ePETG+HS

Technical Data Sheet

PETG+HS is a new optimization of PETG formula, faster and better cooling, suitable for high-speed printing, optimize the problem of material sticking to the nozzle when printing, reduce the chance of bad printing, cost-effective waterproof, resistant, high toughness, fast printing material.

Material Status	Mass Production	
Characteristics	• Great toughness	• Chemical resistance • Water resistance
Applications	• Advertisement • Waterproof application	• Snap-in parts • Flower pot
Form	• Filament	
Processing method	• 3D Print, FDM Print	

	testing method	Typical value	
Physical Properties			
Density	GB/T 1033	1.26	g/cm³
Melt Flow Index	GB/T 3682	24	(190℃/2.16kg)
Mechanical Properties			
Tensile Strength	GB/T 1040	29.2	MPa
Elongation at Break	GB/T 1040	4.2	%
Flexural Strength	GB/T 9341	63	MPa
Flexural Modulus	GB/T 9341	1708.7	MPa
IZOD Impact Strength	GB/T 1843	5.6	kJ/m²
Thermal Properties			
Heat distortion Temperature	GB/T 1634	68	℃
Continuous Service Temperature	IEC 60216	N/A	
Maximum (short term) Use Temperature		N/A	
Electrical Properties			
Insulation Resistance	DIN IEC 60167	N/A	
Surface Resistance	DIN IEC 60093	N/A	

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Recommended printing parameters

Extruder Temperature	220- 260℃
Build Platform Temperature	75-90℃
Fan Speed	100%
Printing Speed	40 - 300mm/s

Based on 0.4 mm nozzle and Simplify 3D v.4.1.2. Printing conditions may vary with different nozzle diameters

Drying Recommendations

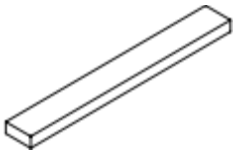
N/A

Precautions:

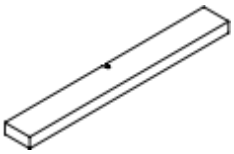
Turn on the Z seam alignment . Turn off the Z-axis lifting with drawing.
Slower the printing speed.

Mechanical Properties

Tensile testing specimen GB/T 1040



Flexural testing specimen GB/T 9341



Impact testing specimen GB/T 1043

The physical properties, mechanical properties, thermal properties, and electrical properties of the line are obtained based on the injection molding spline test.

Print test condition:

Extruder Temperature	220-260℃
Build Platform Temperature	75℃
Outline/Perimeter Shells	4
Top/Bottom Layers	4
Infill Percentage	20%
Fan speed	100%
Printing speed	300mm/s

Based on 0.4 mm nozzle and Simplify 3D v.4.1.2.

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