

HiFill® PET 2476 3DP

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

HiFill® PET 2476 3DP is a specially formulated, glass fiber filled, 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
Uses	• Additive Manufacturing (3D Printing)

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.90		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	20000	psi	ASTM D638
Tensile Elongation (Break)	1.5	%	ASTM D638
Flexural Modulus	3.00E+6	psi	ASTM D790
Flexural Strength	32000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.5	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	450	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	400	°F	ASTM D648
Additional Information	Nominal Value	Unit	Test Method
Recommended Print Bed	Aluminum bed with cement glue or Kapton tape, glass epoxy laminate board, or polyamide sheet		
Recommended Print Bed Temperature	194 to 230	°F	

Processing Information

Extrusion	Nominal Value	Unit
Drying Temperature	280	°F
Drying Time	2.0 to 4.0	hr
Cylinder Zone 1 Temp.	480 to 520	°F
Cylinder Zone 2 Temp.	490 to 530	°F
Cylinder Zone 3 Temp.	500 to 540	°F
Cylinder Zone 4 Temp.	500 to 540	°F
Melt Temperature	490 to 550	°F
Die Temperature	510 to 550	°F

Extrusion Notes

If drying for longer than 6 hours, recommend reducing the temperature to 140°F in a dessiccant dryer to avoid degradaton of the material.

