TECHNICAL DATA SHEET

3D FILAMENT PETG FR-V0 HF
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PRODUCT NAME: 3D FILAMENT PETG FR V0 HF 1,75mm

PRODUCT DESCRIPTION: PETG FR V0 HF filament - poly(ethylene terephthalate) with addition of glycol and flame retardant additives – free from halogen, and red phosphorus. Product in the form of a thread, designed for 3D printing using the FFF/FDM method. Filament coiled on spools, vacuum-packed with desiccant in a PA/PE bag, and then in a box.

STORAGE: Store in dry area. Store in a closed container.

PRODUCT PARAMETERS

Parameter	Value	Unit
Filament diameter	1,75	mm
Diameter tolerance	±0,05	mm
Oval tolerance	±0,02	mm
Net weight	1000 ±20	g
Weight with packaging	1400 ± 30	g
Spool weight	215 ±5	g
Spool dimensions (external ø / height / hole ø)	200/70/52	mm
Box dimensions	220/210/74	mm

RECOMMENDED PRINTING PARAMETERS

Parameter	Value	Unit
Print temperaturę	230-260	°C
Bed temperaturę	60-70	°C
Cooling	0-60	%
Closed chamber	not necessary	-

PHYSICAL PARAMETERS OF THE MATERIAL

Parameter	Value	Unit	Test method
Density	1,26	g/cm^3	ISO 1183
Elastic modulus	2350	MPa	ISO 527-1 (1 mm/min)
Tensile strength at yield	40	MPa	ISO 527-1 (5 mm/min)
Tensile elongation at yield	3,3	%	ISO 527-1 (5 mm/min)
Charpy impact strength, unnotched	-	kJ/m^2	ISO 179-1eU
Charpy impact strength, notched	3	kJ/m^2	ISO 179-1eA
VICAT	70	°C	ISO 306

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HDT	63	°C	ISO 75; 0.45 MN/m²
HDT	58	°C	ISO 75; 1,81 MN/m²
Oxygen index	35	%	ASTM D 2863
Flammability rate	V0	-	UL 94
Flammability rate	V0	-	UL 94
Glow wire flammability index	-	-	IEC 60695-2-12; 960°C @ 1 mm
Glow wire flammability index	-	-	IEC 60695-2-12; 960°C @ 2 mm
Glow wire ignition test	-	-	IEC 60695-2-13; 775°C @ 1 mm
Glow wire ignition test	-	-	IEC 60695-2-13; 775°C @ 2 mm

The values above have been measured using standard test specimens made of non-colored material at room temperature. The figures should be considered as indicative values only. Actual properties of PETG FR V0 HF parts can be affected by the printing parameters, design of the model, ambient conditions, application of the printout etc. It is essential that users test our products to determine whether they are suitable for their intended use. ROSA PLAST Sp. z o.o. accepts no liability for any health detriment or material losses or any other losses related to the use of the material.

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