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Plastics for Additive Manufacturing

E527425

Guide Information

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**Prusa Polymers a.s.**

Partyzanska 7a/188, Prague 7 170 00 CZ

**Prusament PETG V0**

Process Category: Material Extrusion

Polyethylene Terephthalate-glycol (PET-g), furnished as filaments

Color	Min. Thk (mm)	Flame Class	HWI	HAI	RTI Elec	RTI Imp	RTI Str
NC, BK	0.75	V-0	-	-	75	75	75
	3.0	V-0	-	-	75	75	75

- Comparative Tracking Index (CTI): -
- Dielectric Strength (kV/mm): -
- High-Voltage Arc Tracking Rate (HVTR): -
- Dimensional Change (%): -
- Inclined Plane Tracking (IPT) kV: -
- Volume Resistivity (10<sup>x</sup> ohm-cm): -
- Surface Resistivity (10<sup>x</sup> ohms/square): -
- High Volt, Low Current Arc Resis (D495): -

Processing Parameters:

- Build Plane: Horizontal & Vertical
- Layer Thickness (mm): 0.2
- Air Gap (mm): 0
- Post Processing Method: None
- Raster Angle (Degrees): 45/45
- Print Speed (mm/sec): 55-200
- Nozzle Diameter (mm): 0.4

For use with printer: Original Prusa i3 MK3S+, Original Prusa MK4, Original Prusa XL Printer Preset: Balanced or default

Limited properties and ratings assigned to samples produced by the Additive Manufacturing technique representing a specific set of printing parameters and build strategy. Other print parameters and build strategies may result in significantly different results.

IEC/ISO small-scale test data does not pertain to building materials, furnishings and related contents. IEC/ISO small-scale test data is intended solely for determining the flammability of plastic materials used in the components and parts of end-product devices and appliances, where the acceptability of the combination is determined by UL.

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IEC and ISO Test Methods				
Test Name	Test Method	Units	Thk (mm)	Value
Flammability	IEC 60695-11-10	Class (color)	0.75	V-0 (NC, BK)
			3.0	V-0 (NC, BK)
Glow-Wire Flammability (GWFI)	IEC 60695-2-12	°C	-	-
Glow-Wire Ignition (GWIT)	IEC 60695-2-13	°C	-	-
IEC Comparative Tracking Index	IEC 60112	Volts (Max)	-	-
IEC AC Dielectric Strength (AC DS)	IEC 60243-1	kV/mm	-	-
IEC DC Dielectric Strength (DC DS)	IEC 60243-2	kV/mm	0	0.2
IEC Volume Resistivity (VR)	IEC 62631-3-1	10 <sup>x</sup> ohm-m	-	-
IEC Surface Resistivity (SR)	IEC 62631-3-2	10 <sup>x</sup> ohms	-	-
IEC Inclined Plane Tracking (IPT)	IEC 60587	kV	45	55
IEC Ball Pressure	IEC 60695-10-2	°C	-	-
ISO Heat Deflection (1.80 MPa)	ISO 75-2	°C	-	-
ISO Tensile Strength	ISO 527-2	MPa	-	-
ISO Flexural Strength	ISO 178	MPa	-	-
ISO Tensile Impact	ISO 8256	kJ/m <sup>2</sup>	-	-
ISO Izod Impact	ISO 180	kJ/m <sup>2</sup>	-	-
ISO Charpy Impact	ISO 179-1	kJ/m <sup>2</sup>	-	-