rPETG

MATERIAL PROPERTIES

Specific Gravity	1.23 g/cm³	ISO D1505
Moisture Absorption	<0.2 %	ISO D792

Mechanical Properties

Tensile Strength at Yield	52 MPa	ISO D882
Tensile Strength at Break	59 MPa	ISO D882
Elongation at Yield	4%	ISO D882
Elongation at Break	400%	ISO D882
Flexural Strength	68 MPa	ISO 178
Flexural Modulus	2000 Mpa	ISO 178
Izod Impact Strength Notched @ 23°C	101 J/m	ISO D256

Thermal Properties

Heat Deflection Temperature	70°C	ISO D648

GUIDELINE FOR PRINT SETTINGS*

Nozzle temperature	230-255°C
Bed temperature	60-80°C
Active cooling fan	YES (up to 100%)
Layer height**	0.05 - 0.30 mm
Shell thickness**	0.40 – 2.70 mm
Print speed**	40-120 mm/s
Closed chamber	not necessary
Dry box	not necessary
Ruby or hardened nozzle	not necessary

* settings are based on a 0,4 mm nozzle.
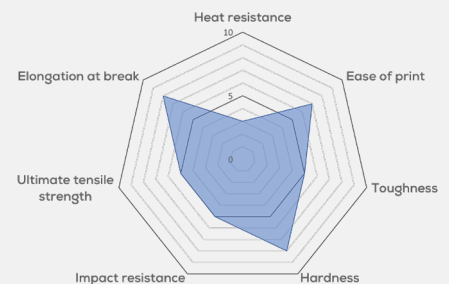** depending on the geometrical complexity

DESCRIPTION

Spectrum r-PETG is an environmentally-friendly 3D printing material that fits into a sustainability initiative. The filament is created by reusing the recycled extrusion residual waste stream. The raw material is collected, shredded, re-mixed and homogenised into a high-grade and easy-to-print recycled PETG filament with much less environmental impact. Spectrum r-PETG retains the properties of classic PETG.

FEATURES

- manufactured from recycled materials
- lower environmental impact by reusing waste
- environmentally-friendly, cardboard spool
- easy printing, similar to standard PETG
- no shrinkage after cooling

STORAGE AND SHELF LIFE

Filament should be stored in a dry room at room temperature. Recommended storage temperature is ca. 18-25°C (64.4 -77.0°F). Keep out of moisture, sunlight and direct heat. When stored properly, product has a shelf life of 24 months.

SUPPORT

If you have any questions or experience any issues, please do not hesitate to contact us at
support@spectrumfilaments.com