



TDS Rev 2.0

Technical Data Sheet: CX14 ESD PETG SERIES 3D PRINTING FILAMENT**BASE RESIN:** PETG compounded with carbon nanotubes (CNT)

Physical Properties	Standard	Unit	Typical Value
Specific Gravity- Density	ASTM D792	g/cc	1.29

Mechanical Properties	Standard	Unit	Typical Value
Tensile Strength	ASTM D638	MPa (psi)	52 (7,500)
Tensile Modulus	ASTM D638	MPa (psi)	2,000 (290,000)
Elongation at Break	ASTM D638	%	12
Flexural Strength	ASTM D790	MPa (psi)	62 (9,000)
Flexural Modulus	ASTM D790	MPa (psi)	1,400 (203,000)
Notched Izod Impact	ASTM D256	J/m (ft-lb/in)	34 (0.6)
Unnotched Izod Impact	ASTM D256	J/m (ft-lb/in)	2,200 (41)

Thermal Properties	Standard	Unit	Typical Value
Heat Deflection Temp @ 0.45MPa	ASTM D648	°C (°F)	70 (158)
Heat Deflection Temp @ 1.8MPa	ASTM D648	°C (°F)	64 (147)

Electrical Properties	Standard	Unit	Typical Value
Surface Resistance	Internal method	Ohm	10 ⁴

SPECIFICATIONS		
Filament Size:	1.75mm	0.0689 in
MIN Diameter:	1.72mm	0.0677 in
MAX Diameter:	1.78mm	0.0701 in
Tolerance	+/- .03mm	+/- 0.0012 in

NOTES	
Typical values from injection-molded samples. Preliminary; not a specification.	
Made in Green Bay, Wisconsin, USA	

Recommended Print Settings
Nozzle Temp: 240–260°C (464–500°F), start at 250°C
Bed Temp: 70–90°C (158–194°F), start at 80°C
Part Cooling Fan: 40–70%, off for first layer
Build Plate: glue stick, hairspray or WELD3D as a release agent
Abrasive: use a hardened steel or wear-resistant nozzle.
Drying: 4–6 h at 60°C (140°F) in a desiccant dryer

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