

TECHNICAL DATA SHEET

ReForm rPETG GF20

Date of issue: 10-02-2025 / Date of update: 31-10-2025



ReForm rPETG GF20 Pellets – The Go-To Material for Large-Format Additive Manufacturing (LFAM)

ReForm rPETG GF20 is a high-performance material designed specifically for Large-Format Additive Manufacturing (LFAM). Made from 100% post-industrial recycled PETG and reinforced with 20% long glass fibers, this compound offers an exceptional balance of sustainability, stiffness, and printability.

Its unique formulation ensures excellent layer adhesion, resulting in a rigid and easy-to-print material that performs reliably in demanding LFAM environments. ReForm rPETG GF20 combines mechanical strength, dimensional stability, and impact resistance, making it a versatile solution for industrial-grade 3D printing.

ReForm rPETG GF20 features a Heat Deflection Temperature (HDT) of 85 °C, providing reliable thermal performance for large-format 3D printed parts exposed to elevated temperatures. This makes it an excellent choice for industrial applications requiring dimensional stability under heat.

Thanks to its low warping, excellent layer adhesion, and high mechanical strength, ReForm rPETG GF20 ensures consistent and reliable performance in large-format 3D printing. Its aesthetically pleasing surface finish and dimensional accuracy make it the preferred choice for manufacturers seeking both quality and sustainability.

Key Features of ReForm rPETG GF20 Pellets for LFAM

- **LFAM-Optimized Printability** – Easy-to-print and reliable performance in large-format 3D printing.
- **20% Long Glass Fiber Reinforcement** – Delivers superior stiffness and strength.
- **High Dimensional Stability** – Ideal for large, functional parts.
- **Impact & Wear Resistance** – Durable under mechanical stress.
- **Good Thermal Performance** - HDT of 85 °C.

Suitable Applications for ReForm rPETG GF20 Pellets for LFAM

- **Electrical & Electronic Enclosures** – Non-conductive, perfect for insulating housings and covers.
- **Architectural & Construction Elements** – Large-format decorative panels, structural prototypes, and formwork.
- **Furniture & Interior Design** – Custom furniture, art installations, and functional design pieces where strength and surface finish matter.
- **Automotive & Transportation Components** – Structural parts, brackets, housings, and panels that need to withstand mechanical stress and heat.
- **Industrial Tooling & Fixtures** – Perfect for jigs, molds, and fixtures that require high stiffness and wear resistance.

Material properties	Typical value	Test Method
Melt mass-flow rate (MFR @ 200 °C /5kg)	1,2 g/10min	ISO 1133
Density	1,39 g/cm ³	ASTM D792
Mechanical properties		
Tensile strength	75 MPa	ISO 527
Tensile modulus	4500 MPa	ISO 527
Elongation at break	4%	ASTM D638
Impact strength (notched)	7,4 kJ/m ²	ISO 179
Thermal properties		
HDT (@ 045MPa)	85 °C	ASTM D648
Melt temperature	240 °C	-



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Processing Recommendations for ReForm rPETG GF20 Pellets for LFAM

Pre-Drying: 8-10hrs at 65 °C (<400ppm / 0,04%) *

Do not exceed a drying temperature of 65 °C, as higher temperatures may cause pellet softening and caking within the drying hopper.

Prolonged (pre-)drying is required for ReForm rPETG GF20

ReForm rPETG GF20 is made from recycled PETG materials that have been used in outdoor applications. Therefore, it is recommended to pre-dry for at least 8-10 hours at 65 °C and lower the moisture content in the ReForm rPETG GF20 compound.

For optimal 3D printing results it is recommended to pre-dry ReForm rPETG GF20 pellets to a moisture content below 400 ppm.

Zone 1: 210°C ±10 °C

Zone 2: 220°C ±10 °C

Zone 3: 230°C ±10 °C

Max temp: 240 °C

Die temp: 230°C ±20 °C

Typical extrusion settings may require optimization based on hardware used.

Storage and Handling Guidelines for ReForm rPETG GF20 Pellets for LFAM

ReForm rPETG GF20 is an inert and safe material under standard storage conditions, presenting no significant hazards. To ensure maximum quality, stability, and long-term performance, proper storage practices are recommended.

For best results:

- Store in a tightly sealed container to protect against moisture absorption.
- Keep in a dry, cool, and well-ventilated environment.
- Avoid direct exposure to sunlight or intense artificial light to preserve material integrity.

By following these guidelines, ReForm rPETG GF20 will maintain its reliability and print performance over time.

Product export information

HS code: 39079980

Description: Recycled PETG resin with glass fiber reinforcement in primary form

Origin: European Union

Disclaimer

The product and technical data provided in this datasheet are, to the best of FormFutura B.V.'s knowledge, accurate at the time of publication and are intended solely for reference and comparative purposes. Actual results may vary depending on printing conditions, model design, environmental factors, and other variables. The values presented are typical, non-binding, and should not be interpreted as guaranteed specifications.

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