

MODIFIED PETG

PETG+ Filament

1.75 mm · 1 kg spool · ±0.03 mm tolerance

Modified PETG with refined flow and strong layer adhesion, giving tough, impact resistant parts with less stringing and warping than standard PETG.

- ✓ Tough and impact resistant
- ✓ HDT 68 °C, above PLA
- ✓ Low warping, no enclosure
- ✓ Low moisture uptake

Recommended Print Settings

Nozzle temperature	210–230 °C
Bed temperature	50–70 °C
Print speed	40–60 mm/s
Support material	PVA, PLA (as support interface)

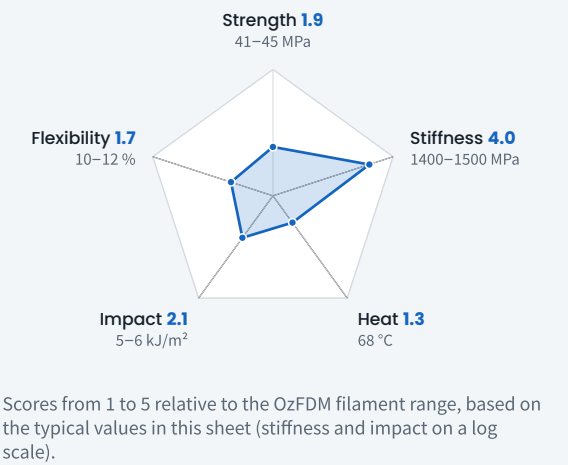
Filament Specifications

Material	Modified PETG (PETG+)
Diameter	1.75 mm
Diameter tolerance	±0.03 mm
Net filament weight	1 kg

Spool & Packaging

Empty spool weight	150 g
Spool with filament	1.15 kg
Spool outer diameter	200 mm
Hub diameter	52 mm
Spool width	65 mm
Shipping weight	1.3 kg
Box dimensions	210 × 220 × 75 mm

Property Profile



Storage & Handling

- Drying**
70 °C for 5 hours in a filament dryer or food dehydrator.
- Storage**
Airtight bag or container with desiccant in a cool, dark and dry area to prevent moisture absorption. For optimal long term storage we recommend drying the filament prior to sealing the filament spool in a vacuum bag with desiccant.

Mechanical Properties

PROPERTY	TEST METHOD	TYPICAL VALUE
Tensile strength	ISO 527	41–45 MPa
Elongation at break	ISO 527	10–12 %
Tensile modulus	ISO 527	1400–1500 MPa
Flexural strength	ISO 178	64–66 MPa
Impact strength	ISO 180	5–6 kJ/m ²

Physical Properties

PROPERTY	TEST METHOD	TYPICAL VALUE
Density	ISO 1183	1.27–1.28 g/cm ³
Melt flow rate (220 °C, 2.16 kg)	ISO 1133	8–12 g/10min
Moisture absorption (23 °C, 24 h)	ISO 62	<0.2 %

Thermal Properties

PROPERTY	TEST METHOD	TYPICAL VALUE
Heat deflection temperature (0.455 MPa)	ISO 75	68 °C
Continuous use temperature	IEC 60216	65 °C

Available Colours 16



Black



White



Natural



Grey



Silver



Gold



Red



Blue



Green



Yellow



Orange



Pink



Rose



Purple



Brown



Transparent

Swatches are indicative only. Colours vary between screens and with print settings.

NOTES
Values shown are typical results measured on test specimens and are provided for guidance only. They are not guaranteed specifications and should not be used as design limits. Printed part properties vary with printer, settings, print orientation and part geometry. Test your parts for suitability before use in critical applications.