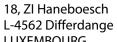
Values



E-mail: sales@airtech.lu Website: www.airtech.lu

Fiche Technique

KIMYA PETG-R 3D FILAMENT

Test Methods

Low-cost recycled filament for FFF 3D Printers

Phone: +352 58 22 82 1

Fax: + 352 58 49 35

DESCRIPTION

RTECH

Kimya PETG-R is a 3D printing filament made from recycled PETG, sourced from the industrial waste of a luxury and medical packaging manufacturer. Despite being recycled, PETG-R offers technical properties like those of Kimya PETG-S, including good mechanical strength and printability. It provides an environmentally responsible alternative for users seeking sustainable materials without compromising performance.

BENEFITS

- Eco-Friendly.
- · Great Mechanical Strength.
- · High rigidity.

Properties

TECHNICAL DATA

Diameter	$1.75 \pm 0.1 \text{ mm}$ $2.85 \pm 0.1 \text{ mm}$	INS-6712
Density	1.27 g/cm³	ISO 1183-1
Melt flow index (MFI)	8 g/10min	ISO 1133-1 (@225°C-2.16kg)
Glass transition temperature (Tg)	80°C (176°F)	ISO 11357-1 DSC (10°C/min-20-300°C)
Properties	Values	Test Methods
Tensile Modulus	1,845 MPa (267.6 ksi)	ISO 527-2/1A/50
Tensile Strength	47.1 MPa (6.8 ksi)	ISO 527-2/1A/50
Tensile Strain at Strength	3.8 %	ISO 527-2/1A/50
Tensile Stress at Break	37.2 MPa (5.4 ksi)	ISO 527-2/1A/50
Tensile Strain at Break (type A)	3.6 - 13 %	ISO 527-2/5A/50
Flexural Modulus	1,746 MPa (253.2 ksi)	ISO 178
Flexural Stress at Conventional Deflection (3.5% Strain)*	6.8 MPa (8.8 ksi)	ISO 178
Charpy Impact Resistance	6.1 kJ/m ² (2.9 ft-lbs/in ²)	ISO 179-1/1eA
Shore Hardness	75.5 D	ISO 868

PROCESSING

Printing Direction

Printing Speed Nozzle Temperature **Bed Temperature**

XY

Initial layers: 10-20 mm/s, further layers 30-60 mm/s 230°C - 260°C (446°F - 500°F)

75°C - 85°C (167°F - 185°F)

NOTES

- *According to ISO 178, end of the test at 5% deformation even if there is no specimen break.
- The data should be considered as indicative values Properties can be influenced by production conditions.

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