



PRINT SETTINGS HH PLA

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| Nozzle Temp | 210°C-230°C |
| Bed Temp | 60°C-80°C |
| Heated Enclosure | Not required (using in a sealed enclosure may cause heat creep) |
| Bed Adhesion | Hairspray, glue stick, or increase bed temperature |
| Drying Settings | 50°C for 2 hours |

Preferred Print Parameters

0.4mm Nozzle – 0.2mm Layer Height
215°C Extruder 60°C Bed
45-55mm/s with part cooling ON

Annealing HH PLA

- 80-130° C for 15min – 2 hours
- Time and temp dependent on method and part density
- Printed parts may deform slightly after annealing!

Printing Considerations

- Larger nozzle diameters, higher volumetric flow, and faster print speeds will require higher nozzle temperatures.
- PLA can become soft as low as 50 degrees C, so avoid using PLA if your 3D printed part will be exposed to heat
- Due to its low heat resistance, certain hot-ends can experience “heat creep”, where the filament prematurely melts in the feed throat causing a jam.
- Layer cooling is essential with PLA – turn up the part cooling fan when printing with this material