

# Technical data sheet - 3D « PETG GLISS' » Filament

| Printing features              | Settings                     |
|--------------------------------|------------------------------|
| <b>Extrusion temperature</b>   | 240°C                        |
| <b>Bed temperature</b>         | 60°C                         |
| <b>Bed type</b>                | Mirror                       |
| <b>Bed surface treatment</b>   | Dimafix on mirror            |
| <b>Chamber temperature</b>     | Ambient temperature          |
| <b>Ventilation</b>             | 0% - 100% from the 2nd layer |
| <b>Printing speed</b>          | 50 mm/sec                    |
| <b>Shrinkage speed</b>         | 25 mm/sec                    |
| <b>Shrinkage distance</b>      | 6.5 mm                       |
| <b>Min. 3D printing skills</b> | For all levels               |

Printing may vary between printers and printheads

## Recommendations :

- Recommended melting temperature of 240° to avoid stringing or remove small threads after production.
- No need for a printer with a closed chamber.

## **THESE VALUES ARE INDICATIVE AND MAY VARY**

CAPIFIL property document, do not duplicate, do not distribute without written permission from CAPIFIL

Non-contractual information

[www.capifil.com](http://www.capifil.com)

| <b>PHYSICAL PROPERTIES - Typical values</b>       | <b>STANDARDS</b> | <b>SI UNITS</b> |                   |
|---|------------------|-----------------|-------------------|
| <b>Density</b>                                    |                  |                 |                   |
| material  | ISO 1183         | 1.34            | g/cm <sup>3</sup> |
| <b>MECHANICAL PROPERTIES - Typical values</b>     | <b>STANDARDS</b> | <b>SI UNITS</b> |                   |
| <b>CHARPY impact strength (sample 80x10x4 mm)</b> |                  |                 |                   |
| Unnotched, injection moulding                     | ISO 179-1eU      | <b>NB</b>       | kJ/m <sup>2</sup> |
| Notched, injection moulding                       | ISO 179-1eA      | 3               | kJ/m <sup>2</sup> |
| <b>Tensile elongation (speed 5 mm/min)</b>        |                  |                 |                   |
| At yield, injection moulding                      | ISO 527-1        | 3.1             | %                 |
| At break, injection moulding                      | ISO 527-1        | 40              | %                 |
| <b>Tensile strength (speed 5 mm/min)</b>          |                  |                 |                   |
| At yield, injection moulding                      | ISO 527-1        | 45              | MPa               |
| At break, injection moulding                      | ISO 527-1        | 25              | MPa               |
| <b>Elastic modulus</b>                            |                  |                 |                   |
| Tensile (speed 1 mm/min), injection moulding      | ISO 527-1        | 2200            | MPa               |
| <b>FILAMENT EXTRUSION PARAMETERS</b>              | <b>STANDARDS</b> | <b>SI UNITS</b> |                   |
| Material drying (at least 4h @ ...)               |                  | 60              | °C                |
| Extrusion temperature                             |                  | 230 ± 240       | °C                |