



PETG+ Pro Series 3D Printer Filament 1.75mm

\$19.99

Color

Green

Quantity

- 1 +

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PRODUCT DETAILS

Improve your print quality with our Pro Series PETG+ filament. We only use quality materials to produce our filament to ensure your printed parts outperform your design requirements.

Filament Specs:

- **Hotend Temperature (°C):** 220-245 (*Recommended:* 220)
- **Bed Temperature (°C):** 75-85 (*Recommended:* 80)
- **Filament Diameter (mm):** 1.75±0.05
- **Net Weight:** 1kg (2.2 lbs)
- **Build Surface:** Polypropylene or PEI

Print Parameters:

We have spent thousands of hours testing our filament with several printer types and recommend these printing settings.

- **Default Print Speed:** 30-60 mm/s (*Recommended:* 40 mm/s)
- **First Layer Height:** 0.28 mm*
- **First Layer Speed:** 15 mm/s
- **Extrusion Width:** 0.48 for 0.4 Nozzle (1.2X Nozzle Diameter)
- **Retraction:** Bowden 5mm @ 45 mm/s or Direct 2mm @ 45 mm/s

* Set to 0.28 mm if you are getting adhesion issues.

- **Perimeter Print Speed:** 70% of Default Print Speed
- **Infill and Support Print Speed:** 80% of Default Print Speed
- **Fan Profile:**
- **Layer 1:** 0%
- **Layer 3:** 25%
- **Layer 5+:** 50%
- **XY Jerk:** 8
- **Z Jerk:** 0.3
- **E Jerk:** 5
- **Acceleration (Print/Travel):** 300
- **Retract Acceleration:** 1000
- **Travel Speed (non-print moves):** 120 mm/s

***Special Notes:**

Most users who are used to printing PLA tend to set their first layer height too low. PETG tends to build-up on the nozzle during the first layer causing adhesion issues. We recommend a first-layer thickness of 0.28mm.



PLA+ Pro Series 3D Printer Filament 1.75mm

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Carbon Fiber PETG Pro Series 3D Printer Filament 1.75mm

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\$24.99

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Mailing Address:

275 Medical Drive #3552

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