

TECHNICAL DATA SHEET

KEXCELLED PAHT K7

Product code:	Revision Number:	Revision date:	TDS No.:
PAHT K7	04	13/01/2022	KT04.20.4101

Characteristic:

High strength | high heat resistance | no buckling deformation | lower shrinkage

IDENTIFICATION OF THE MATERIAL

Trade name	PAHT K7
Chemical name	polyamide 6
Use	3D Printing
Origin	KEXCELLED

GUIDELINE FOR PRINT SETTINGS

Nozzle temperature	260~285°C
Bed temperature	70~100°C
Bed modification	Tape or glue
Active cooling fan	OFF
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	~230°C	ISO 11357
Melt flow rate (MFR)¹	19~22g/10min	ISO 1133
Heat deflection temperature(HDT)²	135°C	ISO 75
Vicat softening temperature(VST)³	207°C	ISO 306
density	1.15g/cm ³	ISO 1183
Odor	Odorless	/
Solubility	Insoluble in water	/

1. test conditions: T= 270°C; m= 2.16kg.

2. test conditions:0.45MPa;120°C/h.

3. test conditions:10N; 120°C/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: 280°C

Heated bed temperature: 100°C

Print speed: 50mm/s

Shell thickness: 1.2mm

Infill under 45°



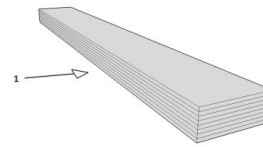
Printed horizontal X,Y-axis

Infill	100%
Tensile strength (Mpa)	70~75
Elongation at break (%)	21~25
E modulus (Mpa)	4600~4800

MECHANICAL PROPERTIES|IMPACT TEST
Test Method ISO 179

The same conditions as tensile test.

1→impact direction

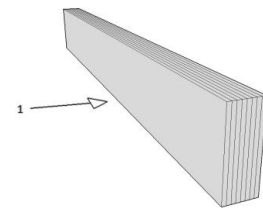


Infill	100%
Impact strength (KJ/m ²)	30~40
Notch impact strength ¹ (KJ/m ²)	4~6

MECHANICAL PROPERTIES |FLEXURAL TEST
Test Method ISO 178

The same conditions as tensile test.

1→bending direction



Infill	100%
Maximum force (Mpa)	100~110
Flexural modulus (Mpa)	2400~2600

1. notch type: type A

*The mechanical properties of nylon and its HDT have a great relationship with its water absorption rate. This table shows its performance in its dry state.

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