Version 1.0
04/2024

EP082206NC001-TDS

COCOON PETG-Birch(GF)

It is an enhanced PETG material with great fluidity and is easy to print and mold. Additionally, it exhibits low odor and excellent chemical resistance. The parts printed with this material are tough and durable, with good dimensional stability, presenting a matte and delicate frosted texture, which is suitable for printing structural parts or outdoor models with high anti-drop and impact resistance requirements.

Part 1 Injection-Molded Specimen Performance

Testing Items	Testing Conditions	Testing Methods	Units	Typical Values
Physical Properties				
Density	23°C	GB/T 1033	g/cm3	1.33
Melt Flow Rate	250°C, 5kg	GB/T 3682	g/10min	10
Mechanical Properties				
Tensile Strength	5mm/min	GB/T 1040.2	MPa	65
Elongation @ Break	5mm/min	GB/T 1040.2	%	10
Flexural Strength	2mm/min	GB/T 9341	MPa	90
Flexural Modulus	2mm/min	GB/T 9341	MPa	2800
Izod Impact Strength	2.75J	GB/T 1843	kJ/m2	8

Note: The typical physical properties are not intended for use as sales specifications.

Part 2 Printed Specimen Performance

Testing Items	Testing Conditions	Testing Methods	Units	Typical Values
Mechanical Properties				
Tensile Strength(X-Y)	50mm/min	GB/T 1040.2	MPa	61
Tensile Strength(Z)	50mm/min	GB/T 1040.2	MPa	19
Flexural Strength	2mm/min	GB/T 9341	MPa	84
Impact Strength, Notched	2.75J	GB/T 1843	kJ/m2	6

Note: All specimens are printed under the following conditions: nozzle temperature = 250°C, printing speed = 100 mm/s, build plate

temperature=65°C infill = 100%, nozzle diameter = 0.4mm.

Printing Path Direction of Specimen (Z)

Printing Path Direction of Specimen (X-Y)

Part 3 Printing Guidelines

Parameters	Settings
Nozzle Temperature	250°C
Build Plate Temp.	60-70°C
Build Plate Material	Glass、PEI、Steel Spring Build Plate
Bottom Layer Printing Temp.	/
Enclosed-chamber Printing	/
Print Speed	60-150mm/s
Drying recommendations	60-70°C in a hot air dryer for 4-8hours