

Technical Data Sheet

PolyLite™ PETG

www.polymaker.com

V5.4



PolyLite™ PETG

PolyLite™ PETG is an affordable PETG filament with balanced mechanical properties and ease of printing.

PHYSICAL PROPERTIES

Property	Testing Method	Typical Value
Density	ISO1183, GB/T1033	1.25 g/cm ³ at 23°C
Melt index	240°C, 2.16kg	10.8 g/10min
Light transmission	GB/T 2410	90%
Flame retardancy	N/A	N/A

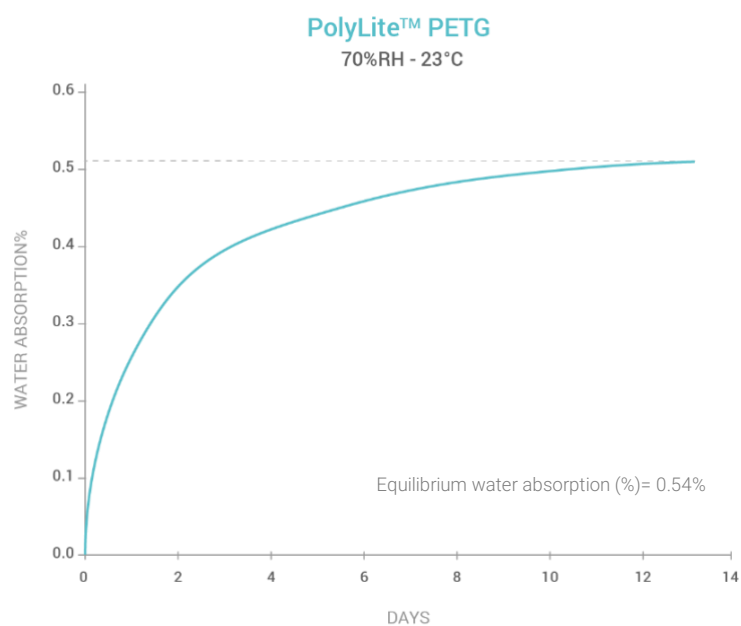
CHEMICAL RESISTANCE DATA

Property	Typical Value
Effect of weak acids	Good
Effect of strong acids	Poor
Effect of weak alkalis	Fair
Effect of strong alkalis	Poor
Effect of oils and grease	Good

Note:

- Good: Material may get minor attack after long periods of storage with chemical at ambient temperature
- Fair: Material can be used for short time contact with chemical at ambient temperature
- Poor: Material becomes unstable on contact with chemical at ambient temperature

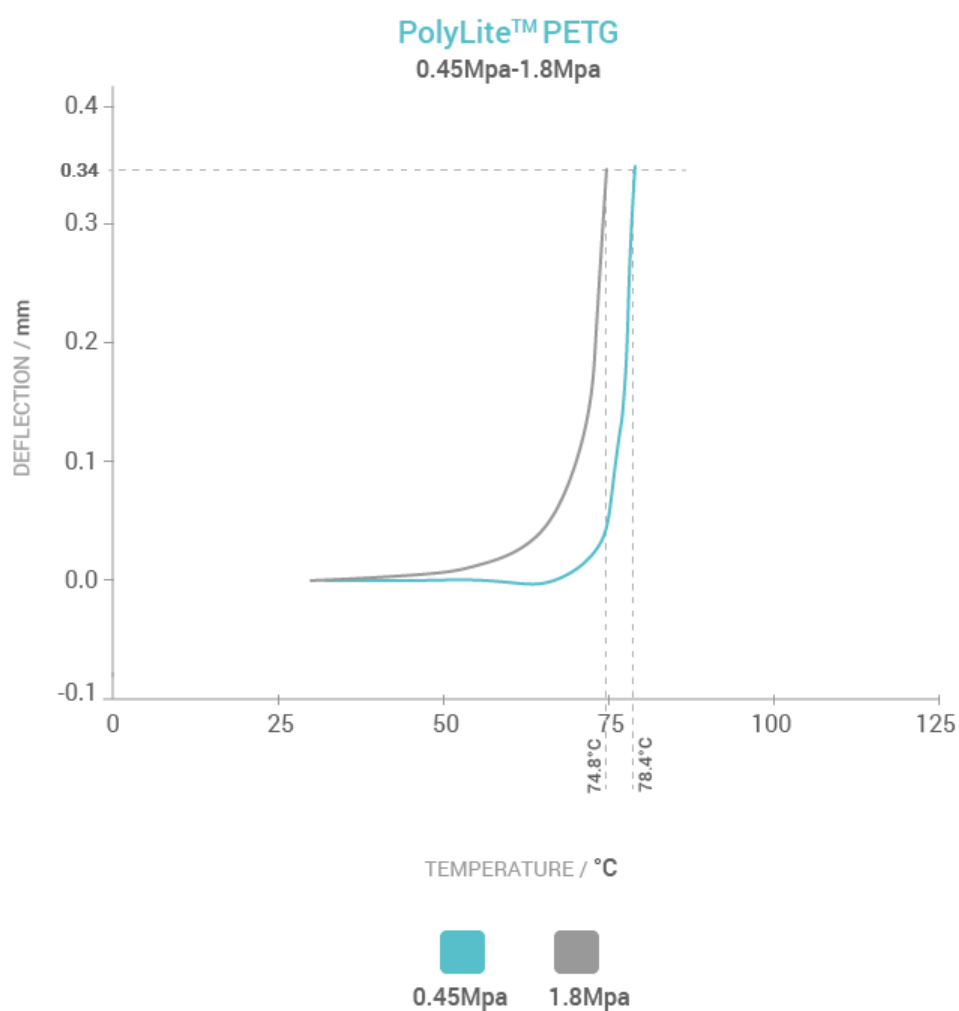
MOISTURE ABSORPTION CURVE



THERMAL PROPERTIES

Property	Testing Method	Typical Value
Glass transition temperature	DSC, 10°C/min	81 °C
Melting temperature	DSC, 10°C/min	N/A
Crystallization temperature	DSC, 10°C/min	N/A
Decomposition temperature	TGA, 20°C/min	N/A
Vicat softening temperature	ISO 306, GB/T 1633	84 °C
Heat deflection temperature	ISO 75 1.8MPa	75 °C
Heat deflection temperature	ISO 75 0.45MPa	78 °C

HDT CURVE



MECHANICAL PROPERTIES

Property	Testing Method	Typical Value
Young's modulus (X-Y)	ISO 527, GB/T 1040	2116.8 ± 68.1 MPa
Young's modulus (Z)		1898.7 ± 98.5 MPa
Tensile strength (X-Y)	ISO 527, GB/T 1040	50.8 ± 0.9 MPa
Tensile strength (Z)		42.8 ± 2.8 MPa
Elongation at break (X-Y)	ISO 527, GB/T 1040	8.4 ± 1.7 %
Elongation at break (Z)		3.3 ± 0.2 %
Bending modulus (X-Y)	ISO 178, GB/T 9341	1898.5 ± 35.5 MPa
Bending modulus (Z)		N/A
Bending strength (X-Y)	ISO 178, GB/T 9341	69.6 ± 0.8 MPa
Bending strength (Z)		N/A
Notched Charpy impact strength (X-Y)	ISO 179, GB/T 1043	2.6 ± 0.2 kJ/m ²
Notched Charpy impact strength (Z)		N/A

RECOMMENDED PRINTING CONDITIONS

Parameter	
Nozzle temperature	230 – 260 (°C)
Build surface treatment	PC and Texture PEI (Glue when needed)
Build plate temperature	70 – 80 (°C)
Cooling fan	OFF-20%
Printing speed	50 - 100 (mm/s)
Retraction distance	1 - 3 (mm)
Retraction speed	20 - 40 (mm/s)
Closure Chamber	No Needed
Recommended support material	PolyDissolve™ S1
Drying setting	65°C for 6h
Annealing setting	-

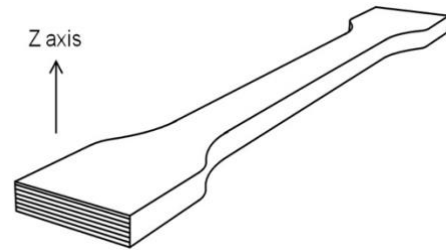
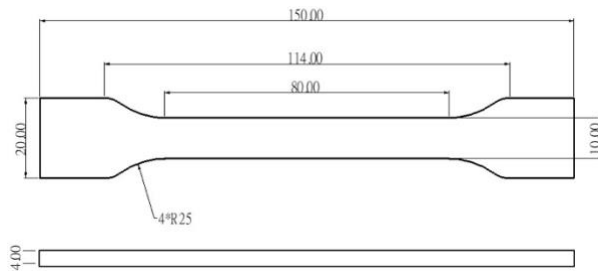
* Based on 0.4 mm nozzle. Printing conditions may vary with different nozzle diameters

Note:

- It is highly recommended to use the PolyBox™ when printing with PolyLite™ PETG and to store it in the resealable bag.

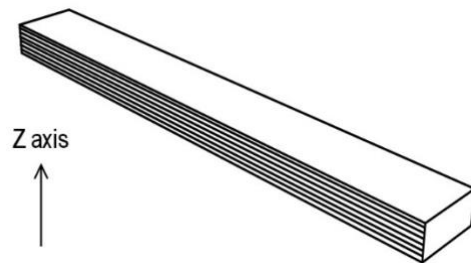
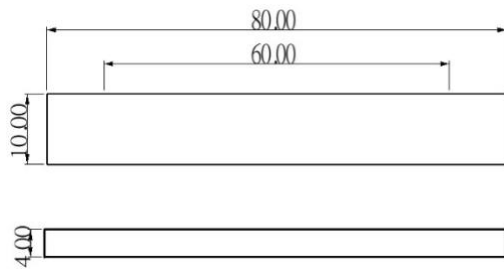
TENSILE TESTING SPECIMEN

ISO 527, GB/T 1040



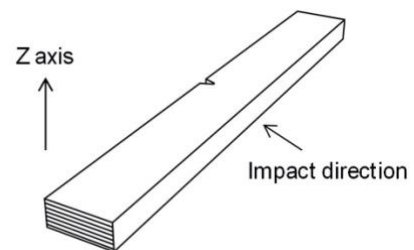
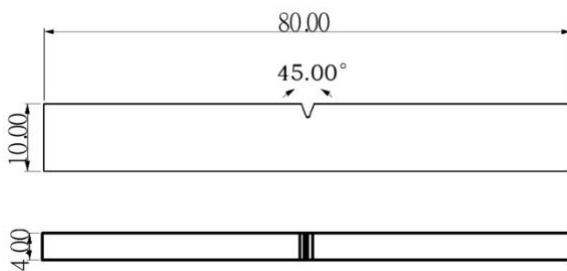
FLEXURAL TESTING SPECIMEN

ISO 178, GB/T 9341



IMPACT TESTING SPECIMEN

ISO 179, GB/T 1043



HOW TO MAKE SPECIMENS

Printing temperature	240 °C
Bed temperature	80 °C
Shell	2
Top & bottom layer	3
Infill	100 %
Environmental temperature	Ambient temperature
Cooling fan	OFF

DISCLAIMER:

The typical values presented in this data sheet are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary significantly with printing conditions. End- use performance of printed parts depends not only on materials, but also on part design, environmental conditions, printing conditions, etc. Product specifications are subject to change without notice.

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