

# PCTG TDS

## AzureFilm PCTG (Copolyester) for FDM 3D Printers

### Product Description

AzureFilm PCTG (Copolyester) features excellent mechanical strength and higher impact resistance, as well as increased transparency. It is designed to withstand higher temperatures and exhibit enhanced durability compared to our PETG Original grade. The material is easy to print and can be used in open environments.

### Properties

Property of 3D printed specimens	Test method	Value
Material	<b>Copolyester</b>	Color Transparent
Specific Density	ASTM D-792	1,26 g/cm <sup>3</sup>
Tensile Yield Stress	ISO 527-2	44,9 MPa
Tensile Modulus	ISO 527-2	1930 MPa
Tensile Strain (Yield)	ISO 527-2	4,5 %
Tensile Strain (Break)	ISO 527-2	4,3 %
Nominal Tensile Strain at Break	ISO 527-2	320%
Flexural Modulus	ISO 178	1780 MPa
Flexural Strength	ISO 178	56,4 MPa

### Test specimens print settings

3D printer: Bambu Lab	Infill: 100 %	Nozzle temperature: 240 °C
Slicer: Bambu Studio	Shells: /	Bed temperature: 80 °C
Nozzle: 0,4 mm	Layer height: 0,2 mm	Print speed: 200 mm/s

### Printing Recommendations

Nozzle temperature: 230 – 250 °C

Heated bed: recommended 60-80 °C

Print speed: 50 – 200 mm/s

Build platform: Textured PEI late Recommended: 3D Lac spray