ePETG-Lite

Technical Data Sheet

PETG-Lite is an economical PETG product that combines the advantages of PLA and ABS. It has a wide range of colors and offers excellent printability, high toughness, and a good surface gloss. The dimensions are stable and do not shrink or warp during printing.

Material Status	Mass Production
Characteristics	• High cost performence • High toughness and high brightness • Excellent printing performance
Applications	• Lamps and lanterns • Cosmetic containers • Electronic appliances • Stationery
Form	• Filament
Processing method	• 3D Print, FDM Print

	testing method	Typical value	
Physical Properties			
Density	GB/T 1033	1.27	g/cm³
Melt Flow Index	GB/T 3682	22	(250℃/10KG)
Mechanical Properties			
Tensile Strength	GB/T 1040	52.7	MPa
Elongation at Break	GB/T 1040	16.8	%
Flexural Strength	GB/T 9341	77.4	MPa
Flexural Modulus	GB/T 9341	2148	MPa
IZOD Impact Strength	GB/T 1843	8.5	kJ/m²
Thermal Properties			
Heat distortion Temperature	GB/T 1634	73℃	(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 - 270°C
Build Platform Temperature	75-90°C
Fan Speed	50-100%
Printing Speed	40-200mm/s

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

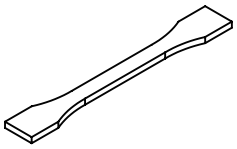
nozzle diameters Drying Recommendations

N/A

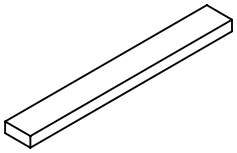
Precautions:

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.

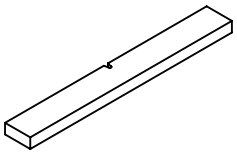
Mechanical Properties



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	270°C
Build Platform Temperature	90°C
Outline/Perimeter Shells	2
Top/Bottom Layers	3
Infill Percentage	100%
Fan speed	50%
Maximum volumetric flow rate	4mm³/s

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

Notice

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