

TECHNICAL DATA SHEET

KEXCELLED PC K7

Product code:	Revision Number:	Revision date:	TDS No.:
PC K7	04	13/01/2022	KT023

Characteristic:

High strength | high heat resistance

IDENTIFICATION OF THE MATERIAL

Trade name	PC K7
Chemical name	Polycarbonate
Use	3D Printing
Origin	KEXCELLED

GUIDELINE FOR PRINT SETTINGS

Nozzle temperature	250~270°C
Bed temperature	80~100°C
Chamber temperature	60~90°C
Bed modification	NO&High temperature 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	30~40g/10min	ISO 1133
Heat deflection temperature(HDT) ²	107°C	ISO 75
Vicat softening temperature(VST) ³	116°C	ISO 306
density	1.20g/cm ³	ISO 1183
Odor	Odorless	/
Solubility	Insoluble in water	/

1.test conditions: T= 260°C; m= 1.2kg.

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: 260°C

Heated bed temperature: 100°C

Print speed: 50mm/s

Shell thickness: 1.2mm

Infill under 45°



Printed horizontal X,Y-axis

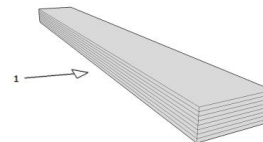
Infill	100%
Tensile strength (Mpa)	65~75
Elongation at break (%)	11~16
E modulus (Mpa)	4200~4600

MECHANICAL PROPERTIES|IMPACT TEST

Test Method ISO 179

The same conditions as tensile test.

1→impact direction



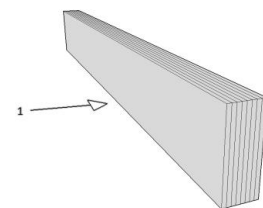
Infill	100%
Impact strength (KJ/m ²)	35~40
Notch impact strength ¹ (KJ/m ²)	2~4

MECHANICAL PROPERTIES |FLEXURAL TEST

Test Method ISO 178

The same conditions as tensile test.

1→bending direction



Infill	100%
Maximum force (Mpa)	90~93
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
Max roundness deviation (1.75)	0.03mm	EX1125
Max roundness deviation (2.85)	0.03mm	EX1125
Net weight on reel	1kg	EX1125