

Product technical instructions

Product brand: Piocreat_PETG

Material No.: D3305050010

Ingredients description section

Specification level: extrusion

Appearance color: transparent particles

Product usage: suitable for sheet blister packaging with thickness less than 1mm, used for packaging of hygiene, electronic appliances, etc.

Processing conditions

Zone 1(°C)	Zone 2 (°C)	Die head(°C)	Screw pressure (Kg)	Extrusion pressure (Kg)
230	245	250	90	110
Remark	The above are the reference temperature conditions for screw extrusion processing. Drying is required when the equipment does not have vacuum exhaust. The drying temperature is 70-80°C and the drying time is not less than 3 hours.			

Performance test

Project	Test standards	PETG
Physical properties		
Density(g/cm ³)	ISO 1183	1.27
Melt index (220°C/2.16Kg)	ISO 1133	6.8
Water absorption rate (%)23°C	ASTM D570	0.35
Mechanical properties		
Bending strength(MPa)	ISO 178	70
Flexural modulus (MPa)	ISO 178	1961
GB notched impact strength 23°C (KJ/m ²)	ISO 180	6.0
ASTM notched impact strength 23°C (KJ/m ²)	ASTM D256	9.02
Tensile strength(MPa)	ISO 527	50
Elongation at break(%)	ISO 527	71
Rockwell hardness(R)	ASTM D785	113

Performance test

Project	Test standards	PETG
Optical properties		
Transmittance(%)	ASTM D1003	90.7
Thermal properties		
Heat distortion temperature (°C)	ASTM D648	75
Vicat softening temperature (°C)	ASTM D1525	78

Passed testing and certification

REACH	181 substances of high concern	pass
ROHS2.0	ROHS10 items	pass
GB4806.6	China food contact testing	pass

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