

Product technical instructions

Product brand: Piocreat_PETG-1013

Material No.: D3305050012

Technical Data Sheet (Ver.1.0, last updated: May, 2023)

PETG-1013 is a glass fiber reinforced (30% mass percent) PETG particle with excellent printability, warp resistance and weather resistance designed specifically for large area additive manufacturing (MAAM) technology.

Physical Properties

Property	Testing Method	Typical Value
Density (g/cm ³ at 21.5 °C)	ASTM D792 (ISO 1183, GB/T 1033)	1.39
Glass transition temperature (°C)	DSC, 10°C/min	81
Heat Deflection Temperature (°C)	ISO 75 1.8MPa 0.45MPa	77 82

Mechanical Properties¹

Property	Testing Method	Typical Value
Bending modulus (MPa) (X - Y)	Modified ASTM D 790 (ISO 178, GB/T 9341)	6094 ± 1344
Bending strength (MPa) (X - Y)	Modified ASTM D 790 (ISO 178, GB/T 9341)	128.1 ± 7.8
Charpy Impact strength (kJ/m ²) (X - Y)	Modified ASTM D256 (ISO 179, GB/T 1043)	21.3 ± 0.92
Bending modulus (MPa) (Z)	Modified ASTM D 790 (ISO 178, GB/T 9341)	2701 ± 366
Bending strength (MPa) (Z)	Modified ASTM D 790 (ISO 178, GB/T 9341)	46.8 ± 3.3
Charpy Impact strength (kJ/m ²) (Z)	Modified ASTM D256 (ISO 179, GB/T 1043)	5.2 ± 1.3

1. Tested with the specimens printed under the following conditions:
Nozzle temperature = 240 °C, printing speed = 12kg/h, Nozzle diameter: 7.0 mm, Shell width = 10mm, Layer height = 3mm, Layer time = 60s, Room temperature = 10° C, 100% solid specimens,

Recommended Printing Conditions

Parameter	Recommended Setting
Drying temperature (° C)	60-65
Drying Time (h)	8-12
Maximum moisture content (%)	0.54
Barrel – zone 1 temperature (° C)	170
Barrel – zone 2 temperature (° C)	220-240
Barrel – zone 3 temperature (° C)	220-240
Nozzle temperature (° C)	210
Bed temperature (° C)	Room temperature-70
Other Comments	
● It is recommended to stop feeding and continue extruding until the extruder is fully empty, if the printing stops in a short term, such as 10-30 min ● It is recommended to stop feeding and continue extruding until the extruder is fully empty, then use polyethylene (PE) to clean the extruder, if the printing stop in a long term, such as several hours. It is helpful to avoid the carbonization of material and keep extruder working in a good condition	

Shenzhen Piocreat 3D Technology Co.,Ltd.

📍 19F, JinXiuHongDu Building, Meilong Blvd, Longhua Dist, Shenzhen, China 518131

☎ Tel: +86 0755-2103-9743 / +86 199 2521 7796

✉ Technical support: after@piocreat3d.com

🌐 www.piocreat3d.com

Disclaimer

The typical values presented in this data sheet are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary significantly with printing conditions. End use performance of printed parts depends not only on materials, but also on part design, environmental conditions, printing conditions, etc. Product specifications are subject to change without notice.

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