amazon basics B07SZLYWS2 Setting Printer Filament Instruction Manual

Print Setting Guideline
PLA 3D Printer Filament

BO7SZLYWS2, B07S571G2L, BO7T6WLFML, BO7SZLYWSN, BO7SZLYHTW, BO7T61GPBG, B07SZLZ2YD, BO7T61GZMN, BO7T6WHW2L, BO7RZTF5Q7, BO7T61CXWN, BO7SZLZ218, B07T6X348M, BO7SZLZG26, BO7T61HC3P, BO7T61FVBB, BO7T6EWMYWYV, BO7T1QD5WW, B0752ZXM97, BO7T4X4RQH, BO7T6VTG61, BO7SZLZ7TY, BO7T2R1BQJ, BO7T4X4Y8L, B07T4X4D2C, BO7T2QZSLY, BO7S48YLWW, BO7T6WS8TRF, BO7SZLZ43X, BO7SZLYTBV, BO7T6W63MY, BO7RZTF5QB, BO7T6VTG44, BO7T61FVF1, BO7T2QZYQD, BO7T4X4Y88, BO7T616NXL, BO7T616NYT, BO7T2QZYSS5, BO7T2QZYS1, BO7T61HMY4, BO7T6VTG5Q, B07SZLZG3L, BO7SZLZG2P, BO7RZTF5QF, BO7T6VTG4H, BO7T2QZSM5, BO7S2ZW2VS5, B07T4X57Q1, BO7SZLZG5G, B07SZLZ241, BO7SZLZ1ZD, BO7SZLZ2WD

Contents

Clean and Level the Print Bed After Every Print

1.1 Glass

Check that the glass is properly cleaned after each print, use water to clean the build plate. Do not touch the print bed with fingers as this can reintroduce oils from fingers onto the print surface and this can cause adhesion issues.

1.2 PEI sheet / sticker

PEI is a long lasting option for improving bed adhesion, it also needs to be cleaned regularly. It is recommended to use an isopropyl alcohol solution (> 70%) to wipe the surface and removing any residue. Using acetone once in a while could help with increasing the adhesion. It is not recommend to use a scraper with PEI as this can damage the surface and diminish the PEI sheets effectiveness.

1.3 Painters tape (sometimes used on non-heated beds)
Though it is recommend to change the tape for every print, it is possible to lightly scrap the surface in between prints to remove any residue. Patch any area where the tape might have been damaged while removing a previous part.

Calibrate Print Settings

NOTICE No two filaments print the same due to the slight differences in formulations from manufacturer to manufacturer.

2.1PLA
It is recommended to start calibrating this material at around 401 °F (205 °C) with 40 mm/s before turning up the printing temperature and/or speed. For the heated bed (when available), it is recommended to keep the bed at 140 °F (60 °C) for the first layers after which can be lowered to 131 °F (55 °C). Ultimately this depends on the printing environment. Do not overheat the bed as this can soften the bottom layers of the print which can result in “elephant feet”. For cooling, it is recommended to turn on the fan to 100% after the first 1-2 layers. Keeping the cooling off for the first layers often result in better adhesion to the bed.

2.2 ABS
It is recommended to start calibrating this material at around 473 °F (245 °C) with 40 mm/s before turning up the printing temperature and/or speed. For the heated bed (when available), it is recommended to keep the bed at 203 °F (95 °C) or higher for the entire print. Ultimately this depends on the printing environment. Enclosing the 3D printer when printing with ABS can greatly reduce the chances of failed prints. Just a little bit of a draft (coming from an AC, a window etc.) can cause failures due to unexpected cooling of the part which in turn can cause warping. For cooling, it is recommended to keep the cooling fan at 0% (or very low) for the entire print unless it is printing something more advanced that requires some cooling. For these instances, perform a few experiments with what settings work for that corresponding print.

2.3 PETG
It is recommended to start calibrating this material at around 464 °F (240 °C) with 40 mm/s before turning up the printing temperature and/or speed. For the heated bed (when available), it is recommended to keep the bed above 158 °F (70 °C) for the entire duration of the print. For cooling, it is recommended to keep the fan low unless the object requires some more cooling. PETG is prone to oozing while 3D printing. To prevent oozing, it is recommend to purchase a silicone nozzle guard (that is compatible with the hot-end) that helps prevent the oozing material from sticking to the hot-end and potentially cause issues later during printing. Drying the material at up to 158 °F (70 °C) maximum for 2-8 hours before printing could also help with decreasing the amount of stringing and oozing.

Thoroughly Clean the Hot – End and Purge in Between Print Jobs

Storage

Make sure to properly store your materials when you are not using them.

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Documents / Resources

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References

- User Manual