



A Subsidiary of ICC Industries, Inc.

# Prime PETG 6763

## Prime PETG 6763:

*The most outstanding features about this product are high stiffness and good impact resistance at low temperature. It is clear and easy to thermoform.*

*Prime PETG 6763 can be sterilized with gamma rays, is resistant to stress whitening and the scrap is recyclable.*

## Applications:

*Prime PETG is suited for the following applications: Blister packaging for medical devices, Point of purchase displays and thermoformed containers for refrigerated/frozen foods, candies and sundries.*

## Processing:

*Recommended forming temperatures for forming Prime PETG 6763 are; Mold temperature = 100-140°F*

*Sheet temperature = 280-300°F*

*Plug temperature = 250-275°F*

*Cycle times in seconds = 3-10 for <.050 thick sheet. Forming pressures = 30-40 PSI. Polarized lenses or a light box should be used to check for residual stress in the part.*



Prime PETG 6763	Very High	High	Average
Impact Strength		*	
Low Temperature Impact Strength			*
Tensile Strength		*	
Flexural Modulus	*		
Heat Deflection Temperature			*



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## Finishing:

Scratches can be repaired with a heat gun. Sawing and routing are best suited for cutting Prime PETG 6763. Circular and band saws generally produce the smoothest cut. Circular saws- number of teeth = 2-4 /in., blade thickness – 3/32 in. for sheet .040 - .375, use 1/8 in. for thicker sheet. The blade tooth rake angle should be 5-10°. For routing use a two-flute bit and run at 10,000 to 20,000 rpm. When drilling use speed of 1750 rpm. Bonding can be done by solvent or adhesives.

Please contact your Primex Plastics representative for more information on finishing, fabricating, or the thermoforming process.

## Colors, Textures and Capabilities:

Prime PETG 6763 can easily be color matched to meet your specific requirements. Textures available; Smooth or Matte. Prime PETG 6763 can be extruded in either rolls or sheet and is offered in .010- .030 and up to 52" in width or in .060-.236 and up to 56" in. width.

Property	Test Method	Value	Unit
Specific Gravity	D-1505	1.27	
Tensile @ Yield	D-638	7,700	psi
Elongation @ Break	D-638	50	%
Flexural Modulus	D-790	310,000	psi
Rockwell Hardness	D-785	115	R Scale
Notched Izod @ 73°F	D-256	1.7	ft-lb/in
Notched Izod @ -22°F	D-256	.7	ft-lb/in
HDT @ 264 psi	D-648	157	°F
Vicat Softening Point	D-1525	181	°F
Haze	D1003	.5	%
CLTE	D696	5.1X10 <sup>-5</sup>	In/in/°F
Water Vapor Transmission	E96E	6	g/m <sup>2</sup> 24h

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