

HiFill® PETG 1704 3DP

 Techmer Polymer Modifiers - *Polyethylene Terephthalate Glycol Comonomer*
General Information
Product Description

HiFill® PETG 1704 3DP is an unreinforced, natural colored thermoplastic material designed for general purpose additive manufacturing applications requiring high transparency.

General

Material Status	• Commercial: Active
Availability	• North America
Uses	• Additive Manufacturing (3D Printing)

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.27		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	7000	psi	ASTM D638
Tensile Elongation (Break)	150	%	ASTM D638
Flexural Modulus	300000	psi	ASTM D790
Flexural Strength	10000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.8	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	156	°F	ASTM D648
Additional Information	Nominal Value	Unit	Test Method
Recommended Print Bed	Heated aluminum bed with cement glue, PC sheet, glass expoy laminate board, pellet coated bead board		
Recommended Print Bed Temperature	176 to 212	°F	

Processing Information

Extrusion	Nominal Value	Unit
Drying Temperature	130	°F
Drying Time	1.0 to 6.0	hr
Cylinder Zone 1 Temp.	340 to 370	°F
Cylinder Zone 2 Temp.	370 to 400	°F
Cylinder Zone 3 Temp.	370 to 400	°F
Cylinder Zone 4 Temp.	370 to 420	°F
Melt Temperature	370 to 420	°F
Die Temperature	360 to 420	°F

Extrusion Notes

If material is to remain in dryer for more than 6 hours in dried state, reduce dryer temperature to 100°F to prevent degradation of material.

