

PETG+HS

Technical Data Sheet

PETG+HS is a new optimization of PETG formula, faster and better cooling, suitable for high-speed printing, optimize the problem of material sticking to the nozzle when printing, reduce the chance of bad printing, cost-effective waterproof, resistant, high toughness, fast printing material.

Material Status	Mass Production	
Characteristics	Great toughness	- Chemical resistance - Water resistance
Applications	- Advertisement - Waterproof application	- Snap-in parts - Flower pot
Form	Filament	
Processing method	3D Print, FDM Print	

	testing method	Typical value	
Physical Properties			
Density	GB/T 1033	1.26	g/cm³
Melt Flow Index	GB/T 3682	24	(190°C/2.16kg)
Mechanical Properties			
Tensile Strength	GB/T 1040	29.2	MPa
Elongation at Break	GB/T 1040	4.2	%
Flexural Strength	GB/T 9341	63	MPa
Flexural Modulus	GB/T 9341	1708.7	MPa
IZOD Impact Strength	GB/T 1843	5.6	kJ/m²
Thermal Properties			
Heat distortion Temperature	GB/T 1634	68	°C
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	

Wuhan University Building A403-I,A901,No.6 Yuexing 2 Road,Nanshan District,Shenzhen,Guangdong

China

Tel +86 755 86581960

fax +86 755 26031982

Email: bright@brightcn.net

www.esun3d.net

Recommended printing parameters

Extruder Temperature	220- 260°C
Build Platform Temperature	75-90°C
Fan Speed	100%
Printing Speed	40 - 300mm/s

Based on 0.4 mm nozzle and Simplify 3D v.4.1.2. Printing conditions may vary with different nozzle diameters

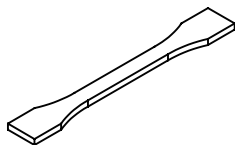
Drying Recommendations

N/A

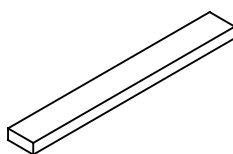
Precautions:

Turn on the Z seam alignment . Turn off the Z-axis lifting with drawing.
Slower the printing speed.

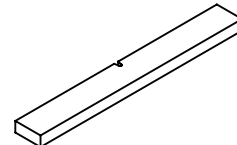
Mechanical Properties



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 line are obtained based on the injection molding spline test.

Print test condition:

Extruder Temperature	220-260°C
Build Platform Temperature	75°C
Outline/Perimeter Shells	4
Top/Bottom Layers	4
Infill Percentage	20%
Fan speed	100%
Printing speed	300mm/s

Based on 0.4 mm nozzle and Simplify 3D v.4.1.2.

Notice

All information supplied by or on behalf of eSUN in relation to this product, whether in the nature of data, recommendations or otherwise, is supported by research and, in good faith, believed reliable, but the product is sold "as is". eSUN assumes no liability and makes no representations or warranties, express or implied, of merchantability, fitness for a particular purpose, or of any other nature with respect to information or the product to which information refers and nothing herein waives any of the seller's conditions of sale.