

TECHNICAL DATA SHEET

KEXCELLED OBC K7

Product code:	Revision Number:	Revision date:	TDS No.:
OBC K7	01	24/11/2022	KT026

Characteristic:

Low absorption of water | high flexibility | chemical resistance | low density

IDENTIFICATION OF THE MATERIAL

Trade name	OBC K7
Chemical name	Olefin Block Copolymers
Use	3D Printing
Origin	KEXCELLED

GUIDELINE FOR PRINT SETTINGS

Nozzle temperature	210~240°C
Bed temperature	70~90°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	~190°C	ISO 11357
Melt flow rate (MFR)¹	3~4g/10min	ISO 1133
Heat deflection temperature(HDT)²	60°C	ISO 75
Vicat softening temperature(VST)³	95°C	ISO 306
density	0.9g/cm ³	ISO 1183
Odor	Low odor	/
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: 240°C

Heated bed temperature: 70°C

Print speed: 50mm/s

Shell thickness: 1.2mm

Infill under 45°



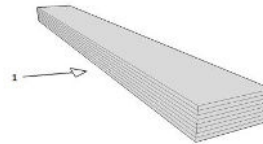
Printed horizontal X,Y-axis

Infill	100%
Tensile strength (Mpa)	11~14
Elongation at break (%)	>800%
E modulus (Mpa)	500~600

MECHANICAL PROPERTIES|IMPACT TEST
Test Method ISO 179

The same conditions as tensile test.

1→impact direction

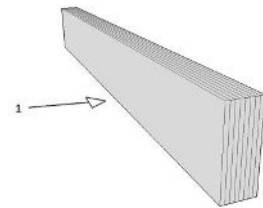


Infill	100%
Impact strength (KJ/m ²)	N/A
Notch impact strength ¹ (KJ/m ²)	32~35

MECHANICAL PROPERTIES |FLEXURAL TEST
Test Method ISO 178

The same conditions as tensile test.

1→bending direction



Infill	100%
Maximum force (Mpa)	2~3
Flexural modulus (Mpa)	370~630

1. notch type: type A

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