

## PET-G Premium High Speed

## MATERIAL PROPERTIES

|                              |                        |       |
|------------------------------|------------------------|-------|
| Specific Gravity             | 1.29 g/cm <sup>3</sup> | D 792 |
| <b>Mechanical Properties</b> |                        |       |
| Tensile Strength             | 35 MPa                 |       |
| Elongation at Break          | 10,00%                 |       |
| Elongation at Yield          | 6,00%                  | D 638 |
| Tensile Modulus              | 2990 MPa               | D 638 |
| Flexural Strength            | 64 MPa                 | D 790 |
| Flexural Modulus             | 2000 MPa               | D 790 |
| <b>Thermal Properties</b>    |                        |       |
| Heat Deflection Temperature  | 70°C                   | D 648 |
| Glass Transition Temperature | 80°C                   | D3418 |

## GUIDELINE FOR PRINT SETTINGS\*

|                                     |                                                                                                            |
|-------------------------------------|------------------------------------------------------------------------------------------------------------|
| Nozzle temperature - standard speed | 240-265°C                                                                                                  |
| Nozzle temperature - high speed     | 245-270°C                                                                                                  |
| Bed temperature                     | 60-80°C                                                                                                    |
| Active cooling fan                  | 75-100%                                                                                                    |
| Layer height**                      | 0.4 - 2.7 mm                                                                                               |
| Shell thickness**                   | 0.05-0.3 mm                                                                                                |
| Closed chamber                      | not necessary                                                                                              |
| Dry box                             | No                                                                                                         |
| Ruby or hardened nozzle             | No                                                                                                         |
| Drying (if wet)                     | recommended***                                                                                             |
| Adhesive                            | not necessary (if increased adhesion needed or to prevent warping:<br>glue stick, Dimafix, 3DLac, Magigoo) |

\* settings are based on a 0.4mm nozzle

\*\* depending on the geometrical complexity

\*\*\* at least 4h at 60°C using a hot dry air oven

## 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

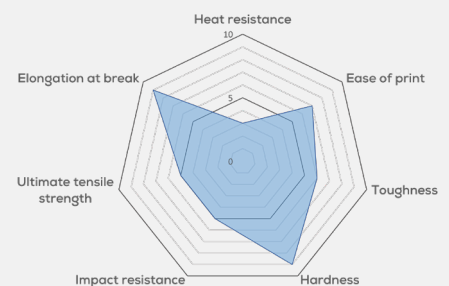
Spectrum PETG Premium High Speed filament is designed for fast 3D printing, combining the excellent mechanical properties of PETG with the capability to print at speeds of up to 800 mm/s. The material has been optimized specifically for high speed 3D printing technology, ensuring the perfect balance between speed and detail quality.

## FEAUTURES

- printing speeds up to 800 mm/s
- chemical resistance
- high dimensional accuracy of printed parts
- combines the advantages of PLA and ABS
- fully recyclable

## 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](mailto:support@spectrumfilaments.com)