

IC3D Standard PETG Clear

MaterialID MAT0053

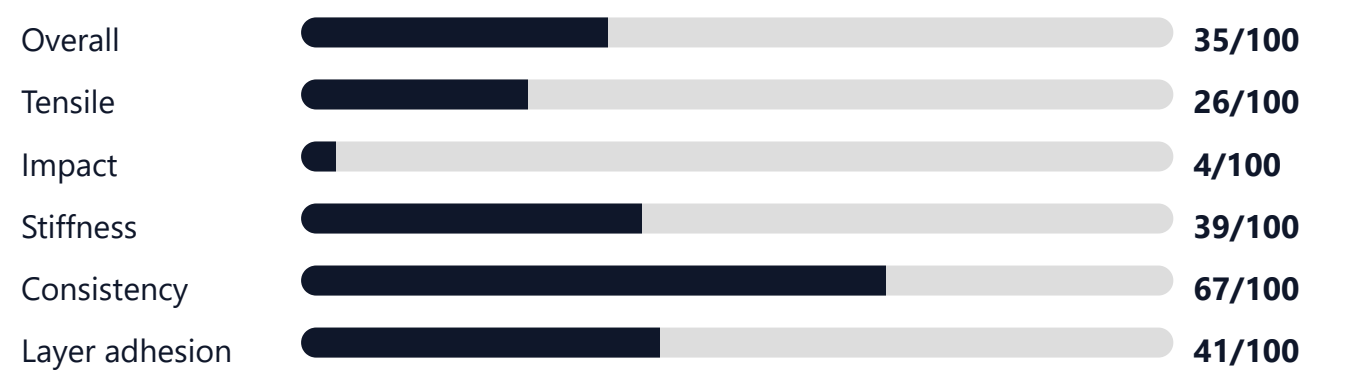


3DPiceland Labs
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WORKFLOW-RELIABILITY - Bug Fixes and Workflow
Reliability
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Guidance boundary: values below are shared base-material guidance resolved only through the canonical BaseMaterialId link. They are not manufacturer-, spool- or printer-specific validated settings. Missing fields remain Not recorded.

Overall 35/100	Engineering axes 5/5	Public rank 228 / 234	MSRP USD/kg 39.00
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Engineering profile



Recommended applications

- Cosmetic parts, concept models or low-load prototypes
- Avoid high tensile load applications
- Avoid high impact components

Measured strengths

- Layer adhesion: 41/100. Z-axis bonding is better than the material-family context.

Limitations

Engineering trade-offs

- Tensile: 26/100. Avoid using this as the primary choice for tensile-loaded parts.
 - Impact: 4/100. Avoid high impact or shock-loaded components without additional validation.
 - Stiffness: 39/100. Expect less shape stability than the stronger materials in the same family.
- Good repeatability does not compensate for low tensile capability in load-bearing designs.
 - The report should be read as a suitability warning rather than a general-purpose recommendation.

Base-material printing guidance

Guidance	Minimum	Recommended	Maximum	Unit
Nozzle temperature	230	250	260	°C
Bed temperature	75	85	85	°C
Print speed	55	130	130	mm/s
Cooling	30	60	75	%

Guidance	Value	Unit
Cooling guidance	Moderate	
Drying temperature	65	°C
Drying time	6	hours
Enclosure	Not required	
Printer / G-code reference	PrusaCoreOneL	
Slicer profile reference	Prusament PETG	

Print workflow checks

- Confirm nozzle temperature, bed temperature, speed, cooling and drying requirements from the manufacturer profile or spool label.
- Print a small validation part before committing to a long, costly or safety-relevant print.
- Orient the part so the governing load does not rely on an unverified or weak engineering axis.

Decision guidance

- Use this material mainly for low-load, visual or experimental parts.
- Review the listed alternatives if the application needs stronger overall performance.
- Do not choose it as a tensile-strength benchmark material.

- Avoid selecting it for impact-focused testing or shock-loaded designs.

Stronger same-family alternatives

MaterialID	Material	Manufacturer	Overall	Tensile	Impact
MAT0236	Yasin Standard Black PETG CF Black	Yasin	50/100	30/100	20/100
MAT0198	Siraya Tech Fiberheart Black PETG Pro CF Black	Siraya Tech	49/100	33/100	19/100
MAT0060	ColorFabb XT PETG Pink	ColorFabb	48/100	—	—

Confirm exact settings against the manufacturer profile, spool label and actual printer/material combination. Results do not replace application-specific validation.

[Testing methodology](#) · [Download PDF](#)

reports/printing-recommendations/MAT0053/