

3D PRINTING GUIDE

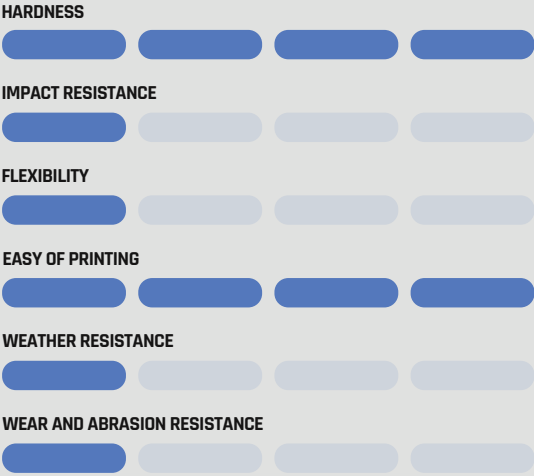
PLA CRYSTAL CLEAR



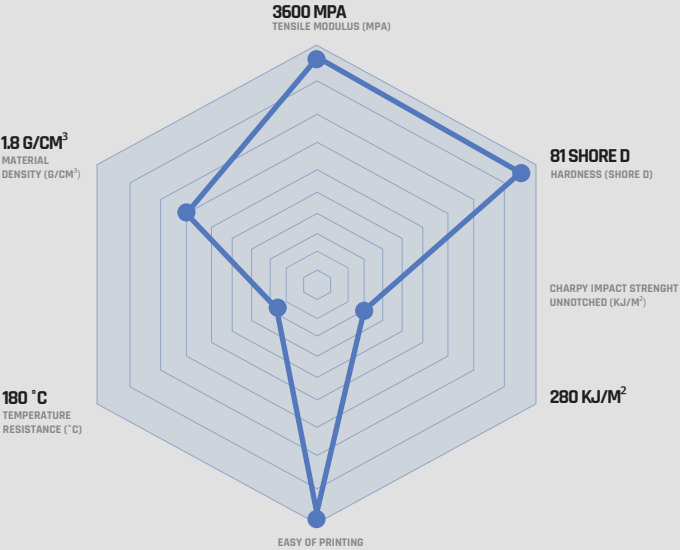
 **Plug in and print.**
Compatible with high speed printers.

 **Second life**
Sustainable spool

BASIC OVERVIEW



DETAILED VIEW



ARE YOU MISSING THE RIGHT ANSWER?


CHOOSE THE PLACE YOU'D LIKE TO CONNECT WITH US.


 **CLICK FOR FILLA FILLA CHAT BOT**
24/7 INSTANT ANSWER


 **HELPPDESK@FILLAMENTUM.COM**
REACTION TIME 12 - 16 HOUR


 **CALL US IF YOU WANT +420 725 463 731**
BETWEEN 8 AM AND 4 PM CENTRAL EUROPEAN TIME.

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.

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...**
24/7 AVAILABLE

WE GUARANTEE THE BEST QUALITY WITH CPK PROCESS MEASUREMENT.

At Fillamentum, we go beyond achieving a lower filament diameter. We focus on CPK (Process Capability Index) could be known as a Sigma within Industry. It is a crucial measure that ensures every spool of filament meets the highest standards. Here is Why CPK is essential for you and why it is more important than just diameter.

WE PROVIDE FILAMENT INSPECTION

