

TECHNICAL DATA SHEET



High Precision PET

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Product specifications

A pure PET filament with guaranteed "High Precision" on diameter, ovality, shrinkage, and color tolerances. Each spool has its own certificate of analysis, which can be verified by scanning the QR code.

Important key features

3-axes filament measurement to ensure the tightest diameter and ovality tolerances

Precise batch-to-batch color consistency (\leq Delta E5)

Suitable applications

3D Prints details with a high resolution and high surface quality

Recommended pretreatment

Drying

Required
45 - 60 °C
6 h

Print with

Enclosure	Yes
Dry box	Yes

Recommended print settings regular speed

Print speed	- mm/s
Nozzle temperature	235 - 260 °C
Bed temperature	80 - 90 °C
Fan speed	0 - 50 %

Recommended print settings high speed

High Precision PET is high speed compatible. Our recommended settings will be added once available. Please take note that the nozzle temperature and fan speed need to be raised when printing at high speed.

Material properties	Typical value	Unit of Measure	Test method	Test condition
Density	1,34	g/cm ³		
Specific gravity				
Melt flow rate	47	g/10min	ISO 1133	285°C/2,16kg
Mechanical properties				
Impact strenght	1.7	kJ/m ²	ISO 179-1	Charpy notched 23°C
Tensile strenght at yield	59,4	MPa	ISO 527-2	
Tensile strenght at break	54,3	MPa	ISO 527-2	
Tensile modulus	2564	MPa	ISO 527-2	
Elongation at yield	2,9	%	ISO 527-2	
Elongation at break	5,2	%	ISO 527-2	
Flexural strenght	87,5	MPa	ISO 178	
Flexural modulus	2621	MPa	ISO 178	
Rockwell hardness	75,3 Shore D			
Thermal properties				
Melting temperature				
Heat deflection temperature	65,7	°C	ISO 75-2	HDT A
Vicat softening temperature	65,9	°C	ISO 306	
Glass transition temperature	70	°C	DSC (10°C/min)	

Product export information

HS code

39169090

Description

Monofilament for 3D printing

Origin

European Union

Disclaimer

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