

LUMAFUSE PETG 0800 ESD FILAMENT

RECOMMENDED PRINT SETTINGS



PRINT TEMPERATURE

- The optimal printing range is 260 – 280° C



BED TEMPERATURE

- A bed temperature of 80°C to 85°C will keep the prints firmly attached.



PRINTING SPEED

- Base printing speed of 60 mm/s
- Infill speed of 45 mm/s
- Wall speed of 40 mm/s
- Initial layer speed of 30 mm/s



COOLING

- For the best mechanical properties, use a regular cooling fan speed of 5%. Increase the fan speed if better feature detail is required, up to 100%.



BED ADHESION

- Firm adhesion can be obtained with PVA-based glue stick on a glass bed or PEI sheet. A brim should be used



OTHER TIPS

- Start with an initial layer height of at least 0.26 mm. If there is stringing, try moving the initial layer height up by increments of 0.02 mm until there is no stringing or until best print quality.
- Print and store in a low humidity environment. If you experience unusual oozing, stringing or rough surface texture, the filament has likely absorbed moisture and needs to be dried.
- To increase the conductivity of the printed part surface, increase the print temperature. Lowering the print temperature will reduce the conductivity of the part surface.

If using Ultimaker Cura, enable the LumaFuse PETg 0800 ESD material profile available in the Marketplace or manually type in the settings from the information above.

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LUMAFUSE PETG 0800 ESD FILAMENT

LumaFuse PETg 0800 ESD filaments are easy processing and electrostatic dissipative (ESD) with a good balance of properties in XY and XYZ directions. This filament provides excellent toughness and durability.

APPLICATIONS

- Automotive, aerospace, general manufacturing
- Jigs, fixtures, tooling
- Housings
- End-of-arm tooling for robotics (EOAT)
- Brackets

ADVANTAGES

- ESD properties - ESD of $10E5$ - $10E9$
- Good stiffness and strength
- Excellent chemical resistance
- Very consistent outer diameter and ovality of the filament
- Easy printability
- Low shrinkage and warpage
- Good continuous use temperature

DIAMETERS

- 1.75mm
- 2.85mm



QUESTIONS? VISIT [LUMASPOLYMERS.COM](https://lumaspolymers.com) FOR THE LATEST PRINT PROFILES.