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› [ELEGOO PLA Basic Refill Filament 1.75mm Instruction Manual](#)

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1. PRODUCT OVERVIEW

The ELEGOO PLA Basic Refill Filament is designed for 3D printing, offering a sustainable and high-quality material solution. This filament is compatible with various reusable spools, including those from ELEGOO, Bambu Lab, and eSun, allowing for reduced plastic waste and a lower carbon footprint. Made from pure premium PLA, it features a 1.75mm diameter with a dimensional accuracy of $\pm 0.02\text{mm}$, ensuring consistent feeding and reliable print quality.



Image 1.1: Overview of refill design, vacuum sealing, and neat winding to prevent tangles.

Compatible with 99% 1.75mm FDM 3D Printers



Image 1.2: Compatibility with standard reusable spools and various FDM 3D printers.

2. SETUP AND INSTALLATION

To use the ELEGOO PLA Basic Refill Filament, it must be loaded onto a compatible reusable spool. Follow these steps for proper installation:

- 1. Separate the Spool Halves:** If using a two-part reusable spool, carefully separate the two halves.
- 2. Prepare the Refill:** Keep the plastic straps on the refill filament until it is securely placed within the spool. This prevents tangling.
- 3. Load the Filament:** Align the refill filament with the central core of one spool half. Ensure the filament is seated correctly.
- 4. Assemble the Spool:** Place the second spool half over the filament, aligning any notches or locking mechanisms. Press firmly until the spool halves click into place, securing the filament.
- 5. Remove Straps:** Once the filament is fully secured within the assembled reusable spool, carefully remove the plastic retaining straps.

Effortless Assembly, Start Printing Instantly

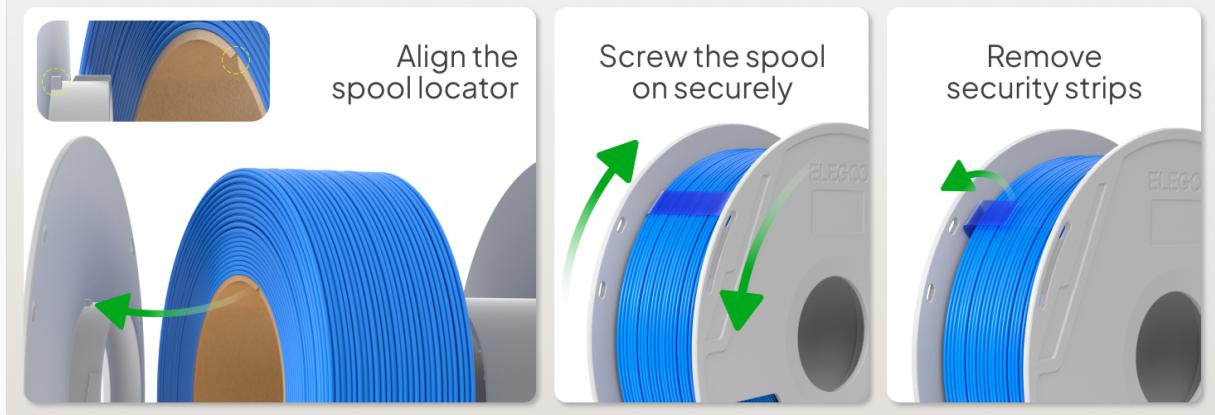


Image 2.1: Visual guide for effortless assembly of the refill filament onto a reusable spool.

Your browser does not support the video tag.

Video 2.1: A tutorial demonstrating the removal and installation process for reusable spools with refill filament.

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Video 2.2: An unboxing and assembly guide for refill PLA filament, highlighting recyclable packaging.

3. RECOMMENDED PRINTING PARAMETERS

For optimal printing results with ELEGOO PLA Basic Refill Filament, consider the following parameters. These are general guidelines and may require slight adjustments based on your specific 3D printer model and environmental conditions.

- **Nozzle Temperature:** 190 - 230 °C
- **Bed Temperature:** 35 - 65 °C
- **Printing Speed:** < 270 mm/s



Image 3.1: Recommended printing temperatures and speed for ELEGOO PLA filament.

4. STORAGE AND MAINTENANCE

Proper storage of your ELEGOO PLA Basic Refill Filament is crucial for maintaining its quality and ensuring consistent print performance. PLA is hygroscopic, meaning it can absorb moisture from the air, which can lead to printing issues.

- **Keep Dry:** Always store unused filament in a dry, cool place. The filament is dried before packing and vacuum-sealed to protect it from moisture.
- **Vacuum Seal:** After opening, if you do not use the entire refill, store it in an airtight container or a resealable vacuum bag with desiccant packets to prevent moisture absorption.
- **Prevent Tangles:** The filament is neatly wound to minimize tangles. When handling, ensure the end of the filament is secured to prevent it from unwinding and creating knots.

5. TROUBLESHOOTING COMMON ISSUES

While ELEGOO PLA Basic Refill Filament is designed for ease of use, occasional printing issues may arise. Here are some common problems and potential solutions:

- **Bubbles or Stringing:** This often indicates moisture absorption. Ensure your filament is properly dried and stored in a low-humidity environment. Consider using a filament dryer if you suspect moisture.
- **Clogging:** Clogging can be caused by various factors, including incorrect nozzle temperature, dust on the filament, or heat creep. Verify your nozzle temperature is within the recommended range (190-230 °C) and ensure the filament path is clear.
- **Poor Layer Adhesion:** Check your bed temperature (35-65 °C) and ensure your print bed is clean and properly leveled. Adjusting the initial layer height or using an adhesive can also help.

- **Warping:** Warping occurs when the print cools unevenly. Ensure your print bed temperature is appropriate and consider using an enclosure for your printer to maintain a stable printing environment.

6. TECHNICAL SPECIFICATIONS

Feature	Specification
Material	Polylactic Acid (PLA)
Diameter	1.75 Millimeters
Dimensional Accuracy	±0.02mm
Weight	1kg per spool (4.46 Kilograms total for 4-pack)
Recommended Nozzle Temp	190 - 230 °C
Recommended Bed Temp	35 - 65 °C
Color	Yellow, Pink, Purple, Turquoise Green

7. WARRANTY AND SUPPORT

For any inquiries, technical support, or warranty information regarding your ELEGOO PLA Basic Refill Filament, please contact ELEGOO customer service. You can find contact details on the official ELEGOO website or through your purchase platform.

We are committed to providing high-quality products and support to ensure your satisfaction with ELEGOO products.