



## Technical Data Sheet

**BPET (i3D-FFF)**

Revision date: 29/06/2016

### Technical Specifications

Glass transition temperature	75-90°C
Melting temperature	240-255°C
Diameter	1.75 ± 0.03 mm / 2.85 ± 0.03 mm
Roundness deviation (max)	0.06 mm
Density	1.36 kg/dm <sup>3</sup>
Tensile strength	80 MPa (ISO 527)
E-modulus	3200 MPa (ISO 527)

### Printing Guidelines

B-PET has similar or even better print performance as PLA, provided the nozzle temperature settings are slightly higher than those for PLA.

Nozzle temperature	230-250°C
Heated bed temperature	*65°C +/- 10°C on glass or room temp. w/ Kapton tape
Printing speeds	**25-50mm/s
Bed material	Kapton or glass

\*Warning: do not exceed 100°C as B-PET will loose adhesion.

\*\*Use the above values as a starting point, optimal values for your specific printer may vary from the values shown above, depending on e.g. firmware, nozzle diameter, printer build, etc.

### Other Specifications

Shipping weight (kg)	1.25
Net weight (kg)	1
Material	Post Consumer Recycled PET
Brand	BPET
Transparency	Highly Transparent