

Fillamentum PLA Extrafill

(polylactic acid)

Printing temperature: 190 – 210 °C

Heated bed temperature: 0 – 55 °C

Speed: 30 – 70 mm/s

Part cooling fan: 100 %

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.

Surface

- To achieve more matte surfaces use lower printing temperatures around 180–190 °C. If you are interested in glossier surfaces, use higher temperatures of printing.