

BASIC INFORMATION

PRODUCT NAME: FILAMENT 3D PET-G MDT, x-Ray DT 1.75mm

PRODUCT DESCRIPTION: Filament PET-G MDT, x-Ray DT is a poly(ethylene terephthalate) glycol-enriched MDT additive in the form of a filament, designed for 3D printing by FFF/FDM. The supplied filament is wound on a cardboard coil (no spool), vacuum sealed in a moisture absorbing bag and packaged in a cardboard box. The product is designed for use with 3D printers using FDM technology. It should be used in a well-ventilated room to avoid exposure to emissions during printing. It is important to avoid direct contact with hot printer components, which can lead to burns. Filament should be stored in a dry place, in a closed container and away from children. It is recommended to use the filament within the recommended printing temperature range for optimal results. Dispose of waste filament in accordance with local regulations. The product has been designed with safety in mind and meets all relevant standards for consumer use.

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

PRODUCT PARAMETERS

PARAMETER	VALUE
Filament diameter [mm]	1.75
Diameter tolerance [mm]	+/-0,05
Oval tolerance [mm]	+/-0,02

RECOMMENDED PRINTING PARAMETERS

PARAMETER	VALUE
3D printing temperature [C]	240-260
Heated bed [C]	60-80
Cooling fan [%]	0-25
Closed chamber	recommended
Drying conditions [C/h]	60/4, pre-drying recommended before each print

* Recommended to pre-dry the filament before each print.

PHYSICAL PARAMETERS OF THE MATERIAL

PARAMETER	VALUE	UNIT	TEST METHOD
Gęstość /Density	1,40-1,43	g/cm ³	-
Moduł sprężystości/Tensile modulus	2200	MPa	PN-EN ISO 527-2:2012
Wytrzymałość na rozciąganie/Tensile strength	38,8	MPa	PN-EN ISO 527-2:2012
Wydłużenie przy zerwaniu/Elongation at break	9,7	%	PN-EN ISO 527-2:2012
Udarność metodą Charpy'ego - karb/Charpy impact strength - notched	3,15	kJ/m ²	PN-EN ISO 179-1:2023-11, 1eA
HDT A	68	C	PN-EN ISO 75-2:2023-06, 1,8 MPa
VICAT	69,2	C	PN-EN ISO 306:2023-05, B50

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 PET-G MDT, x-Ray DT 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. Additional documents, certificates and detailed technical information can be provided on special request.

