



PRINT SETTINGS PLA (Standard)

Nozzle Temp	210°C-230°C
Bed Temp	30°C-70°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

Printing Considerations

- Temperature variations: 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 cause “heat creep”, where the filament prematurely melts causing a jam.
- Layer cooling is essential with PLA – turn up the part cooling fan when printing with this material