

PET

POLYETHYLENE TEREPHTHALATE - MAKERGEEK



Pre and Post Processing

Does not stick well to blue tape, however a heated glass plate is very effective.

Be aware of the danger of breaking standard PET.



HAZARDS (rating 1-10)

Not FDA approved for food safety, however PET has no measurable fumes, although it is still suggested to have a ventilated area.

<p>SETTINGS TO PRINT WITH</p> <ul style="list-style-type: none"> • Temp Range: 200-250 (ideal for Hyrel 210°C) • Recommended flow multiplier: 1.15 • Recommended layer size: .2 • Build Plate Temp: 70 • Recommended Fan: 80% 	<p>PRIME/UNPRIME:</p> <table border="0"> <tr> <td>Steps: 100</td> <td>Steps: 100</td> </tr> <tr> <td>Rate: 10,000</td> <td>Rate: 10,000</td> </tr> <tr> <td>Time (ms): 25</td> <td>Time (ms): 20</td> </tr> <tr> <td>Primes after Tool Change: 1</td> <td>Primes after Tool Change: 1</td> </tr> </table>	Steps: 100	Steps: 100	Rate: 10,000	Rate: 10,000	Time (ms): 25	Time (ms): 20	Primes after Tool Change: 1	Primes after Tool Change: 1
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<p>HOW WELL IT HANDLES PRINTS</p> <p>Overhangs: 35° Retraction: 5 Circles: 4 Layer change: 4 Fine detail: 5 Curling: 4</p>	<p>PROPERTIES OF MATERIAL</p> <p>Modulus of Elasticity: Yield Strength: Fracture Point: Modulus of Elasticity in Bending: <i>All parts done with a ___% infill</i></p>								



CHEMICAL/RESISTANCE

Chemical	Water	Vinegar	HCl	Acetone	HF	Sulfuric Acid
Resistance (High/Limited/None)						
Chemical	Aqua Regia	Bleach	Gasoline	Methyl Alcohol	Ethyl Alcohol	NaOH
Resistance (High/Limited/None)						



Images (Left to right, top to bottom): Single walled vase, Artifact/Feature size test, Retraction/Feature size test.

Overhang: Minimum angle to the horizontal at which layers are relatively unperturbed.

Print handling parameters: 5-optimal, 4-very good, 3-fair, 2-passable, 1-very poor

Chemical Resistance: High-no observable affect after a long period of time, Limited-Slight affects over time (swelling, discoloration, slight softening, etc), None-very severely affected by chemical.



NOTES:

None