

PETG+

Technical Data Sheet

PETG+ is a high-performance, eco-friendly 3D printing material engineered for exceptional printability and superior part fidelity. It delivers a smooth surface finish with clean, consistent layer lines, outstanding optical clarity, and reliable processability. Featuring an optimal balance of strength, stiffness, and toughness, PETG+ provides stable and dependable performance for creative 3D printing applications, effortlessly transforming design concepts into high-quality finished parts.

Basic Information

Characteristics	• Excellent resilience • Good transparency • High molding accuracy	• Smooth surface and neat layer lines • Easy to print • Hard to break
Applications	• Prototyping • Translucent model	• Decoration • Other mechanical parts
Forming Method	• Filament	
Processing Method	• 3D Printing	• FDM Printing

Physical Properties	Testing Method	Data
Density	GB/T 1033	1.27±0.01g/cm ³
Melt Flow Index	GB/T 3682	15±5(250°C/2.16kg)

Thermal Properties	Testing Method	Data
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15AB, Microsoft Ketong Building, No. 55, Gaoxin South Nine Road, Yuehai Street, Nanshan District, Shenzhen, China

Tel: (086)-0755-86581960

Fax: (086)-0755-26031982

Email: bright@brightcn.net

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Heat Distortion Temperature	GB/T 1634	70°C(0.45Mpa)
Glass Transition Temperature		N/A
Continuous Service Temperature	IEC 60216	N/A
Maximum(short term)Use Temperature		N/A

Electrical Properties	Testing Method	Data
Insulation Resistance	DINIEC 60167	N/A
Surface Resistance	DINIEC 60093	N/A

Mechanical Properties	Testing Method	Data
Tensile Strength (X-Y)	GB/T 1040	48Mpa
Tensile Strength (Z)	GB/T 1040	26MPa
Elongation at Break (X-Y)	GB/T 1040	5.56%
Elongation at Break (Z)	GB/T 1040	3.31%
Flexural Strength (X-Y)	GB/T 9341	83.2MPa
Flexural Strength (Z)	GB/T 9341	53.2Mpa
Flexural Modulus (X-Y)	GB/T 9341	1993.64MPa
Flexural Modulus (Z)	GB/T 9341	1687.64Mpa
IZOD Impact Strength (X-Y)	GB/T 1843	2.21KJ/m ²
IZOD Impact Strength (Z)	GB/T 1843	2.02KJ/m ²

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Chemical Properties	Data
Acid and Alkali Resistance	NO
Grease Resistance	N/A
UV Resistance	NO
Water Repellency	N/A

Recommended Printing Parameters	Data
Drying Preparation	60°C > 8H
Nozzle Size	0.2,0.4,0.6,0.8mm
Nozzle Temperature	230-250°C
Build Platform Type	PEI
Build Platform Temperature	75-90°C
Fan Speed	100%
Printing Speed	≤250mm/s

Printing Tips

When slicing, it is best to turn on the Z seam alignment and starting point alignment functions, turn off the Z-axis lift and exit, avoid passing through the shell when idling, optimize the slicing printing path, and appropriately reduce the printing speed to achieve the best printing effect.

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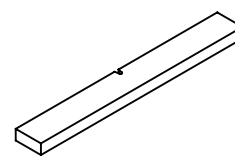
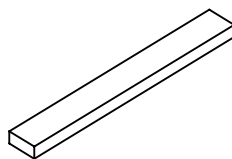
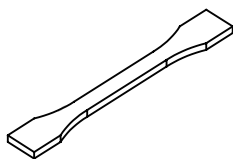
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Test Conditions of Mechanical Properties



Tensile testing specimen GB/T 1040 Flexural testing specimen GB/T 9341 Impact testing specimen GB/T 1843

The performance of the filament is evaluated based on standard samples printed by eSUN, while the actual printing performance is influenced by various factors such as printer type, printing parameters, and print environment.

Printing Test Conditions

Extruder Temperature	245°C
Build Platform Temperature	70°C
Outer Layer Number	2
Top/Bottom Layer Number	3
Infill Density	100%
Fan Speed	20%

*Based on Bambu P1S 0.4mm nozzle and Orcaslicer 2.1.0 Beta.

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