

Technical data sheet – 3D Filament

PEKK – (60/40)

PEKK 60/40 – Poly Ether Ketone Ketone is a copolymer with lower melting point T_m of 305°C but possessing a relatively high T_g of ~160 °C. The lower melting point allows for ease of processing at lower temperatures (310-350°C). **PEKK A** is High performance thermoplastic unreinforced pseudo-amorphous polymer based on Polyether Ketone Ketone. It offers low out gassing properties, good heat resistance, wear resistance, chemical resistance & excellent mechanical performance, easy to print.

FILAMENT PROPERTIES

PROPERTIES	TEST METHODS	UNITS	Typical Values PEKK 60/40
Diameter	INS-6712	mm	1.75 ± 0.05
Specific gravity	ISO 1183	g/cm3	1.28
Moisture rate	INS-6711	%	< 1
MFI (@295°C – 5 kg)	ISO 1133	g/10min	30 to 40
Glass transition T_g	ISO 11357	°C	160
Melting temp T_m	ISO 11357	°C	305
TEST METHOD			
Tensile Strength	ISO 527	Mpa	95 to 110
Tensile Elongation	ISO 527	%	7 to 10
Tensile Modulus	ISO 527	GPa	3.0 to 3.5
Flexural Strength	ISO 178	MPa	130 to 140
Flexural Modulus	ISO 178	GPa	3 to 3.5
Heat Distortion Temp. 0.45 Mpa	ISO 75	°C	182
Flammability Behaviour	UL	Rating	(V-0) @1.5mm

PRINT RECOMMENDATION	PEKK 60/40 XY- Flat on bed
Nozzle Temp	315 to 340 °C
Print Speed	20-55 mm/sec
Bed Temp	130 °C
Nozzle	0.4 mm/
Infill	100 % +/- 45
Bed Adhesion	PEI

Disclaimer: The testing has been done in house so we extend no warranties what so ever, expressed or implied, including but not limited to, any implied fitness for any particular purpose. From the moment the product is shipped it is beyond our control. The information in this document is believed to be correct at the time of writing. However, handling, processing, settings, the type of 3D printer, slicing and other variables are completely up to the user. The method through which the product is used can be varied. It is up for the customer to determine how it is 3D printed and whether it is fit for purpose or suited to a particular application.



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