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SUNLU PETG Filament 1.75mm 10kg

SUNLU PETG Filament 1.75mm 10KG Bundle Instruction Manual

BRAND: SUNLU | MODEL: PETG FILAMENT 1.75MM 10KG

1. Introduction to SUNLU PETG Filament

SUNLU PETG (Polyethylene Terephthalate Glycol) filament combines the best characteristics of both PLA and ABS 3D printer filaments. It offers the ease of use found in PLA, alongside the durable strength and impact resistance typically associated with ABS. This makes it a versatile material suitable for a wide range of 3D printing applications.

Your browser does not support the video tag.

Video: Overview of SUNLU PETG Filament properties and applications.

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Video: Demonstrating the quality and versatility of SUNLU PETG filament.

PETG Filament: Best of ABS and PLA Combined



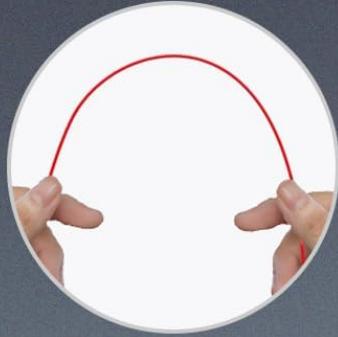
Image: PETG filament combines the advantages of both ABS (durable strength, high toughness, heat resistance) and PLA

(easy to use, good stability, high precision).

2. Product Features

- **PETG Filament Advantages:** Combines the benefits of PLA (easy to use) and ABS (durable strength).
- **1.75mm Filament Diameter:** Dimensional accuracy of +/- 0.02mm ensures wide compatibility with most 1.75mm FDM 3D printers.
- **SUNLU Neat Spool Design:** Spool Diameter: 8.00", Spool Width: 2.50", Spool Hub Hole Diameter: 2.20". Designed to fit many FDM 3D printers.
- **Individually Vacuum-Sealed:** Each 1kg spool is individually vacuum-sealed with desiccant to prevent moisture absorption and ensure optimal print quality.

Strong and High Toughness



Great Bending Strength



High Durability



Good Toughness



Image: Demonstrating the strong bending strength, high durability, and good toughness of SUNLU PETG filament.

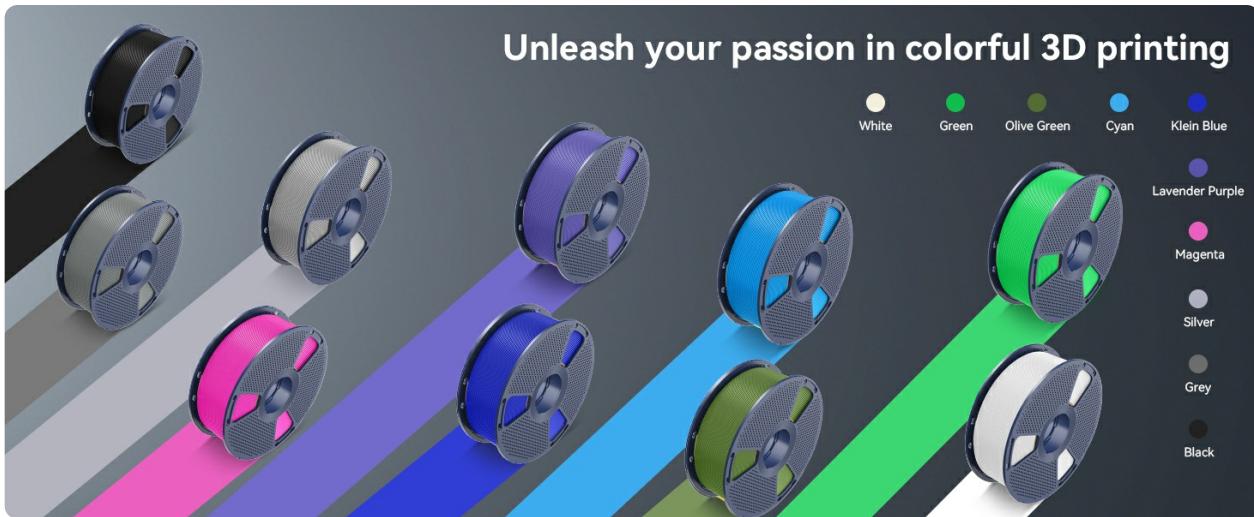


Image: Visual comparison showing SUNLU PETG filament results in less stringing for smoother prints compared to other brands.

3. Setup: Assembling the Refill Spool

The SUNLU PETG filament comes as a refill, designed to be used with a reusable spool. Follow these steps to properly assemble your filament onto the spool:

- 1. Separate the Spool Sides:** Gently pull apart the two halves of the reusable spool.
- 2. Prepare the Refill:** Unpack the new filament refill. **Do NOT remove the plastic straps** holding the filament together at this stage.
- 3. Load Refill Filament:** Place one side of the spool onto the refill filament. Ensure the positioning hole on the refill aligns with the notch on the spool hub.
- 4. Combine Spool Halves:** Align the triangular marks on both sides of the spool and press them together firmly. Rotate one side clockwise until it clicks and locks into place.
- 5. Remove Plastic Straps:** Once the spool is securely assembled, carefully remove the plastic straps from the filament.
- 6. Ensure Tightness:** Press the filament hard to ensure it is close to the spool, leaving no gap between the filament and the spool.

Your browser does not support the video tag.

Video: Step-by-step guide on how to assemble the SUNLU refill filament onto the reusable spool.

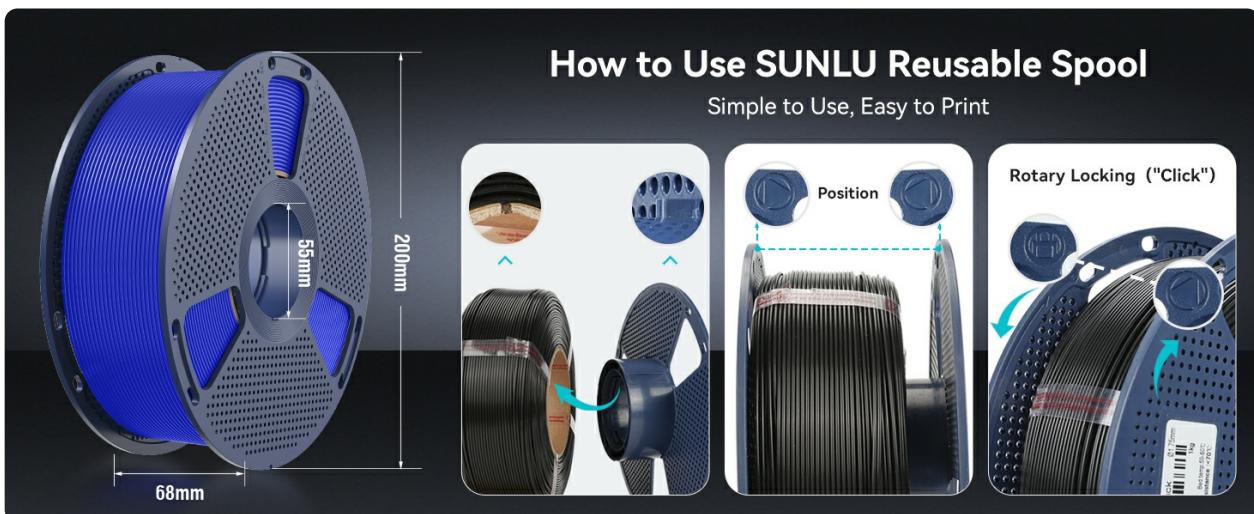


Image: Visual instructions for reel conversion and packaging sizes, illustrating how to load the refill filament.

4. Operating Instructions: Recommended Print Settings

For optimal results with SUNLU PETG filament, we recommend the following print settings. These are general guidelines and may require slight adjustments based on your specific 3D printer model and environmental conditions.

- **Nozzle Temperature:** 240-260°C
- **Bed Temperature:** 65-75°C
- **Printing Speed:** 50-200mm/s



Image: Recommended print settings for PETG filament, including nozzle temperature, heated bed temperature, and printing speed.

5. Maintenance

Proper maintenance of your filament ensures consistent print quality and extends its lifespan:

- **Storage:** Always store unused filament in its original vacuum-sealed packaging or in an airtight container with desiccant. This prevents moisture absorption, which can lead to printing issues like stringing and bubbling.
- **Drying:** If you suspect your filament has absorbed moisture (e.g., it produces popping sounds during printing, excessive stringing, or poor layer adhesion), consider drying it using a filament dryer or a low-temperature oven according to PETG drying guidelines.



Image: Demonstrating flawless printing with SUNLU PETG due to low moisture content, preventing bubbles and clogs.

6. Troubleshooting

Encountering issues during printing is common. Here are some tips for common problems with PETG filament:

- **Excessive Stringing:** PETG can be prone to stringing. Try reducing your print temperature in 5°C increments, increasing retraction distance, or increasing retraction speed. Ensure your filament is dry.
- **Poor Layer Adhesion:** If layers are not bonding well, increase your print temperature slightly (5°C increments) or slow down your print speed. Ensure your bed temperature is within the recommended range and that your print surface is clean and properly prepared.
- **Warping:** Ensure your heated bed is at the recommended temperature and consider using an enclosure for your printer to maintain a stable ambient temperature.

Excellent Layer Adhesion

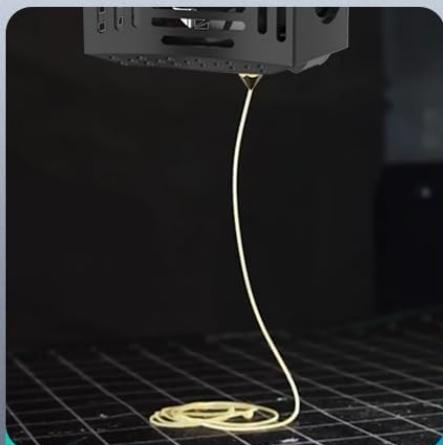
Tight bonding between each layer



1 Strong layer Bonding



3 Get a Perfect Print



2 Print More Smoothly

Image: Illustrates excellent layer adhesion, showing tight bonding between layers for a perfect print.

7. Applications

SUNLU PETG filament is suitable for a variety of applications due to its strength, durability, and ease of printing:

- **Architectural Models:** For detailed and sturdy building prototypes.
- **Toys:** Durable and safe for creating various toy designs.
- **Jewelry:** For intricate and resilient wearable art pieces.
- **Tools:** Functional parts that require mechanical strength and resistance.

- **Decorations:** For aesthetic and long-lasting decorative items.

3D Printer Filament PETG

Different applications to meet different needs

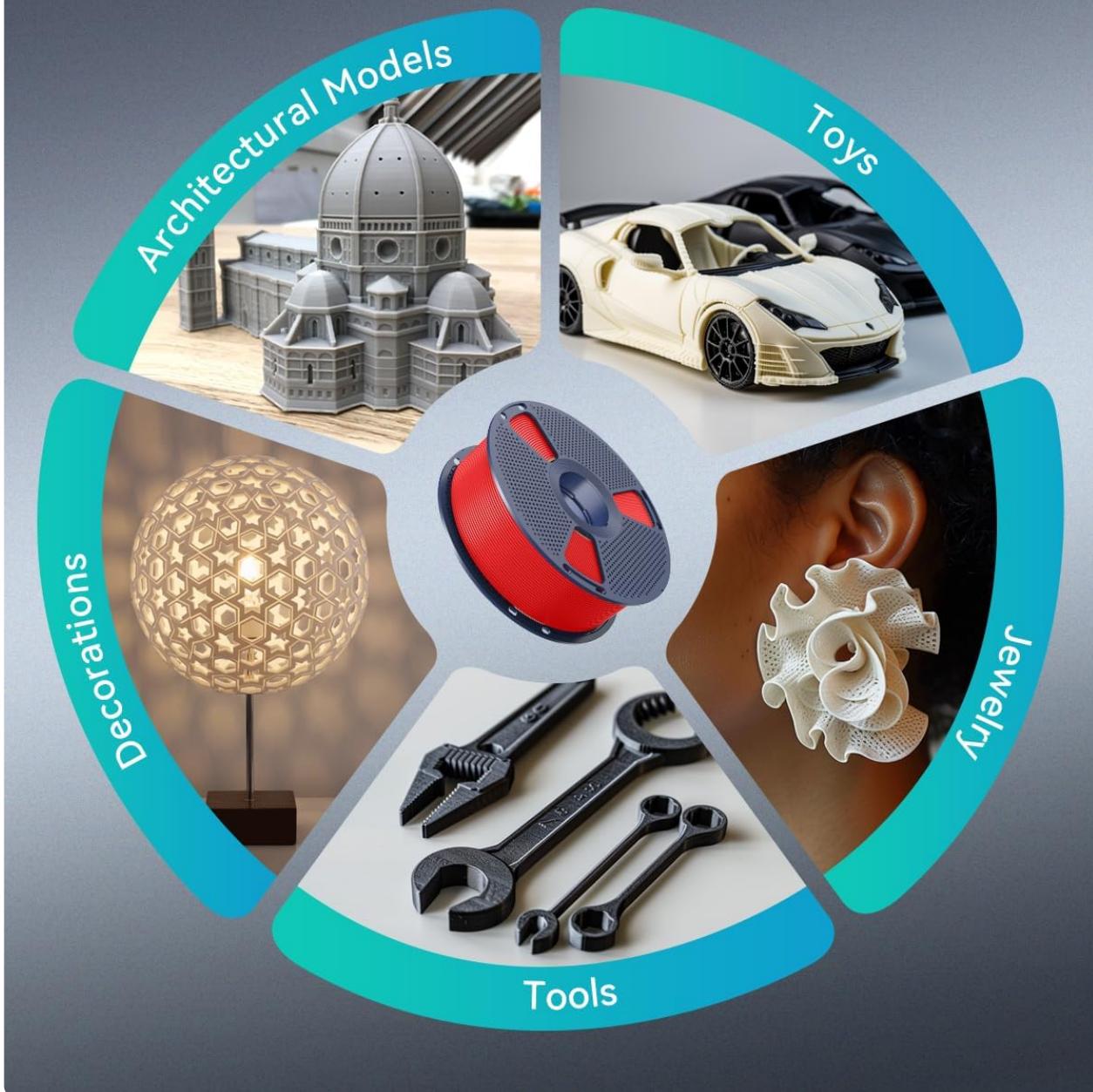


Image: Examples of different applications for PETG filament, including architectural models, toys, jewelry, tools, and decorations.

8. Specifications

Specification	Detail
Brand	SUNLU
Material	Polyethylene Terephthalate Glycol (PETG)

Item Diameter	1.75 Millimeters
Dimensional Accuracy	+/- 0.02mm
Item Weight (Total)	10 Kilograms (22 pounds)
Number of Items	10 (1kg per spool)
Spool Diameter	8.00 inches
Spool Width	2.50 inches
Spool Hub Hole Diameter	2.20 inches
Recommended Nozzle Temp	240-260°C
Recommended Bed Temp	65-75°C
Recommended Print Speed	50-200mm/s
Manufacturer Part Number	SLUS-PETG-BK+WT+GY+BL+RD+GN+OR+YL+PK+TP

9. Warranty & Support

SUNLU is committed to providing high-quality 3D printing materials and excellent customer service. For any inquiries, technical support, or warranty information, please refer to the official SUNLU website or contact their professional support team.

You can visit the official SUNLU Store for more products and support resources: [SUNLU Store on Amazon](#)