATA SHEET

FILAMENT 3D PET-G Standard HS

Revision date: 14.07.2025

Date of issue: 04/09/2025

BASIC INFORMATION

PRODUCT NAME: FILAMENT 3D PET-G Standard HS 1.75mm

PRODUCT DESCRIPTION: PET-G Standard filament - poly(ethylene terephthalate) with addition of glycol in the form of a thread, designed for 3D printing using the FFF/FDM method. Filament coiled on spools or cardboard core (no spool), vacuum-packed with desiccant in a PA/PE bag, and then in a box. The product is designed for use with 3D printers using FDM technology. It should be used in a well ventilated room to avoid exposure to fume emissions during printing. It is important to avoid direct contact with hot printer components, which can lead to burns. Filament should be stored in a dry place, in a closed container and away from children. It is recommended to use the filament within the recommended printing temperature range for optimum results. Dispose of waste filament in accordance with local regulations. The product has been designed with safety in mind and meets all relevant standards for consumer use.

STORAGE: Store in dry area. Store in a closed container.

PRODUCT PARAMETERS

PARAMETER	VALUE
Filament diameter [mm]	1.75
Diameter tolerance [mm]	+/-0,05
Oval tolerance [mm]	+/-0,02

RECOMMENDED PRINTING PARAMETERS

PARAMETER	VALUE
3D printing temperature [C]	220-250
Heated bed [C]	60-80
Cooling fan [%]	0-60
3D printing temperature (High Speed printing) [C]	240-270
Closed chamber	not required
Drying conditions [C/h]	60/4

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PHYSICAL PARAMETERS OF THE MATERIAL

PARAMETER	VALUE	UNIT	TEST METHOD
Density	1.29	g/cm3	-
Tensile modulus	2980	MPa	ISO 527
Tensile Stress at yield	51	MPa	ISO 527
Tensile strength at break	51	MPa	ISO 527
Tensile Strain at yield	4	%	ISO 527
Tensile Strain at break	4	%	ISO 527
Nominal Tensile Strain at Break	29	%	ISO 527
Flexural modulus	2040	MPa	ISO 178
Flexural stress	68	MPa	ISO 178
Izod impact strength (notched)	4	kJ/m2	ISO 180, -30°C
Izod impact strength (notched)	4	kJ/m2	ISO 180/A, 0°C
Izod impact strength (notched)	4.7	kJ/m2	ISO 180/A, 23°C
Izod impact strength (unnotched)	120	kJ/m2	ISO 180, -30°C
Izod impact strength (unnotched)	no break	kJ/m2	ISO 180, 0°C
Izod impact strength (unnotched)	no break	kJ/m2	ISO 180, 23°C
Glass Transition Temperature Tg	80	°C	ASTM D3418
VICAT	78	°C	ISO 306

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HDT B	68	°C	ISO 75, 0,45MPa
HDT A	62	°C	ISO 75, 1,8 MPa
Flame rating	V2	-	UL94 (4,0 mm)
Food Contact Approval	YES	-	FCA declaration in separate document

The values above have been measured using standard test specimens made of non-colored material at room temperature. The figures should be considered as indicative values only. Actual properties of PET-G Standard HS parts can be affected by the printing parameters, design of the model, ambient conditions, application of the printout etc. It is essential that users test our products to determine whether they are suitable for their intended use. ROSA PLAST Sp. z o.o. accepts no liability for any health detriment or material losses or any other losses related to the use of the material. Additional documents, certificates and detailed technical information can be provided on special request.

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