



Landu Filament

Technical Data Sheet V1.0

Hyper PETG

• Basic Info

Landu HyperPETG, PETG formula newly optimized for faster and superior cooling solidification, compatible with high-speed printing, material adhesion to nozzle during printing issues optimized, reducing the likelihood of poor printing, cost-effective waterproof, chemical resistant, high toughness, and fast printing material.

• Specifications

Subjects	Data
Diameter	1.75 mm
Net Filament Weight	1 kg
Filament Length	330m
Tolerance	±0.03mm

• Recommended Printing Settings

Subjects	Data
Nozzle temperature	230 – 260 (°C)
Build surface material	BuildTak®, Glass
Build surface treatment	Glue
Build plate temperature	65 - 75 (°C)
Cooling fan	0 - 60%
Printing speed	< 300 mm/s
Raft separation distance	0.14 (mm)
Retraction distance	1 (mm)
Retraction speed	20 mm/s
Environmental temperature	Room temperature
Threshold Overhang Angle	70 °

• Properties

Landu has tested the differing aspects in the performance of PETG material, including physical and chemical properties. Typical values are listed as followed:

Physical Properties		
Subjects	Testing Methods	Data
Density	ISO 1183,GB/T1033	1.28 g/cm ³
Melt Index	210 °C, 2.16 kg	28.2±2.7 g/10 min
Light transmission	GB/T 2410	90%
Flame retardancy	N/A	N / A

Mechanical Properties		
Subjects	Testing Methods	Data
Young's modulus (X-Y)	ISO 527, GB/T 1040	1810 ± 190 MPa
Young's modulus (Z)		1540 ± 130 MPa
Tensile strength (X-Y)	ISO 527, GB/T 1040	34 ± 4 MPa
Tensile strength (Z)		23 ± 4 MPa
Elongation at break (X-Y)	ISO 527, GB/T 1040	8.6 ± 1.2 %
Elongation at break (Z)		5.1 ± 0.8 %
Bending modulus (X-Y)	ISO 178, GB/T 9341	2050 ± 120 MPa
Bending modulus (Z)		1810 ± 140 MPa
Bending strength (X-Y)	ISO 178, GB/T 9341	64 ± 3 MPa
Bending strength (Z)		48 ± 4 MPa
Charpy impact strength (X-Y)	ISO 179, GB/T 1043	31.5± 2.2 kJ/m ²
Charpy impact strength (Z)		10.6± 1.2 kJ/m ²

• Specimen Test

Specimen Printing Conditions	
Subjects	Data
Nozzle Temperature	255 °C
Bed Temperature	70 °C
Infill Density	100%

• Disclaimer

The performance values are tested by standard samples at Landu, and the values are for design reference and comparison only. Actual 3D printing model performance is related to many other factors, including printers, printing conditions, printing models, printing parameters, etc.

In the process of using Landu 3D printing filaments, users are responsible for the legality, safety, and performance indicators of printing. Landu is not responsible for the use of materials and scenarios and is not responsible for any damage that occurs in the process of using our filaments.