



Technical Data Sheet

3D Printing Filament

Material: PETG-HF

Description:

PETG-HF is a toughness-modified PETG engineered specifically for high-speed 3D printing. It delivers excellent flow behavior, enabling faster print speeds with consistent layer bonding, while offering enhancing mechanical strength and heat resistance compared to standard PETG. PETG-HF combines ease of printing with enhanced durability, making it ideal for both functional and end-use parts.

Physical Properties	Typical Value	Test Method
Density	1.29 g/cm3	ASTM D792
Dia Tolerance	+/-0.03	
Weight	1000gm	
MFR	2-3 g/10min	ISO 1133

Mechanical Properties (Printed)	Typical Value	Test Method
Tensile Strength	54MPA	ISO-527
Elongation at Break	15%	ISO-527
Flexural Modulus	2145 N/mm2	ISO-527
Flexural Strength	73MPa	ISO-178
Impact Strength	5.6 KJ/M2	ISO-179

Thermal Properties		
Heat Deflection Temperature	80oC	ISO 306
Melting Temperature	200 oC +/-5	ISO 306

Print Settings		
1st Layer Temp	240-250	oC
Printing Temp	235-265	oC
Flow Ratio	0.95-0.96	%
Bed Temp	80-90	oC
Bed Surface	PEI Textured	
Cooling	0-50%	%
Speed	18-21	mm3/s

* Dry Filament before use - 60/ 6hrs

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