



TECHNICAL DATA SHEET

XPETG CF

1. DESCRIPTION

XPETG CF has been developed for a wide range of applications where the main requirement is a good balance between mechanical and optical material properties. The raw material is certified according to REACH and RoHS standards. PETG is flame retardant according to UL 94 with a wall thickness of 3.2 mm.

2. FEATURES

- Carbon composite material for performance applications
- Excellent mechanical properties
- High chemical resistance
- Low warping
- Low shrinking

3. PROPERTIES

TEST	METHOD	UNIT	VALUE
Tensile modulus (E-Modulus)	ISO 527	MPa	3350 ± 50
Yield stress	ISO 527	MPa	59 ± 0,4
Elongation at yield	ISO 527	%	3,8 ± 0,1
Strength	ISO 527	MPa	59 ± 0,4
Elongation at break	ISO 527-2	%	9,4 ± 1,5
Notched impact strength	ISO 180	kJ/m ²	1,7 ± 0,4
Unnotched impact strength	ISO 180	kJ/m ²	67 ± 7
Heat Deflection Temperature HDT/B	ISO 75	°C	69
VICAT A (VST)	ISO 306	°C	85
Density	ISO 1183-1XA	g/cm ³	1,29
Flammability	UL 94	V-2	3,2 mm

*Temperature resistance tested at a minimum wall thickness of 4 mm.

PRINT SETTINGS	
Nozzle	220-250°C
Heatbed	60-90°C
Adhesive	not required
Speed	20-200mm/s
Cooling	20-50%
Enclosed Space	for larger components
Hardened Nozzle	yes
Max. Volumetric Speed	10 mm ³ /s

Note: Due to the abrasive nature of the carbon fibers, a hardened nozzle (e.g., hardened steel or ruby nozzle) is strongly recommended. Additionally, a nozzle diameter of at least 0.6 mm should be used to prevent clogging and ensure smooth extrusion.

4. CERTIFICATIONS & ADDITIONAL INFORMATION



Certifications depend on colors in final product. More info in the additional information sheet.

5. STORAGE AND SHELF LIFE

Store in a dry room at room temperature (18-27°C / 65-80°F). Keep out of direct heat and sunlight. When stored correctly, this material has a shelf life of 2 years. Additional info in our regulatory, additional information and chemical resistance data sheets.