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IWECOLOR IWECOLOR

IWECOLOR 3D Printer Filament User Manual

Model: IWECOLOR 1.75mm PLA Dual Color Filament

1. PRODUCT OVERVIEW

The IWECOLOR 1.75mm PLA Dual Color Filament is a high-quality 3D printing material designed for FDM (Fused Deposition Modeling) printers. This filament features a unique silk metallic finish with a captivating blue and green color shift, offering an amazing visual effect from different angles. It is engineered for reliable performance, ensuring smooth printing with excellent dimensional accuracy.

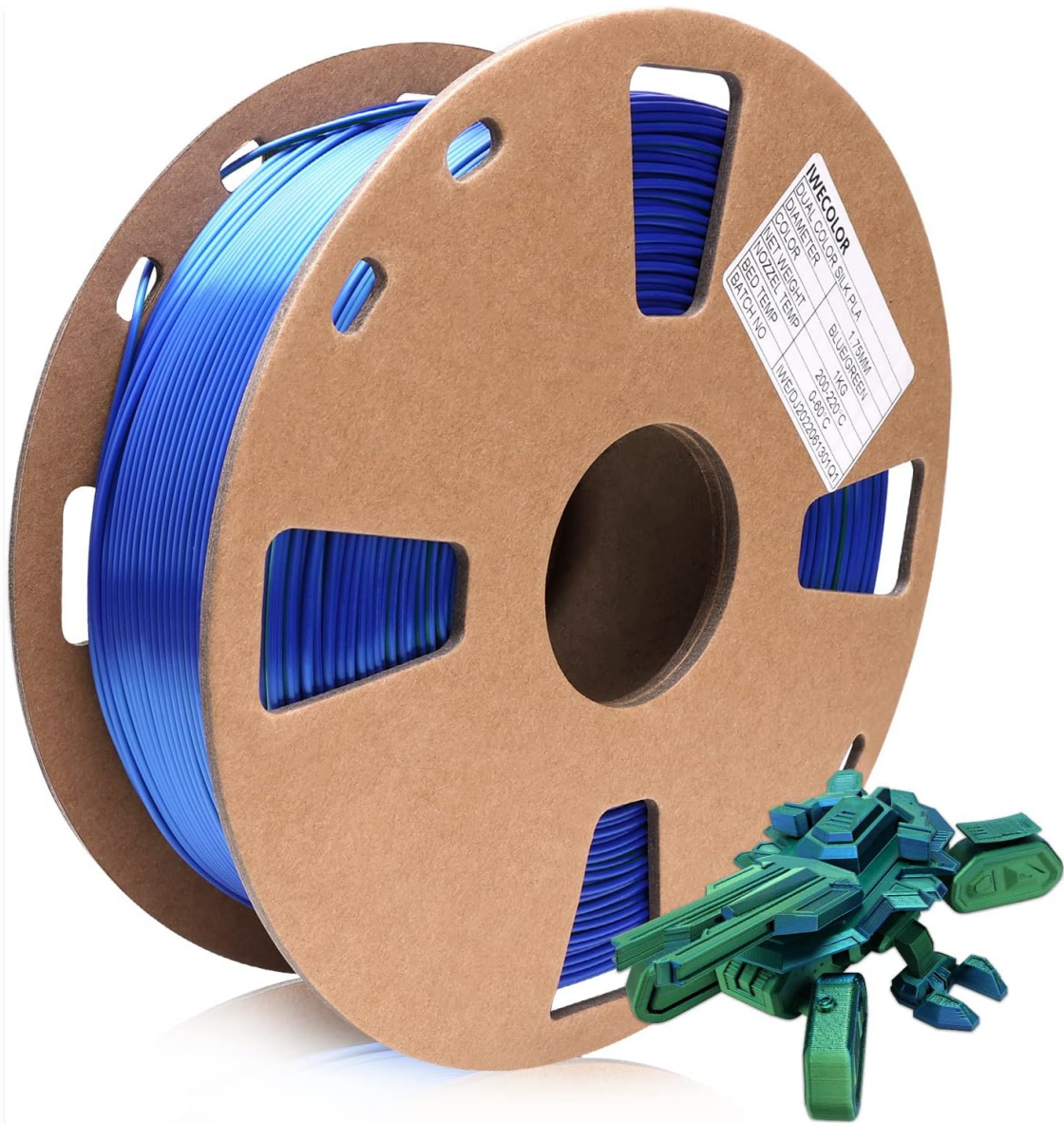


Image: A spool of IWECOLOR blue and green dual-color PLA filament, showcasing its unique color blend, alongside a small 3D printed model.

2. SETUP AND PREPARATION

Proper setup and preparation are crucial for successful 3D printing. Follow these guidelines to ensure optimal results with your IWECOLOR PLA filament.

2.1 Unpackaging the Filament

The filament is vacuum-sealed with desiccant to prevent moisture absorption. Carefully open the packaging just before use. It undergoes a 24-hour drying process before vacuum packaging to ensure it is bubble-free.

2.2 Loading the Filament

1. Ensure your 3D printer's hot end is preheated to the recommended temperature for PLA.
2. Feed the filament into the extruder mechanism according to your printer's instructions. The filament is designed to be tangle-free due to automatic winding and strict manual inspection.
3. Push the filament through until it extrudes smoothly from the nozzle, free of air bubbles or

inconsistencies.

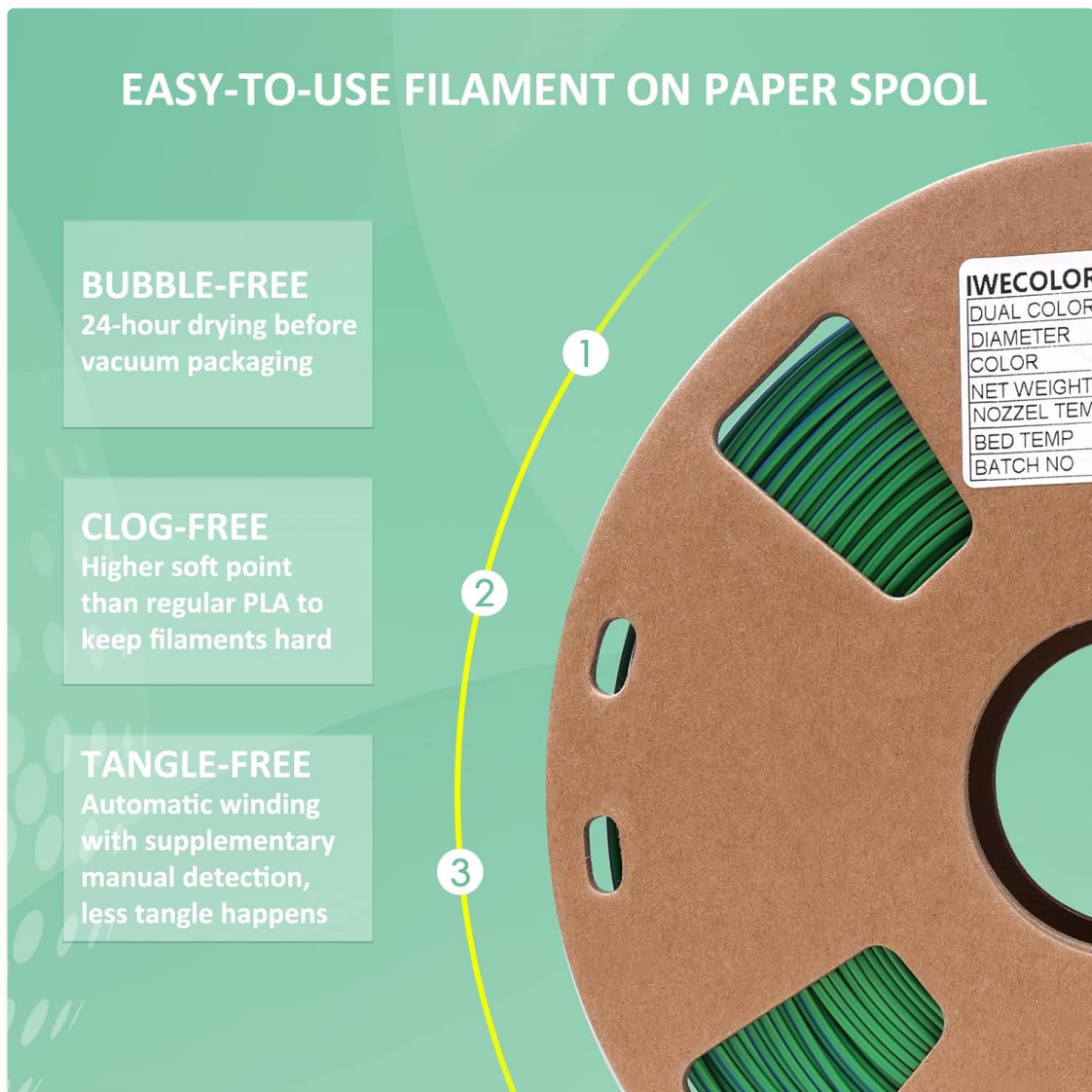


Image: A close-up of the filament spool highlighting key features such as bubble-free, clog-free, and tangle-free properties, ensuring ease of use.

3. OPERATING PARAMETERS

For optimal printing results, adhere to the following recommended operating temperatures and settings.

3.1 Temperature Settings

- **Nozzle Temperature:** 200-220°C. Start with 210°C and adjust based on your printer and specific print requirements.
- **Bed Temperature:** 0-60°C. A heated bed is not strictly necessary for PLA but can improve adhesion. If using a heated bed, 50-60°C is generally sufficient.

3.2 Printing Speed

Typical printing speeds for PLA range from 40-80 mm/s. Experiment to find the best speed for your printer and desired print quality. Slower speeds generally yield higher detail and better surface finish.

3.3 Adhesion

Ensure your print bed is clean and level. Adhesion aids like glue stick, painter's tape, or specialized print surfaces can be used to prevent warping and improve first layer adhesion.

1 Contents **2 Shrinkwrap** **3 Sturdy box**

PERFECT SPOOL SIZE FOR 99% FDM 3D PRINTERS

Diameter is measured in both axes by CCD in high frequency to guarantee the maximum precision and best possible circularity

98% Probability + 0.02 mm Average Diameter Accuracy

IWECOLOR	
DUAL COLOR SILK PLA	
DIAMETER	1.75MM
COLOR	BLUE/GREEN
NET WEIGHT	1KG
NOZZEL TEMP	200-220°C
BED TEMP	0-60°C
BATCH NO	IWE/DJ2022061301Q1

Image: A detailed view of the filament spool, emphasizing its perfect size for FDM 3D printers and displaying recommended nozzle and bed temperatures for optimal printing.

4. MAINTENANCE AND STORAGE

Proper maintenance and storage of your filament will extend its lifespan and ensure consistent print quality.

4.1 Storage

PLA filament is hygroscopic, meaning it absorbs moisture from the air. Store unused filament in a cool, dry place, preferably in its original vacuum-sealed bag or an airtight container with desiccant packets. This prevents moisture absorption, which can lead to printing issues like bubbling, stringing, and reduced print quality.

4.2 Drying Filament

If your filament has absorbed moisture, you may notice popping sounds during printing, excessive stringing, or poor layer adhesion. You can dry PLA filament by baking it in a conventional oven at 40-45°C (104-113°F) for 4-6 hours, or by using a dedicated filament dryer.

5. TROUBLESHOOTING

Here are some common issues you might encounter and their potential solutions.

- **Poor Layer Adhesion:**
 - Increase nozzle temperature slightly.
 - Reduce print speed.
 - Ensure proper bed adhesion and leveling.
- **Stringing/Oozing:**
 - Increase retraction distance and speed in your slicer settings.
 - Decrease nozzle temperature slightly.
 - Ensure filament is dry.
- **Clogging:**
 - Check for debris in the nozzle. Perform a cold pull or clean the nozzle.
 - Ensure filament is dry and free of contaminants. The filament has a higher soft point to help prevent clogs.
 - Verify correct printing temperature.
- **Warping:**
 - Improve bed adhesion (e.g., use glue stick, increase bed temperature if applicable).
 - Ensure consistent ambient temperature around the printer, avoiding drafts.
 - The filament is designed for less warping.
- **Bubbles/Popping Sounds During Printing:**
 - This indicates moisture in the filament. Dry the filament as described in the Maintenance section.

RELIABLE FILAMENTS FOR YOUR 3D PRINTS OR PROJECTS



ISO 9001 2015
Quality Control



Consistent Color



Less Warping



Less Stringing



No Bubble



Smooth Printing



Image: An infographic illustrating the reliability of IWECOLOR filaments, highlighting features such as ISO 9001 certification, consistent color, reduced warping, less stringing, no bubbles, and smooth printing.

6. SPECIFICATIONS

Attribute	Value
Material	Polylactic Acid (PLA)
Color	Blue & Green (Dual Color, Silk Metallic)
Diameter	1.75 mm
Dimensional Accuracy	+/- 0.02 mm
Net Weight	1 KG (2.2 lbs)
Recommended Nozzle Temp.	200-220°C
Recommended Bed Temp.	0-60°C

Attribute	Value
Spool Dimensions (approx.)	7.9 x 2.3 x 7.9 inches



Image: A collage displaying various spools of IWECOLOR dual-color filament in different shades, alongside examples of intricate 3D printed objects such as astronauts, owls, and boats, demonstrating the filament's versatility.

7. WARRANTY AND SUPPORT

Information regarding product warranty and customer support for IWECOLOR 3D Printer Filament is not available in the provided product data. Please refer to the seller's or manufacturer's official website for the most up-to-date warranty terms and support contact information.



Image: A collage showing various individuals engaged in 3D printing activities, illustrating the practical application of filament in different settings.

8. PRODUCTION PROCESS

IWECOLOR filaments are produced with a focus on quality and consistency, from raw materials to final packaging.

- **Premium Raw Materials:** Only high-quality raw materials are selected for filament production.
- **Filament Extrusion:** The raw materials are extruded into filament form.
- **Precise Diameter and Circularity:** Advanced measuring systems ensure strict tolerances and consistent diameter (± 0.02 mm).
- **Automatic Spooling:** Filaments are automatically spooled to prevent tangles.
- **Vacuumed with Desiccants:** Each spool is vacuum-sealed with desiccant to protect against moisture.
- **Packaging and Batch No.:** Products are carefully packaged with batch numbers for quality control.

INTRODUCING PRODUCTION PROCESS

Premium Raw Materials



Filaments Extrusion



Precise Diameter and Circularity



Automatic Spooling



Vacuumed with Desiccants



Packaging and Batch No.



Image: An infographic illustrating the meticulous production process of IWECOLOR filament, from premium raw materials to precise extrusion, automatic spooling, and final vacuum packaging.