

# Fillamentum PETG

(polyethylene terephthalate glycol)

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**Printing temperature:** 235 - 255 °C

**Heated bed temperature:** 65 - 75 °C

**Speed:** 40 - 60 mm/s

**Part cooling fan:** 0 - 30 %

**Heated bed surface:** PEI, mirror / glass

**Adhesive:** Magigoo, 3DLac, PVA glue

**Raft / skirt / brim:** Skirt / Brim 5 mm

**Heated chamber / enclosure:** not needed

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### Cooling

- It is not recommended to use more than 30 % of fan speed, as fast cooling could lead to improper layer bonding. We recommend using no cooling for standard objects, which leads to stronger parts. For bridges and big overhangs, it is possible to go up to 50 % for the desired layer.

### Storing

- Airtight bag with desiccant.

In the case of moist material, re-dry it in an appropriate device. The conditions to achieve an optimal level of moisture are 65 °C for 4 hours. Processing of moist filament may cause degradation of polymer chains, brittleness, poor layer adhesion, stringing, oozing, etc.