

PETG-ESD Filament

Technical Data Sheet



Main Specifications

Physical Properties		Test Means	
Density	ISO 1183	1.27~1.28	g/cm ³
MFR (220 °C/2.16Kg)	ISO 1133	8~12	g/10min
Moisture Absorption (23 °C/24h)	ISO 62	<0.2	%
Mechanical Properties			
Tensile strength (X-Y)	ISO 532	35~40	Mpa
Surface resistivity (X-Y)	ISO 2878	10 ⁶ ~10 ⁸	Ω/sq
Elongation at break (X-Y)	ISO 527	5~8	%
Flexural Modulus (X-Y)	ISO 527	1400~1500	Mpa
Flexural Strength (X-Y)	ISO 178	64~66	Mpa
Impact Strength (X-Y)	ISO 180	5~6	KJ/m ²
Thermodynamic Properties			
HDT @ 0.455 MPa (66 psi)	ISO 75	74	°C

Recommended Printing Parameters

Parameters	
Nozzle Temperature	220~270°C
Bed Temperature	70~80°C
Bed Materials	Tempered glass, BuildTak, Carbon fiber board
Nozzle Diameter	φ 0.4/0.6
Model Cooling Fan	0~50%
Layer	0.1~0.3mm
Printing Speed	40~220mm/s(High speed requires high temperature)
Retraction Distance	1~2mm
Retraction Speed	30~50mm/s
Supporting Materials	Itself