



PRINT SETTINGS HH + Tough PLA

Nozzle Temp	215°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
220°C Extruder 70°C Bed
45-55mm/s with part cooling ON

Annealing HH + Tough 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