

# Technical Data Sheet

## Ice9™ PETG

Thermally conductive, electrically non-insulating plastic

Filament product code: TC-PA-175-1000

Pellet product code: TC-PA-000-1000

*Properties based on 3D printed samples*



GENERAL PROPERTIES	VALUE	
Base Material	Polyethylene terephthalate glycol	
Color	Dark gray	
Filament diameter	1.75 ± 0.1 mm	
TEMPERATURE SETTINGS	VALUE	UNITS
Extruder temperature	255-290	°C
Bed temperature	70-90	°C
Chamber temperature	40-55	°C
Cooling fan	Bridging only, 60	%
SLICING SETTINGS	VALUE	UNITS
Print speed	60-150	mm/s
Layer height	0.2-0.7	mm
Retraction distance	5	mm
Extra restart distance	0.5	mm
Infill for best thermal performance	95-100	%
ADDITIONAL GUIDELINES		
Nozzle diameter	0.4-1.0 mm	
Extruder type	Direct drive or Bowden	
Print bed preparation	PEI or glue stick on glass	
Storage instructions	Sealed bag	
Drying instructions	4 hour @ 70°C	

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