PETG Data Sheet

Physical Properties

PROPERTIES	ASTM METHOD	UNIT	VALUE
General			
Specific Gravity	D-792	g/cm³	1.17
Water Absorption	D-570	% @ 24 hrs	0.2
Light Transmission	D-1003	%	86
Dielectric Strength	D-149	Volts/Mil	410
Mechanical			
Notched Izod Impact	D-256	J/m	88
Tensile Strength	D-638	MPa	53
Flexural Strength	D.790	MPa	77
Hardness Rockwell	D-785	M or R	R115
Thermal			
Cont. Working Temp.		°C	62°
Vacforming Temp.		°C	125-150°
Thermal Expansion	D-696	10^-5/°C	6.8

Fabrication

Sawing, Cutting, Drilling & Guillotining: A circular saw blade with carbide teeth utilising the triple chip tooth design is preferred. Typical laser cutting and router methods are also very successful. For drilling, use conventional drill bits with the standard drill angles and a negative rake. Other suitable methods for cutting PETG sheet include: shearing, blanking and punching. Shears produce straight-edged cuts, while blanking dies and punches can produce a wide variety of shapes. Appropriate clearance angles are required.
Forming: PETG can be thermoformed using typical strip heating and vacuum forming equipment. Manual or brake press cold bending also is possible up to a thickness of 2mm.
Decorating: All PETG grades can be screen printed using inks specifically formulated for PETG . Vinyl graphics can also be applied using typical application methods. Edge finishing can be accomplished by sanding, flame polishing, or buffing.
Cementing: PETG can be bonded using Weldon 7.

N.B. For sheet sizes, gauges and colours, refer to your price list, or contact your nearest Mulford Plastics Branch.

The information detailed in this Data Sheet, is provided in good faith and should only be used as a general guide. For further information on various processes and technical properties, contact your local Mulford Plastics branch.