

Public printing recommendation

Winkle Standard Ash Gray PETG Gray

MaterialID MAT0165



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
46/100

Engineering axes
6/5

Public rank
127 / 234

MSRP USD/kg
79.83

Engineering profile



Recommended applications

- Repeatable print jobs and production-style batches
- Cosmetic parts, concept models or low-load prototypes
- Avoid high tensile load applications
- Avoid high impact components

Measured strengths

- Layer adhesion: 47/100. Z-axis bonding is better than the material-family context.
- Consistency: 81/100. Repeatability is one of the stronger signals in this material profile.

Limitations

- Tensile: 30/100. Avoid using this as the primary choice for tensile-loaded parts.
- Impact: 14/100. Avoid high impact or shock-loaded components without additional validation.

Engineering trade-offs

- 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

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

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