

Sovol SILK PLA-Gold & Green & Rose

Sovol PLA Silk Tri-Color Filament Instruction Manual

Model: SILK PLA-Gold & Green & Rose

1. PRODUCT OVERVIEW

The Sovol PLA Silk Tri-Color Filament is a premium 1.75mm 3D printer filament designed for creating prints with a unique multi-color, pearlescent, and shiny finish. This filament features a co-extrusion of three distinct colors (Gold, Green, and Rose Red) along its length, allowing for dynamic color shifts in your printed objects depending on the viewing angle and model geometry.

Key Features:

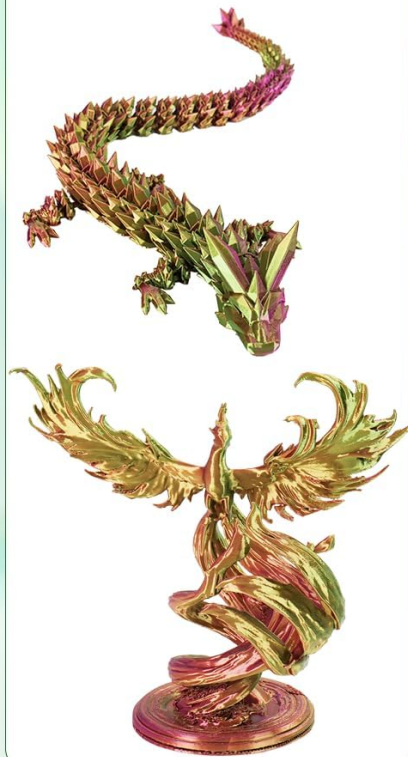
- **Tri-Color Co-extrusion:** Each segment of the filament is composed of Gold, Green, and Rose Red, providing a vibrant, color-blending effect even on small prints.
- **High-Quality PLA Material:** Manufactured from imported raw materials, ensuring a charming gloss, smooth extrusion, and consistent diameter.
- **Optimized Printing Performance:** Engineered to minimize common printing issues such as jamming, bubbles, tangling, and layer lines. Offers excellent first layer adhesion to reduce warping, shrinkage, and curling.
- **Precise Diameter Tolerance:** With a diameter tolerance of +/- 0.03mm, this filament promotes a smoother and more reliable 3D printing experience.
- **Eco-Friendly Packaging:** Utilizes cardboard spools and packaging, reducing plastic waste. Filament is vacuum-packed with desiccant for optimal dryness.
- **Universal Compatibility:** Suitable for use with most FDM 3D printers and 3D pens that support 1.75mm PLA filament.



This image displays a spool of Sovol Silk Tri-Color PLA Filament (Gold, Green, Rose Red) alongside a complex 3D printed dragon model, showcasing the filament's unique color blend and shiny finish.

Sovol Triple Colors Filaments

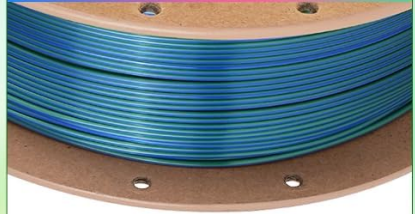
Triple Color/Gold, Green, Rose Red



Triple Color/Blue, Green, Orange



Triple Color/Dark Red, Green, Blue



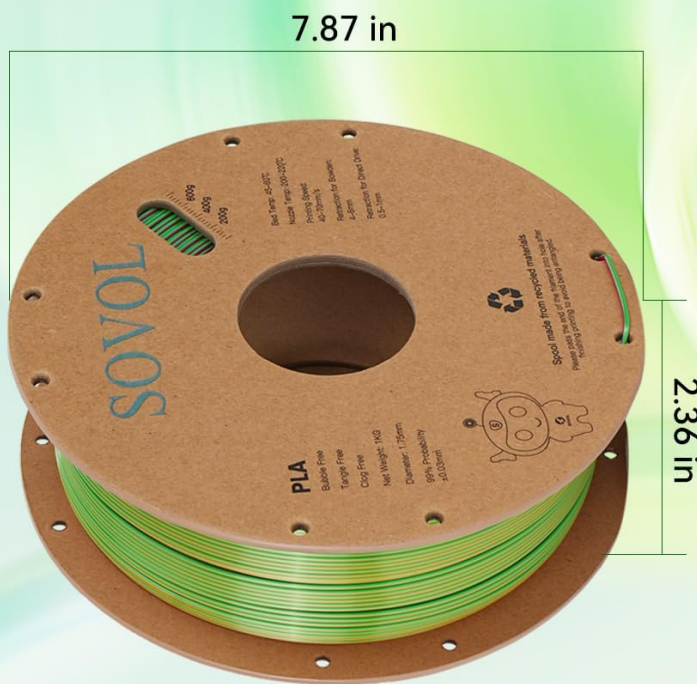
This image illustrates the variety of Sovol's triple-color co-extruded filaments, featuring spools in Gold/Green/Rose Red, Blue/Green/Orange, and Dark Red/Green/Blue, each accompanied by intricate 3D printed models that highlight the distinct color transitions.

2. SPECIFICATIONS

Parameter	Value
Material	Polylactic Acid (PLA)
Color	Gold Green Rose (Tri-Color Co-Extrusion)
Item Diameter	1.75 mm
Diameter Tolerance	+/- 0.03 mm

Parameter	Value
Net Weight	1 KG (2.2 lbs)
Recommended Print Temperature	210-230°C
Recommended Print Speed	40-100 mm/s
Melting Point	175-185°C
Recommended Hot Bed Temperature	45-60°C
Retraction for Bowden Extruder	4-6 mm
Retraction for Direct Drive Extruder	0.5-1 mm

Spool Design Suitable for Most of 3D Printer



Sealed Storage



Sturdy Package

This image illustrates the dimensions of the Sovol filament spool and details its sturdy, vacuum-sealed packaging designed to maintain filament quality.

3. SETUP AND LOADING

Unpacking the Filament:

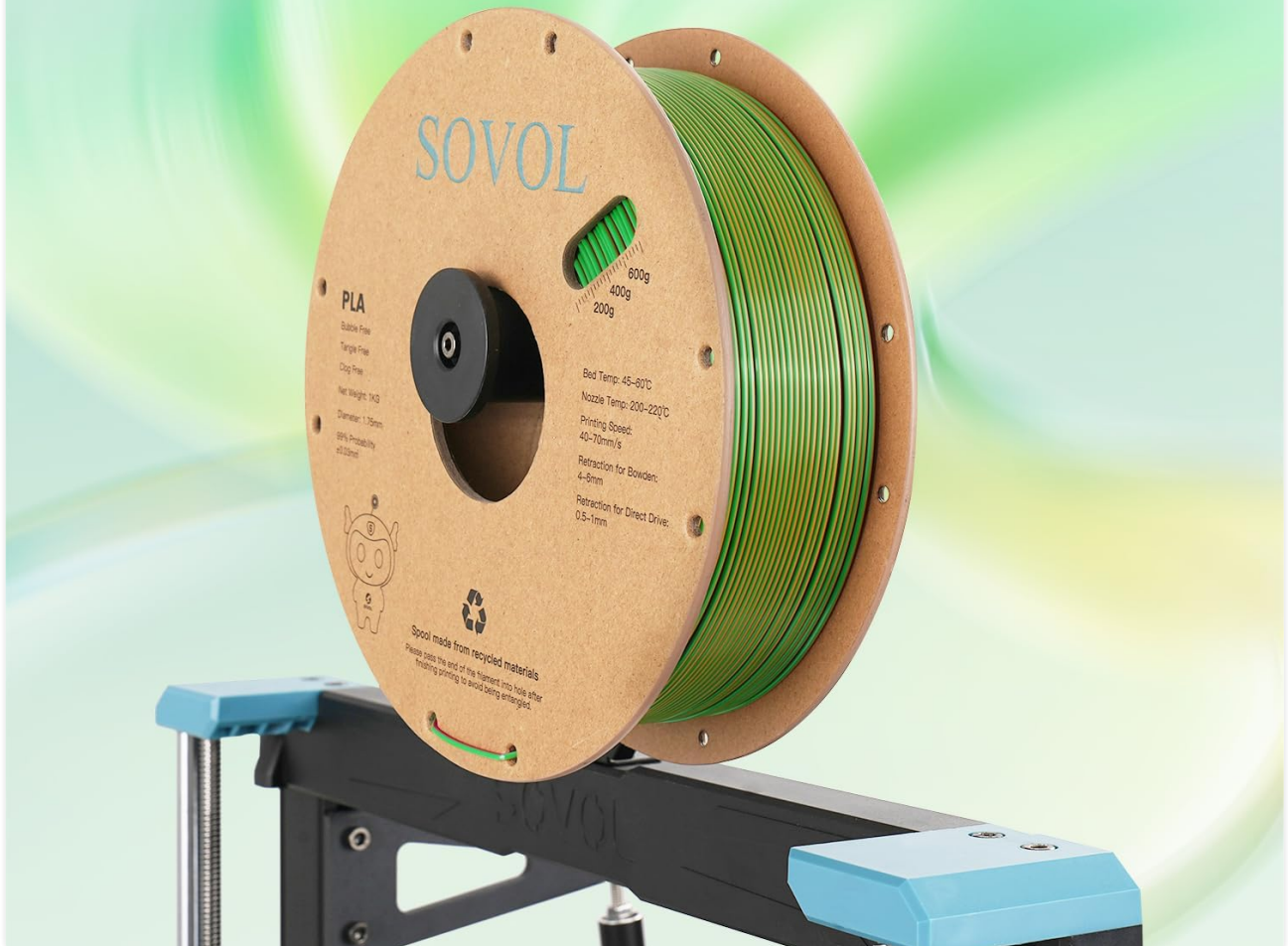
1. Carefully open the cardboard packaging.
2. Remove the vacuum-sealed bag containing the filament spool.
3. Open the vacuum-sealed bag and remove the desiccant packet. Keep the desiccant for future storage.
4. Unwind the end of the filament from the spool, ensuring it is not tangled.

Loading Filament into Your 3D Printer:

1. Mount the filament spool onto your 3D printer's spool holder. Ensure the spool can rotate freely.
2. Feed the filament into the extruder mechanism according to your printer's specific instructions.
3. Preheat your printer's hot end to the recommended PLA temperature (210-230°C).
4. Once heated, manually extrude a small amount of filament to ensure it flows smoothly and is free of any clogs or air bubbles.

No Jam and less tangled

Reasonable and precise design of spool ensures continuous input and output of filament.



This image shows a spool of Sovol PLA filament correctly mounted on a 3D printer, emphasizing its precise winding which helps prevent tangles and ensures continuous, jam-free filament feeding during the printing process.

4. OPERATING INSTRUCTIONS

Recommended Printing Parameters:

- **Nozzle Temperature:** 210-230°C (Start at 215°C and adjust as needed for your specific printer and desired finish).
- **Hot Bed Temperature:** 45-60°C (A heated bed is recommended for optimal adhesion and to prevent warping).
- **Print Speed:** 40-100 mm/s (Adjust based on model complexity and printer capabilities. Slower speeds often yield better detail and surface finish).
- **Retraction Settings:**
 - Bowden Extruder: 4-6 mm

- Direct Drive Extruder: 0.5-1 mm
- **First Layer Adhesion:** Ensure proper bed leveling and use an adhesive (e.g., glue stick, hairspray) if necessary to prevent the first layer from detaching.

Achieving Optimal Prints:

The unique tri-color co-extrusion of this filament means the visible color of your print will change based on the orientation of the filament during extrusion. Experiment with model orientation and print settings to achieve desired color transitions and effects. The silk finish provides a pearlescent and glossy appearance, enhancing the visual appeal of your creations.



A detailed 3D printed phoenix model, exhibiting a smooth, shiny, and multi-colored surface, is shown on a 3D printer's build plate. This illustrates the filament's ability to produce high-quality prints free from common issues like nozzle clogging or warping.

5. MAINTENANCE AND STORAGE

Proper Storage:

To maintain the quality and performance of your Sovol PLA Silk Tri-Color Filament, proper storage is crucial. PLA can absorb moisture from the air, which can lead to printing issues.

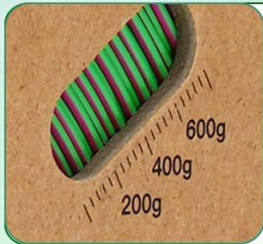
- Always store unused filament in a cool, dry place.
- Place the filament spool back into its original vacuum-sealed bag with the desiccant packet.
- If the original bag is damaged, use an airtight container or a resealable bag with fresh desiccant.
- Avoid exposing filament to direct sunlight or high humidity environments.

Drying Filament:

If your filament has absorbed moisture and exhibits signs like popping sounds during extrusion, stringing, or poor layer adhesion, it may need to be dried.

- Use a dedicated filament dryer set to a low temperature (e.g., 45-50°C for PLA) for several hours.
- Alternatively, a conventional oven can be used at a very low temperature (e.g., 40-45°C) for 4-6 hours, ensuring the temperature is stable and does not exceed the filament's glass transition temperature.
- Always monitor the filament during drying to prevent overheating or damage.

Easy to Operate And Store



Weight Scale

You can clearly see how much you have used

Winding Hole

You don't worry about messy thread



A close-up view of the Sovol filament spool reveals practical features such as a weight scale to monitor remaining filament and a winding hole designed to secure the filament end, preventing tangles and simplifying storage.

6. TROUBLESHOOTING COMMON ISSUES

Below are common issues encountered during 3D printing with filament and potential solutions:

• Nozzle Clogging:

- Ensure proper print temperature.
- Check for debris in the nozzle; perform a cold pull or clean the nozzle.
- Verify filament diameter consistency.

• Warping or Poor Bed Adhesion:

- Level the print bed correctly.
- Increase hot bed temperature within recommended range (45-60°C).



- Apply a bed adhesive (e.g., glue stick, hairspray).
- Ensure the printing environment is free from drafts.
- **Stringing or Oozing:**
 - Optimize retraction settings (distance and speed).
 - Reduce print temperature slightly.
 - Ensure filament is dry.
- **Brittle Filament / Popping Sounds:**
 - These are strong indicators of moisture absorption. Refer to the "Drying Filament" section under Maintenance and Storage.
- **Layer Separation / Weak Layers:**
 - Increase print temperature slightly to improve layer bonding.
 - Reduce print speed.
 - Check for partial clogs in the nozzle.

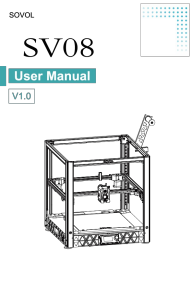



7. CUSTOMER SUPPORT

For any questions, concerns, or technical assistance regarding your Sovol PLA Silk Tri-Color Filament, please refer to the official Sovol support channels or contact your retailer. We are committed to providing support to ensure your satisfaction with our products.

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Related Documents - SILK PLA-Gold & Green & Rose

	<p>Sovol SV06 Plus 3D Printer Leveling Guide and Printing Tips</p> <p>A comprehensive guide to leveling the Sovol SV06 Plus 3D printer, including detailed steps, Z-axis offset adjustments, auto leveling procedures, and essential printing tips for high-temperature filaments and retraction settings.</p>
	<p>Sovol SV08 3D Printer User Manual: Setup, Assembly, and Operation Guide</p> <p>Comprehensive user manual for the Sovol SV08 3D printer. Learn about assembly, setup, calibration, printing, WiFi connection, Obico integration, and mainboard details.</p>

 The image shows the cover of the Sovol SV08 3D Printer User Manual. It features the Sovol logo at the top left, the model name 'SV08' in large bold letters, and 'User Manual' and 'V1.0' in smaller text. A technical line drawing of the printer is on the right.	<p>Sovol SV08 3D Printer User Manual</p> <p>Comprehensive user manual for the Sovol SV08 3D printer, covering setup, operation, maintenance, and troubleshooting. Learn how to get the most out of your Sovol SV08.</p>
 The image shows the cover of the SOVOL SV02 3D Printer User Guide and Assembly Instructions. It features the Sovol logo, the model name 'SOVOL SV02 Printer', and a list of features including 'Compatible for 1.75mm filament', 'Max. printing volume: 125x125x125mm', and 'Max. printing speed: 100mm/s'. A small image of the printer is also present.	<p>SOVOL SV02 3D Printer User Guide and Assembly Instructions</p> <p>Comprehensive guidebook for assembling, setting up, and operating the SOVOL SV02 3D printer. Includes sections on components, installation, software, printing, and after-sales service.</p>
 The image shows the cover of the Sovol SV07 Plus User Manual. It features the Sovol logo, the model name 'SV07 PLUS' in large bold letters, and 'User Manual'. A photograph of the printer is on the right.	<p>Sovol SV07 Plus User Manual: Setup, Operation, and Troubleshooting</p> <p>Comprehensive user manual for the Sovol SV07 Plus 3D printer, covering assembly, setup, operation, maintenance, and troubleshooting for optimal printing performance.</p>
 The image shows the cover of the Sovol SV04 Extruder Leveling Knob Troubleshooting Guide. It features a photograph of the extruder assembly with a red arrow pointing to the leveling knob. The title 'Sovol SV04 Extruder Leveling Knob Troubleshooting Guide' is at the top.	<p>Sovol SV04 Extruder Leveling Knob Troubleshooting Guide</p> <p>A comprehensive guide to troubleshooting and resolving issues with the extruder leveling knob on the Sovol SV04 IDEX 3D printer, covering common problems like stiffness and incorrect slider plate adjustment.</p>