

TECHNICAL DATA SHEET

KEXCELLED PLA K6

Product code:	Revision Number:	Revision date:	TDS No.:
PLA K6	04	12/01/2022	KT04.20.1009

Characteristic:

Higher toughness | no buckling deformation | lower shrinkage

IDENTIFICATION OF THE MATERIAL

Trade name	PLA K6
Chemical name	Polylactic Acid
Use	3D Printing
Origin	KEXCELLED

GUIDELINE FOR PRINT SETTINGS

Nozzle temperature	200~230°C
Bed temperature	30~60°C
Bed modification	Tape or glue below 60°C
Active cooling fan	ON, 50%~100%
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°C	ISO 11357
Melt flow rate (MFR)¹	4~6 g/10min	ISO 1133
Heat deflection temperature(HDT)²	54°C	ISO 75
Vicat softening temperature(VST)³	59°C	ISO 306
Density	1.20~1.22g/cm ³	ISO 1183
Odor	Odorless	/
Solubility	Insoluble in water	/

1. test conditions: T= 190°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: 215°C

Heated bed temperature: 60°C

Print speed: 50mm/s

Shell thickness: 1.2mm

Infill under 45°



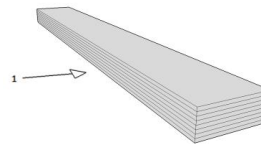
Printed horizontal X,Y-axis

Infill	100%
Tensile strength (Mpa)	34~38
Elongation at break (%)	10~15
Emodulus (Mpa)	3400~3600

MECHANICAL PROPERTIES|IMPACT TEST
Test Method ISO 179

The same conditions as tensile test.

1→impact direction

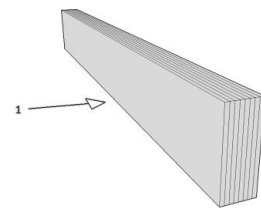


Infill	100%
Impact strength (KJ/m ²)	65~100
Notch impact strength ¹ (KJ/m ²)	25~35

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