

# 3D PRINTING GUIDE PLA CRYSTAL CLEAR



**Plug in and print.**  
Compatible with high speed printers.

**Second life**  
Sustainable spool

## BASIC OVERVIEW

### HARDNESS



### IMPACT RESISTANCE



### FLEXIBILITY



### EASY OF PRINTING



### WEATHER RESISTANCE



### WEAR AND ABRASION RESISTANCE



## BASIC NON HIGH-SPEED PRINTERS SETUP

**Print Temp:**  
190 - 210 °C

**Bed Temp:**  
0 - 55 °C

**Printing Speed:**  
30 - 70 mm/s

**Cooling Fan:**  
100 %

## HIGH SPEED PRINTERS SETUP

### GLOSSY AND MATTE FINISHES WITH TWO SETUPS

When aiming for consistent surface finishes, the printing temperature plays a crucial role. A common issue arises when using the same printing temperature, as the extrusion temperature can vary significantly, resulting in different surface finishes.

#### GLOSSY FINISH

**Print Temp:**  
230 - 270 °C

**Printing Speed | Outer line:**  
50 - 200 mm/s

**Bed Temp:**  
0 - 55 °C

**Cooling Fan:**  
100 %

#### MATTE FINISH

**Print Temp:**  
180 - 230 °C

**Printing Speed | Outer line:**  
100 - 400 mm/s

**Bed Temp:**  
0 - 55 °C

**Cooling Fan:**  
100 %

#### DISCLAIMER:

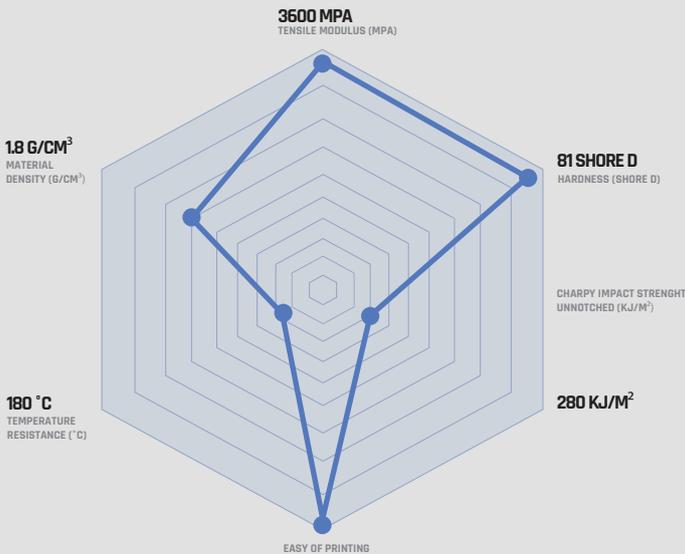
This settings does not function with PLA Mukha.

The ratio between speed and temperature depends on the type of printer.

#### NOTE:

THE glossy finish can slightly (up to 5%) affect the mechanical properties of the final print. Conversely, for a matte look, adjust your setup to achieve a uniform, non-reflective finish without compromising the mechanical integrity. This guide will help you fine-tune both setups for the desired aesthetic and functional outcomes.

## DETAILED VIEW



## ARE YOU MISSING THE RIGHT ANSWER?

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## TIPS BEFORE YOU START

#### HEATED BED SURFACE:

PEI, mirror/glass, Kapton, Blue tape

#### ADHESIVE:

Magigoo, 3Dlac, PVA glue

#### RAFT/SKIRT/BRIM:

Skirt

#### HEATED CHAMBER/ ENCLOSURE:

Not needed

#### HOTEND:

In case you are going to print only PLA we do not recommend using all-metal hotend. It may cause jams if the inside of the heatbreak is not made well. Therefore, it is reasonable to use hotends with PTFE which is pretty good for PLA printing only.



**DATASHEETS AND MORE...**  
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## WE GUARANTEE THE BEST QUALITY WITH CPK PROCESS MEASUREMENT.

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WE PROVIDE FILAMENT INSPECTION



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