

## HiTerra® PETG 2424 3DP

Techmer Polymer Modifiers - *Polyethylene Terephthalate Glycol Comonomer*

### Product Description

HiTerra® rPETG 2424 3DP is a specially formulated and compounded thermoplastic material designed for general purpose additive manufacturing applications. This product has been optimized for maximum printability in additive manufacturing.

### General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Recycled Content	• Yes
Uses	• Additive Manufacturing (3D Printing)

### Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.50		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	12500	psi	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	1.00E+6	psi	ASTM D790
Flexural Strength	15000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.0	ft·lb/in	ASTM D256

### Processing Information

Extrusion	Nominal Value	Unit
Drying Temperature	130	°F
Drying Time	1.0 to 5.0	hr
Cylinder Zone 1 Temp.	370 to 400	°F
Cylinder Zone 2 Temp.	380 to 420	°F
Cylinder Zone 3 Temp.	420 to 460	°F
Cylinder Zone 4 Temp.	420 to 480	°F
Melt Temperature	410 to 460	°F
Die Temperature	420 to 480	°F

### Extrusion Notes

If drying for longer than 5 hours, recommend reducing the temperature to 100°F in a dessiccant dryer to avoid degradation of the material.

