PETG-Basic

Technical Data Sheet

PETG-Basic is an economical PETG product that combines the advantages of PLA and ABS.it has a wide range of clors and off ers excellent printability,higt touhness,and a good surface gloss.The dimensions are stable and do not shrink or warp during printing.

Basic Information

Characteristics	• High cost performmence • Excellent printing performance • High toughness and high brightness	• High speed printing
Applications	• Lamps and lanterns • Electronic appliances	• Cosmetic containers • Stationery
Forming Method	• Filament	
Processing Method	• 3D Printing	

Physical Properties	Testing Method	Data
Density	GB/T 1033	1.27 g/cm3
Melt Flow Index	GB/T 3682	28 （250℃/2.16kg）

Thermal Properties	Testing Method	Data
Heat Distortion Temperature	GB/T 1634	73.8 ℃ (0.45Mpa)
Glass Transition Temperature		N/A
Continuous Service Temperature	IEC 60216	N/A
Maximum (short term) Use Temperature		N/A

Electrical Properties	Testing Method	Data
Insulation Resistance	DIN IEC 60167	N/A
Surface Resistance	DIN IEC 60093	N/A

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Mechanical Properties	Testing Method	Data
Tensile Strength (X-Y)	GB/T 1040	68.41 Mpa
Tensile Strength (Z)	GB/T 1040	35.84 MPa
Elongation at Break (X-Y)	GB/T 1040	7.56 %
Elongation at Break (Z)	GB/T 1040	3.17 %
Flexural Strength (X-Y)	GB/T 9341	100.2 MPa
Flexural Strength (Z)	GB/T 9341	59.7 Mpa
Flexural Modulus (X-Y)	GB/T 9341	2636.66 MPa
Flexural Modulus (Z)	GB/T 9341	2207.6 Mpa
IZOD Impact Strength (X-Y)	GB/T 1843	2.28 KJ/m^2
IZOD Impact Strength (Z)	GB/T 1843	2.06KJ/m^2

Chemical Properties	Data
Acid and Alkali Resistance	N/A
Grease Resistance	N/A
UV Resistance	YES
Water Repellency	YES

Recommended Printing Parameters	Data
Drying Preparation	60℃ > 8H
Nozzle Size	0.2,0.4,0.6,0.8mm
Nozzle Temperature	240-260℃
Build Platform Type	PEI
Build Platform Temperature	75-90℃
Fan Speed	50-100%
Printing Speed	< 250mm/s

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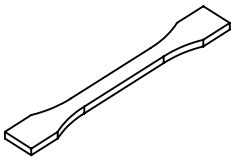
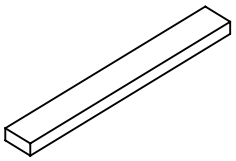
Printing Tips

When slicing, it is best to turn on the Z seam alignment and starting point alignment functions, turn off the Z-axis lift and exit, avoid passing through the shell when idling, optimize the slicing printing path, and appropriately reduce the printing speed to achieve the best printing effect.

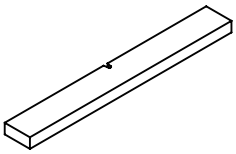
Test Conditions of Mechanical Properties



Tensile testing specimen GB/T 1040



Flexural testing specimen GB/T 9341



Impact testing specimen GB/T 1843

The performance of the filament is evaluated based on standard samples printed by eSUN, while the actual printing performance is influenced by various factors such as printer type, printing parameters, and print environment.

Printing Test Conditions:

Extruder Temperature	255℃
Build Platform Temperature	70℃
Outer Layer Number	2
Top/Bottom Layer Number	3
Infill Density	100%
Fan Speed	100%

*Based on Bambu P1S 0.4 mm nozzle and Orcaslicer 2.1.0 Beta.

Notice

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