



# Technical Data Sheet

Recycled Polyethylene Terephthalate Glycol (rPETG)  
3D Printing Filament

## General Information

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Recycled polyethylene terephthalate glycol (rPETG) filament is an environmentally conscious alternative to PETG, a common 3D printing material. This filament allows you to print components with excellent impact strength, like ABS, and high 3D printing speeds, similar to PLA. This filament will give your prints nearly zero warpage and strong layer bonds. These features come with the satisfaction of knowing that the filament is made with 100% recycled material, without compromising performance.

### Users

Beginner-Intermediate

### Available in Standard Colors

See website for available colors

### Features & Benefits

- 100% recycled material
- High printing speed
- Excellent impact strength
- High optical clarity
- Low odor
- High flexibility
- Unmatched layer adhesion

### Available Sizes

See website for details

## Quality

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At ABC3D, our filaments are manufactured using 5-Axis laser-controlled precision, ensuring the highest quality for the 3D printing industry. All filaments are vacuum sealed with desiccants for optimal moisture protection, ensuring top-quality prints.. Rest assured,our products are carefully crafted to deliver consistent excellence in every print.

**Tolerances** + 0.003" / -0.003"

### Storage

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Store between 17 to 28 °C in a dry area, away from sunlight. Keep sealed in an airtight container.

Physical Properties	Standard	Unit	Value
Density	ISO 1183	g/cm <sup>3</sup>	1.30
Mechanical Properties	Standard	Unit	Value
Tensile modulus	ISO 527	MPa	1510
Tensile elongation	ISO 527	%	16
Tensile strength	ISO 527	MPa	51.5
Zero-shear viscosity	ASTM D4440-15	Pa.s	4190
Thermal Properties	Standard	Unit	Value
Glass transition temperature (Tg)	DSC	°C	82
Shrinking	ASTM D6289-13	%	0.1
Electrical Properties	Standard	Unit	Value
Electrical resistivity	ASTM D257	Ω.cm	>10 <sup>6</sup>

Print Settings	Unit	Value
Nozzle temperature	°C	230-250
Heated bed temperature	°C	50-70
Print speed	mm/s	30-70
Extrusion width	mm	0.45
Volume flow rate	mm <sup>3</sup> /s	2-3

## Disclaimer

The technical data contained on this data sheet is furnished without charge or obligation and accepted at the recipient's sole risk. This data should not be used to establish specifications limits or used alone as the basis of design. The data provided is not intended to substitute any testing that may be required to determine fitness for any specific use.