



HIGHEST RATED FILAMENT ON AMAZON  
60-DAY MONEY BACK GUARANTEE

FAST, FREE MAINLAND DELIVERY OVER £65!  
HEAVY USER? SUBSCRIBE AND SAVE!

## Description:

A high-purity general purpose low-temperature biopolymer that is easy to print with.

Prints at a lower temperature than most other PLA filaments.

## Applications:

Prototyping, general modelling, and artwork.

## Recommended Print Settings:

Printing Temps 1.75mm	180-205°C
Printing Temps 2.85mm	185-210°C
Heated Bed Temp	None-45°C
Cooling Fans	Off, then 100% after 1st layer
Ideal Build Volume	Doors and covers open/removed
Extrusion Multiplier	x0.9 (90%)
Retraction (direct drive)	Try 1mm as a starting point at 20-30mm/s
Retraction (bowden feed)	Varies per printer, as above, but try 3mm as a starting point
Print Speed Advisory	None
Print Surface Advisory	None
Print Layer Advisory	None

## General Advice:

Start at the low end of the temperature range and increase if needed for faster print speeds.

Do not leave the hotend idle at printing temperatures for more than 5 minutes as the filament will begin to degrade in the nozzle.

## Material Properties:

Physical Properties <sup>(1)</sup>	Value
Density	1.24g/cm <sup>3</sup>
Glass Transition Temperature	55-60°C
Melting Point	145-160°C
Heat Distortion Temperature <sup>(2)</sup>	55°C
Tensile Yield Strength	60 MPa / 8700 psi

(1) NOT to be construed as specifications

(2) @0.5MPa

## Other Info:

Versatile biopolymer that's easy to print with

Low smell and long-term biodegradable

Very little shrinkage

rigid.ink PLA is surprisingly strong, great for end-use parts

Ideal for general modelling

Compatible with most printers

Can be sanded and smoothed to give an outstanding finish

Readily accepts most kinds of paints

A superb material for general use in school

Can be annealed to improve strength and thermal properties

Damp filament can be dried at 40-50°C for 8-12 hours in a circulating air dryer

## Print Surface Materials:

Adheres well to most bed surfaces including PEI, BuildTak, blue painters' tape, etc.

Bed surfaces must be kept clean with the appropriate cleaning fluid/solvent in order to obtain reliable adhesion.

A heated bed is usually unnecessary. Notable exceptions are bed surfaces based on FR4 materials. These often require a bed to be heated up to the maximum advised temperature of 45°C in order to achieve satisfactory adhesion.

Other methods of securing a print include 3DLAC, Extra-Hold vinyl-based hairspray, glue sticks, ABS slurry, and so on.

---

Please note that the information given in this Technical Data Sheet, including, but not limited to, data, statements and typical values, are given in good faith. They are provided as an aid for material selection purposes only. The values and information presented on this sheet are typical values and should not be interpreted as being absolute or precise specifications. Colour pigments may induce variance in printing settings between filament colours.