

## PET transparent

- Temperature print: 240-270 °C for 2,90 mm filament / 230-260 °C for 1,75 mm filament
- Temperature pad: 60°C



Material data sheet for PET:

Property <sup>a</sup>	Test <sup>b</sup> Method	Typical Value, Units <sup>c</sup>
<b>General Properties</b>		
Specific Gravity	D 792	1.27
Mold Shrinkage Parallel to Flow, 3.2-mm (0.125-in.) thickness	D 955	0.002-0.005 mm/mm (0.002-0.005 in./in.)
<b>Thermal Properties</b>		
Deflection Temperature		
@ 0.455 MPa (66 psi)	D 648	69°C (156°F)
@ 1.82 MPa (264 psi)	D 648	60°C (140°F)
<b>Mechanical Properties</b>		
Tensile Stress @ Break	D 638	26 MPa (3700 psi)
Tensile Stress @ Yield	D 638	48 MPa (6900 psi)
Elongation @ Break	D 638	58%
Elongation @ Yield	D 638	4.3%
Tensile Modulus	D 638	1950 MPa (2.8 x 10 <sup>5</sup> psi )
Flexural Strength	D 790	64 MPa (9300 psi)
Flexural Modulus	D 790	1880 MPa (2.7 x 10 <sup>5</sup> psi )
Rockwell Hardness, R Scale	D 785	108
Izod Impact Strength, Notched		
@ 23°C (73°F)	D 256	126 J/m (2.4 ft·lbf/in.)
@ -40°C (-40°F)	D 256	57 J/m (1.0 ft·lbf/in.)
<b>Optical Properties</b>		
Haze	D 1003	0.3%
Total Transmittance	D 1003	90%
<b>Typical Processing Conditions</b>		
Drying Temperature		71°C (160°F)
Drying Time		6 hrs
Processing Melt Temperature		249-271°C (480-520°F)
Mold Temperature		16-38°C (60-100°F)