

TECHNICAL DATA SHEET

KEXCELLED ABS K5T

Product code:	Revision Number:	Revision date:	TDS No.:
ABS K5T	04	13/01/2022	KT04.20.2002

Characteristic:

High heat distortion temperatures | transparency | excellent toughness.

IDENTIFICATION OF THE MATERIAL

Trade name	ABS K5T
Chemical name	Acrylonitrile-butadiene-styrene terpolymer
Use	3D Printing
Origin	KEXCELLED

GUIDELINE FOR PRINT SETTINGS

Nozzle temperature	240~260°C
Bed temperature	80~100°C
Bed modification	Tape or glue
Active cooling fan	0~50%
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	~180°C	ISO 11357
Melt flow rate (MFR)¹	30~35g/10min	ISO 1133
Heat deflection temperature(HDT)²	95°C	ISO 75
Vicat softening temperature(VST)³	101°C	ISO 306
density	1.05~1.06g/cm ³	ISO 1183
Odor	Low odor	/
Solubility	Insoluble in water	/

1. test conditions: T= 220°C; m= 10kg.

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: 250°C

Heated bed temperature: 100°C

Print speed: 50mm/s

Shell thickness: 1.2mm

Infill under 45°



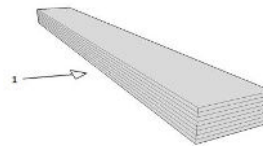
Printed horizontal X,Y-axis

Infill	100%
Tensile strength (Mpa)	42~44
Elongation at break (%)	8~10
E modulus (Mpa)	2700~3000

MECHANICAL PROPERTIES|IMPACT TEST
Test Method ISO 179

The same conditions as tensile test.

1→impact direction

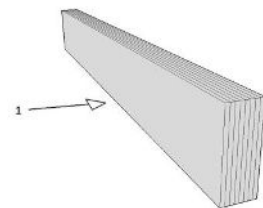


Infill	100%
Impact strength (KJ/m ²)	23~28
Notch impact strength ¹ (KJ/m ²)	14~18

MECHANICAL PROPERTIES |FLEXURAL TEST
Test Method ISO 178

The same conditions as tensile test.

1→bending direction



Infill	100%
Maximum force (Mpa)	75~78
Flexural modulus (Mpa)	2200~2400

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