ePETG-CF

Technical Data Sheet

Adding carbon fiber reinforced materials to PETG and modifying, it strengthens the rigidity and toughness of PETG.

Material Status	Mass Production		
Characteristics	• High strength • Wear resistance • Impact resistance	• Chemical resistance	
Applications	• Aerospace	• Automotive	• Industrial applications
Form	• Filament		
Processing method	• 3D Print, FDM Print		

	testing method	Typical value	
Physical Properties			
Density	GB/T 1033	1.26	g/cm^3
Melt Flow Index	GB/T 3682	18.0	(220℃/10KG)
Mechanical Properties			
Tensile Strength(Z)	GB/T 1040	28	MPa
ElongationatBreak(Z)	GB/T 1040	3.6	%
Flexural Strength(X-Y)	GB/T 9341	80.8	MPa
Flexural Modulus(X-Y)	GB/T 9341	2500	MPa
IZOD Impact Strength(X-Y)	GB/T 1843	5.2	kJ/m^2
Thermal Properties			
Heat distortion Temperature	GB/T 1634	70℃	(0.45Mpa)
Continuous Service Temperature	IEC 60216	N/A	
Maximum (short term) Use Temperature		N/A	
Electrical Properties			
Insulation Resistance	DIN IEC 60167	N/A	
Surface Resistance	DIN IEC 60093	N/A	

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Recommended printing parameters

Extruder Temperature	240 - 260°C
Build Platform Temperature	75-90°C
Fan Speed	100%
Printing Speed	0-150mm/s

Based on Bambu P1S 0.4 mm nozzle and Orcaslicer2.1.0 Beta. Printing conditions may vary with different

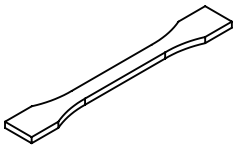
nozzle diameters Drying Recommendations

N/A

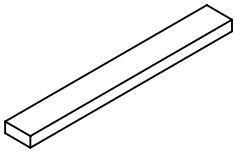
Precautions:

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.

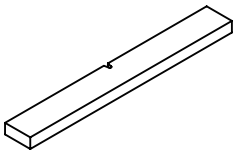
Mechanical Properties



Tensile testing specimen GB/T 1040



Flexural testing specimen GB/T 9341



Impact testing specimen GB/T 1043

The physical properties, mechanical properties, thermal properties, and electrical properties of the filament are obtained based on the injection molding spline test.

Print test condition:

Extruder Temperature	255℃
Build Platform Temperature	75℃
Outline/Perimeter Shells	2
Top/Bottom Layers	3
Infill Percentage	100%
Fan speed	40%
Maximum volumetric flow rate	4mm³/s

Based on Bambu P1S 0.4 mm nozzle and Orcaslicer2.1.0 Beta.

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