

## TECAFIL PEKK natural - Filament

### Chemical Designation

PEKK (Poly etherketoneketone)

### Colour

amber

### Density

1.27 g/cm<sup>3</sup> (\*2)

### Target Industries

- electronics
- automotive industry
- mechanical engineering
- aircraft and aerospace technology

General material information	parameter	value	unit	norm	comment
Diameter		1,75 +/- 0,05	mm	-	(1) standard spool body
Spool Measurements	width	55	mm	-	(2) do not dry spool >120°C
Spool Measurements	holder	Ø 52	mm	-	(3) Ø 1,75mm
Spool Measurements	outer diameter	Ø 200	mm	-	(1)
Spool Material		Polycarbonate	-	-	(2)
Filament Load per Spool		500	g	-	
Filament Length per Spool		155	m	-	(3)
Mechanical properties	parameter	value	unit	norm	comment
Tensile strength	50 mm/min	88	MPa	DIN EN ISO 527-1	(1) (*1)
Modulus of elasticity (tensile test)	50 mm/min	2900	MPa	DIN EN ISO 527-1	(2) (*1)
Elongation at break (tensile test)	50 mm/min	80	%	DIN EN ISO 527-1	(3) (*1)
Flexural strength	2 mm/min, 10 N	128	MPa	DIN EN ISO 178	(4) (*1)
Modulus of elasticity (flexural test)	2 mm/min, 10 N	3000	MPa	DIN EN ISO 178	(5) (*1)
Elongation at break (flexural test)	2 mm/min, 10 N	-	%	DIN EN ISO 178	(6) (*1)
Impact strength (Charpy)	max 7,5J - 23°C	-	kJ/m <sup>2</sup>	DIN EN ISO 179-1eJ	(7) (*1)
Notched impact strength (Charpy)	max 7,5J - 23°C	5	kJ/m <sup>2</sup>	DIN EN ISO 179-1eA	(8) (*1)
Thermal properties	parameter	value	unit	norm	comment
Glass transition temperature		160	°C	ASTM D 3418	(1) (*2)
Melting temperature		300	°C	DIN EN ISO 11357	(2) (*2)
Deflection temperature	HDT-A	139	°C	ISO-R 75 Method A	(3) (*2)
Service temperature	short term	230	°C	-	(4) (*2)
Service temperature	long term	200	°C	-	(5) (*2)
Thermal expansion (CLTE)		-	10 <sup>-3</sup> K <sup>-1</sup>	DIN EN ISO 11359-1:2	(6) (*2)
Other properties	parameter	value	unit	norm	comment
Moisture absorption		0,6	%	DIN EN ISO 62	(1) (*2)
MVR	380°C / 5kg	35	cm <sup>3</sup> /10 min	DIN EN ISO 1133	(2) (*2)
Processing parameter	parameter	value	unit	norm	comment
Nozzle temperature		345 - 375	°C	-	(1) required
Max. melt temperature		500	°C	-	
Print bed temperature		120 - 160	°C	-	
Build chamber temperature		150 - 170	°C	-	(1)
Nozzle diameter		0,4	mm	-	
Print speed		30 - 40	mm/s	-	
Fan speed		0	%	-	
Predrying	parameter	value	unit	norm	comment
Drying temperature		120	°C	-	(1) (*4)
Drying time		8	h	-	

→ To achieve optimum mechanical properties, it is recommended to pre-dry the material with the above mentioned parameters.

- (\*1) Values measured on injection moulded test specimens
- (\*2) Values measured on the raw material
- (\*3) The exact parameters depend on the printer used.
- (\*4) Do not exceed maximum drying temperature of 120°C
- (\*5) Properties tested on printed specimens
- (\*6) Specimens printed on Minifactory Ultra

→ The filament should preferably be stored in dry, normal temperature rooms and protected from direct sunlight.

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