

## Product Name:

# Anycubic PETG

Anycubic PETG is a high-toughness basic filament known for its vibrant colors, durability (impact-resistant), water/weather resistance, and chemical stability. Its cost-effectiveness makes it widely adopted in various applications.

## Physical Properties

| Property                      | Testing Method   | Unit              | Typical Value |
|-------------------------------|------------------|-------------------|---------------|
| Density/ (g/cm <sup>3</sup> ) | ISO 1183,at 23°C | g/cm <sup>3</sup> | 1.23          |
| Melt Index/ (g/10min)         | ISO 1133         | g/10min           | 26.3±2.35     |
| Moisture Content              | ISO 787-2        | %                 | 0.27          |

## Mechanical Properties

| Property                                        | Testing Method | Unit              | Typical Value |
|-------------------------------------------------|----------------|-------------------|---------------|
| Tensile Strength / MPa (X-Y)                    | ISO 527        | MPa               | 52±1          |
| Tensile Strength / MPa (Z)                      |                |                   | 31±3          |
| Young's Modulus / MPa (X-Y)                     | ISO 527        | MPa               | 1850±100      |
| Young's Modulus / MPa (Z)                       |                |                   | /             |
| Elongation at Break / % (X-Y)                   | ISO 527        | %                 | 13±1          |
| Elongation at Break / % (Z)                     |                |                   | /             |
| Bending Strength / MPa (X-Y)                    | ISO 178        | MPa               | 80±2          |
| Bending Strength / MPa (Z)                      |                |                   | /             |
| Bending Modulus / MPa (X-Y)                     | ISO 178        | MPa               | 2000±50       |
| Bending Modulus / MPa (Z)                       |                |                   | /             |
| Izod Impact Strength (kJ/m <sup>2</sup> ) (X-Y) | ISO 179        | kJ/m <sup>2</sup> | 45±2          |
| Izod Impact Strength (kJ/m <sup>2</sup> ) (Z)   |                |                   | /             |

\*All data are based on printed test samples. '(X-Y)' and '(Z)' indicate different testing orientations (refer to the direction schematic).

### Thermal Performance

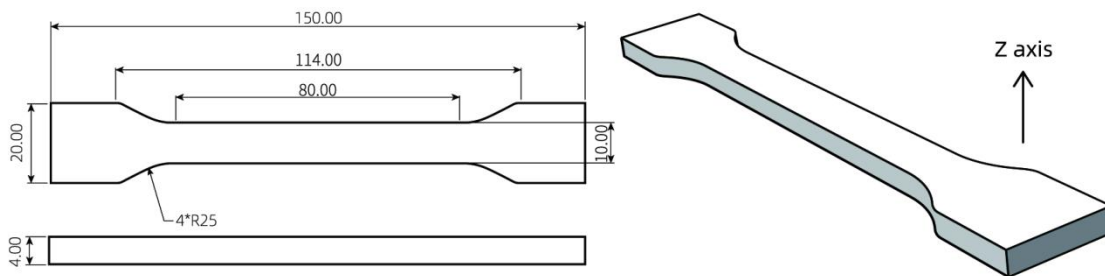
| Property                          | Testing Method        | Unit | Typical Value |
|-----------------------------------|-----------------------|------|---------------|
| Glass Transition Temperature      | ISO 11357-1, 10°C/min | °C   | 74.1          |
| Melting Temperature               | ISO 11357-1, 10°C/min | °C   | /             |
| Crystallization Temperature       | ISO 11357-1, 10°C/min | °C   | /             |
| Vicat Softening Temperature (VST) | ISO 306, 10N          | °C   | 72            |
| Heat Deflection Temperature (HDT) | ISO 75-2, 1.8 MPa     | °C   | /             |
| Heat Deflection Temperature (HDT) | ISO 75-2, 0.45MPa     | °C   | 69            |

### Recommended Printing Parameters

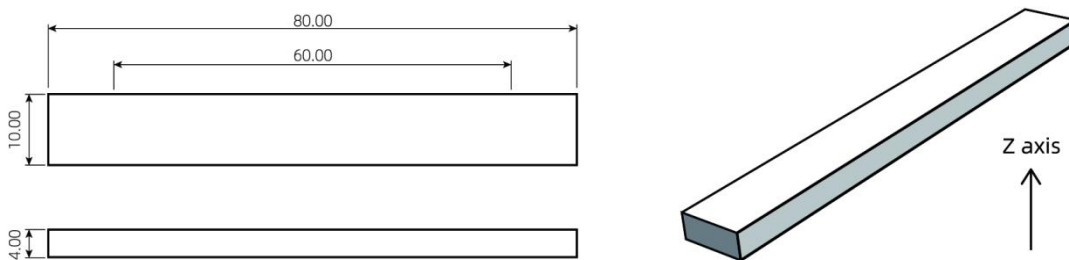
\*Based on a 0.4mm nozzle, printing conditions may vary with different nozzle diameters

| Parameter                | Recommended Value |
|--------------------------|-------------------|
| Nozzle Temperature       | 230-250           |
| Bed Temperature          | 60-70             |
| Dry Environment          | 55-65°C , 6-8h    |
| Printing Speed           | 50-250            |
| Extrusion Multiplier     | 0.96              |
| Max Volumetric Flow Rate | 12                |
| Fan Speed                | 90%               |
| Cooling Time             | 12                |
| Minimum printing Speed   | 20                |
| Raft Separation Distance | 0.8               |
| Retraction Speed         | 30                |

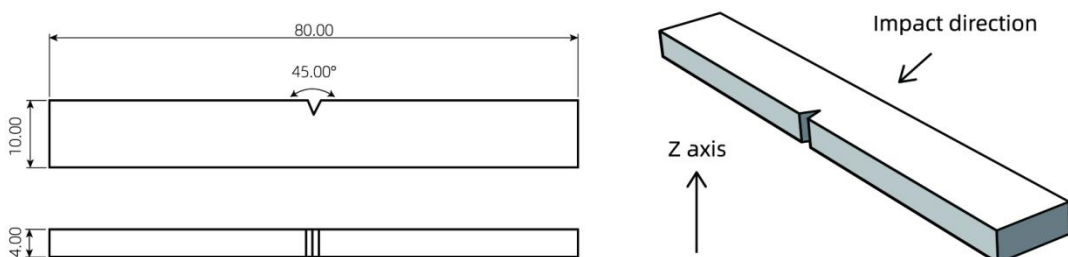
### TENSILE TESTING SPECIMEN



### IMPACT TESTING SPECIMEN



### IMPACT TESTING SPECIMEN



#### Disclaimer:

The values shown in this chart are for comparison purposes only and are not appropriate for design specifications or quality assurance. Variations may arise due to printing conditions. The end-use performance of printed parts depends on materials, design, environmental conditions, and printing conditions. Please note that product specifications are subject to change without notice.

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