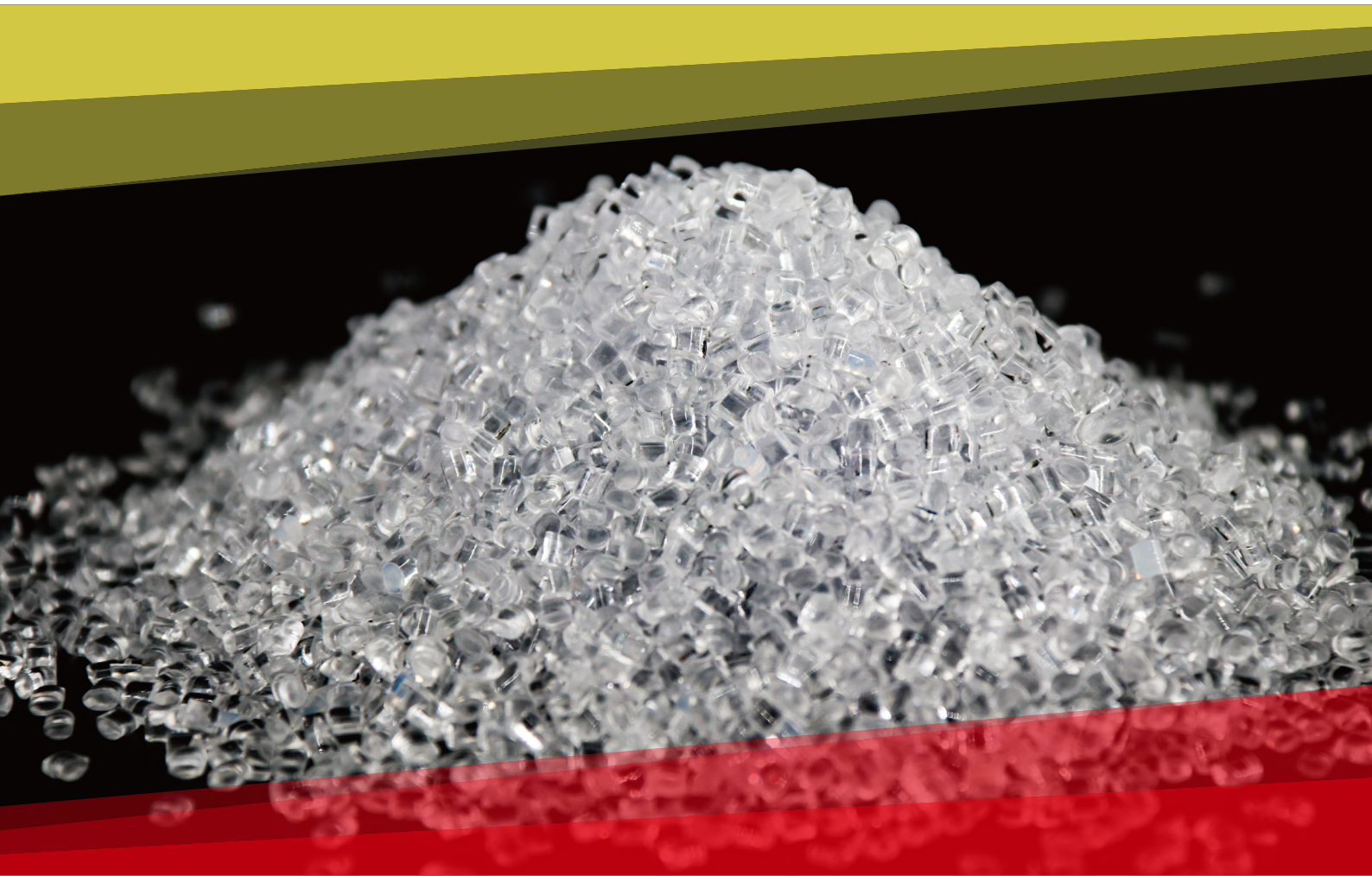


TECHNICAL DATA



P460-PETG

Polymer Composite Material



■ Material Overview

P460 is a transparent, non-crystalline copolyester featuring excellent toughness, high impact strength, superior transparency, and gloss. It is easy to print and offers environmental advantages. Typical applications include furniture manufacturing, decorative items, and various prototypes.

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Kings
3D Printing

Physical Properties

Property	Test Method	Value
Density (g/cm ³ , 21.5 °C)	ASTM D792	1.28
Rockwell Hardness (R-scale)	ASTM D785	112
Water Absorption (%)	ASTM D570	0.17
Melt Flow Index (275°C/5kg)	ISO 1133	g/10min

Mechanical Properties

Property	Test Method	Value
Tensile strength at break (MPa)	ASTM D638	24.2
Bending strength(MPa)	ASTM D790	72.7
Flexural modulus (MPa)	ASTM D790	2160
Izod notched impact strength(J/m)	ASTM D256	83
Yield elongation (%)	ASTM D638	4.2

Thermal Properties

Property	Test Method	Value
Heat Deflection Temperature (°C)	ASTM D648	73.5
Vicat softening temperature	ASTM D1525	81.4
Flame retardant performance (1.6mm)	UL94	Class
Flame retardant performance (3.0mm)	UL94	Class

Recommended Printing Conditions

Parameter	Recommended Settings
Drying temperature (° C)	100
Drying time (hours)	4
Maximum moisture content (%)	0.1
Barrel 1 temperature (°C)	140
Barrel 2 temperature (°C)	170
Barrel 3 temperature (°C)	210
Nozzle temperature (° C)	80-90
Platform temperature (° C)	100- 120