



TECHNICAL DATA SHEET

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PETG 3D Printer Filament

PETG copolyester · Product code CX13 · 1.75 mm and 2.85 mm

Base resin: PETG copolyester

Typical values for the base resin. Printed parts vary with print settings, orientation and moisture content. Values are for the PETG base resin. Matte PETG contains 10% matte additive, so its values can differ.

Physical properties

Property	Standard	Unit	Typical value
Density / specific gravity	ASTM D792		1.27
Molding shrinkage, flow	ASTM D955	in/in	2.0E-3 to 5.0E-3
UL 94 flammability classification @ 1.0 mm	UL-94		HB
UL 94 flammability classification @ 1.5 mm	UL-94		HB
UL 94 flammability classification @ 3.0 mm	UL-94		V-2

Mechanical properties

Property	Standard	Unit	Typical value
Tensile strength at yield	ASTM D638	MPa (psi)	44.6 (6,470)
Tensile strength at yield	ISO 527-2	MPa (psi)	49.0 (7,110)
Tensile strength at break	ASTM D638	MPa (psi)	29.4 (4,270)
Tensile strength at break	ISO 527-2	MPa (psi)	30.0 (4,350)
Tensile elongation at yield	ASTM D638	%	4.5
Tensile elongation at yield	ISO 527-2	%	4.1
Tensile elongation at break	ASTM D638	%	250
Tensile elongation at break	ISO 527-2	%	240
Flexural modulus	ASTM D790	MPa (psi)	2,160 (313,000)
Flexural modulus	ISO 178	MPa (psi)	1,800 (261,000)
Flexural strength	ASTM D790	MPa (psi)	73.8 (10,700)
Flexural strength	ISO 178	MPa (psi)	64.0 (9,280)
Notched Izod impact, 73 °F	ASTM D256	J/m (ft·lb/in)	107 (2.0)
Notched Izod impact, 73 °F	ISO 180	kJ/m ² (ft·lb/in ²)	7.36 (3.5)
Rockwell hardness (R-scale)	ASTM D785		108

Thermal properties

Property	Standard	Unit	Typical value
Deflection temperature under load, 66 psi, unannealed	ASTM D648	°C (°F)	70.0 (158)
Deflection temperature under load, 66 psi, unannealed	ISO 75-2/B	°C (°F)	72.2 (162)
Deflection temperature under load, 264 psi, unannealed	ASTM D648 / ISO 75-2/A	°C (°F)	62.2 (144)

Optical properties

Property	Standard	Unit	Typical value
Light transmittance	ASTM D1003	%	90.0
Haze	ASTM D1003	%	< 1.00

Filament specifications

Diameter	Nominal	Minimum	Maximum	Tolerance
1.75 mm	1.75 mm (0.0689 in)	1.72 mm (0.0677 in)	1.78 mm (0.0701 in)	±0.03 mm (±0.0012 in)
2.85 mm	2.85 mm (0.1122 in)	2.79 mm (0.1098 in)	2.91 mm (0.1146 in)	±0.06 mm (±0.0024 in)

Recommended print settings

Nozzle temperature	240–265 °C
Bed temperature	70–90 °C
Part cooling fan	40–70%, off for the first layer
Enclosure	Recommended
Drying	65 °C for 4–6 hours

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