TECHNICAL DATA SHEET

KEXCELLED PLA K6

Product code:	Revision Number:	Revision date:	TDS No.:
PLA K6	02	2/04/2020	KT04.012.0123

Characteristic:

Higher toughness|no buckling deformation|lower shrinkage

IDENTFICATION OF THE MATERIAL	
Trade name	PLA K6
Chemical name	Polylactic Acid
Use	3D Printing
Origin	KEXCELLED

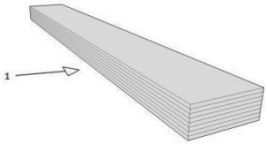
GUIDELINE FOR PRINT SETTINGS	
Nozzle temperature	200~230℃
Bed temperature	30~60℃
Bed modification	Tape or glue below 60℃
Active cooling fan	ON
Layer height	0.2mm
Shell thickness	≥0.8mm
Print speed	40~80mm/s

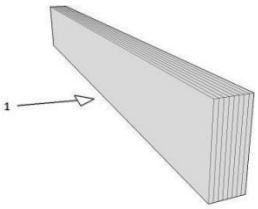
Settings are based on a 0.4mm nozzle.

MATERIAL PROPERTIES		Test Method
Melt temperature	~160 ℃	ISO 11357
Melt flow rate (MFR) [1]	5~6 g/10min	ISO 1133
Heat deflection temperature(HDT)[2]	54 ℃	ISO 75
Vicat softening temperature(VST)[3]	59 ℃	ISO 306
density	1.20 g/cm^3	ISO 1183
Odor	Odorless	/
Solubility	Insoluble in water	/

1. test conditions: T= 190℃; m= 2.16kg.
2. test conditions:0.45MPa;120℃/h.
3. test conditions:10N; 120℃/h.

MECHANICAL PROPERTIES|TENSILE TEST	Test Method ISO 527
All test specimens were printed using an FlashForge Guider 2s，under the following conditions： Printing temperature: 210℃ Heated bed temperature：50℃ Print speed：45mm/s Shell thickness：0.8mm Infill under 45°	
Infill	100%
Tensile strength（Mpa）	34~38
Elongation at break（%）	10~15

MECHANICAL PROPERTIES|IMPACT TEST	Test Method ISO 179
The same conditions as tensile test. 1→impact direction	
Infill	100%
Impact strength（KJ/m^2）	65~100
Notch impact strength[1]（KJ/m^2）	25~35

MECHANICAL PROPERTIES |FLEXURAL TEST	Test Method ISO 178
The same conditions as tensile test. 1→bending direction	
Infill	100%
Maximum force（Mpa）	60~65
Flexural modulus（Mpa）	2100~2400

1. notch type: type A

FILAMENT SPECIFICATION		Test Method
Diameter 1.75mm	1.75±0.03mm	EX1125
Diameter 2.85mm	2.85±0.03mm	EX1125
Diameter 3.00mm	3.00±0.03mm	EX1125
Max roundness deviation（1.75）	0.03mm	EX1125
Max roundness deviation（2.85）	0.03mm	EX1125
Max roundness deviation（3.00）	0.03mm	EX1125
Net weight on reel	1kg	EX1125