

Technical Data Sheet Plexiwire PETG

Description

Plexiwire PETG is a modified PET with glicole 3D printing filament for FDM/FFF printers, available in 400m, 300m and 100m in 8 colors.

Material Properties

Specific Gravity	1.27 g/cm ³	D 792
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Mechanical Properties

Tensile Stress at Yield	26 MPa	D 638
Tensile Stress at Break	48 MPa	D 638
Elongation at Break	58,00%	D 638
Elongation at Yield	4,30%	D 638
Tensile Modulus	1950 MPa	D 638
Flexural Strength	64 MPa	D 790
Flexural Modulus	1880 MPa	D 790
Rockwell Hardness, R Scale	108	D 785
Izod Impact Strength, Notched @ 23°C	126 J/m	D 256
Izod Impact Strength, Notched @ -40°C	57 J/m	D 256

Thermal Properties

Heat Deflection Temperature	70°C	D 648
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Guideline for print settings*

Nozzle temperature	230-255°C
Bed temperature	60-80°C
Active cooling fan	YES (up to 100%)
Layer height**	0.05 - 0.30 mm
Shell thickness**	0.40 - 2.70 mm
Print speed**	40-120 mm/s
Closed chamber	not necessary
Dry box	not necessary
Ruby or hardened nozzle	not necessary

* settings are based on a 0,4 mm nozzle

** depending on the geometrical complexity

Filament Specification

Nominal diameter	1,75mm
Diameter tolerance	+ - 3%
Ovality	>= 97%
Available colors	white, black, yellow, green, red, blue, orange, grey
Netto filament weight	400m = 1.2kg +-5%, 300m = 0.9kg +-5%, 100m = 0.3kg +-5%