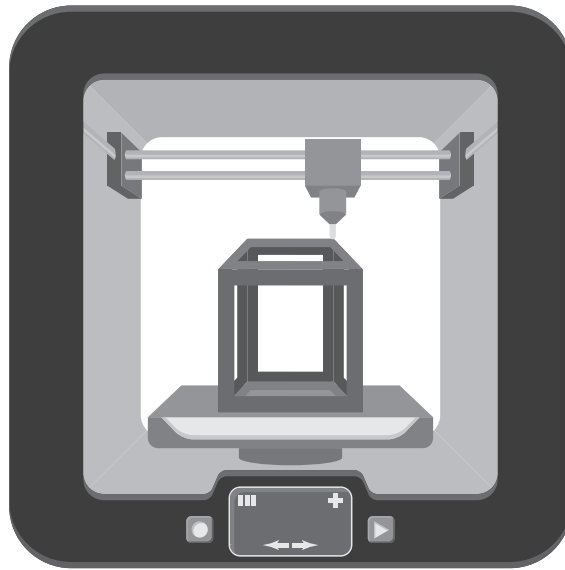


amazonbasics



3D Printer Filament

Filament d'Imprimante 3D

3D-Drucker-Faden

Filamento per Stampante 3D

Filamento para Impresora 3D

3D Printerfilament

3D プリンター用フィラメント

English	3
Français	7
Deutsch	11
Italiano	15
Español	19
Nederlands	23
日本語.....	27

**B07T2QZSLY, B07SZLYHTW, B07T6W8TRF, B07T2QZSM5, B07T6X348M, B07SZLZ2WD,
 B07SZLZ43X, B07SZLZ1ZD, B07T4X57Q1, B07T6WLFML, B07SZLYWS2, B07T2R1BQJ,
 B07T6VTG44, B07T61FVBB, B07SZLYWSN, B07SZLZ218, B07SZLZG26, B07T6VTG4H,
 B07SZLYTBV, B07T6WHW2L, B07SZLZG2P, B07T61HMY4, B07T4X4Y88, B07T2QZYQD,
 B07T61HC3P, B07T4X4Y8L, B07SZLZ2YD, B07SZLZG3L, B07S2ZXM97, B07S571G2L,
 B07RZTF5Q7, B07S48YLWW, B07RZTF5QB, B07RZTF5QF, B07S2ZW2V5, B07T616NXL,
 B07T6VTG5Q, B07SZLZ7TY, B07T6VTG61, B07T4X4D2C, B07T61GPBG, B07T2QZYS1,
 B07T2QZYS5, B07T61FVF1, B07T6W63MY, B07T1QD5WW, B07T61CXWN, B07T6WMYWV,
 B07T616NYT, B07T61GZMN, B07T4X4RQH, B07SZLZ241, B07SZLZG5G**



IMPORTANT SAFEGUARDS



Read these instructions carefully and retain them for future use. If this product is passed to a third party, then these instructions must be included.

When using the product, basic safety precautions should always be followed to reduce the risk of injury including the following:

- Thin layers or layers with random dots or holes when making a print could indicate under-extrusion. This means that your printer cannot supply the correct amount of material needed to print a layer. This can be caused by debris or carbonized plastic that sticks in the nozzle which may occur if the nozzle has been heating up without extruding any filament.
- When you insert the filament into the printer, make sure your hands are not slippery as this may cause you to let go of the filament and release the tension.
- When the print is finished, remove the filament from the printer but make sure to keep the tension on the spools so it does not accidentally unwind.
- Should you find or notice an entanglement or a knot, hold the spool horizontally and unwind until the knot is removed. Then rewind the spool using a decent amount of tension on the filament.
- Always lock the filament in the small holes in the sides of the spools and make sure that it cannot come loose.

Before First Use

- Check the product for transport damages.

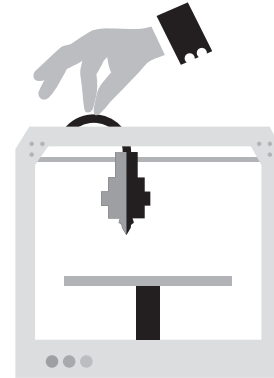
⚠ DANGER Risk of suffocation! Keep any packaging materials away from children – these materials are a potential source of danger, e.g. suffocation.





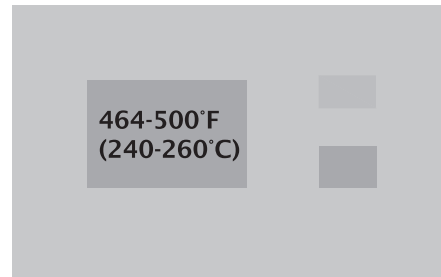
Before Printing, do a Full Cold-Pull Procedure and Follow the Steps:

1. Make sure you have good access to the hot end. For Bowden-type extruders, this might mean that you need to unplug the guide tube.

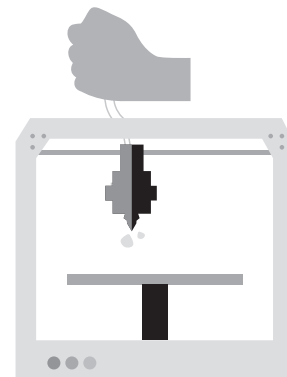


2. Heat the nozzle to around 464-500°F (240-260°C). If you have only printed with PLA, heat the nozzle to around the 428 °F (220 °C).

⚠ CAUTION Risk of burns! Do not touch the bed or the tip of the nozzle with your fingers. Those parts get very hot.

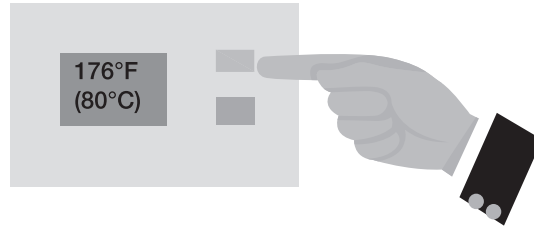


3. Insert a piece of white/bright nylon or a glow-in-the-dark – a strong filament. Push it down hard by hand. If there is some filament coming out of the nozzle, then keep pushing.

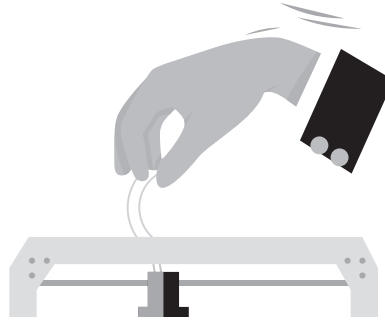




4. Stop the heater and let the printer cool down to around 176 °F (80 °C) for PLA. Keep pushing until strong resistance is felt.



5. When the printer has cooled down, pull back the filament out of the hot end and inspect the semi-molten end. This should have some dirt and impurities on it. If you have difficulties, slightly increase the temperature by 41 °F (5 °C).



6. Cut away the dirty part of the filament and repeat from step 2 until your filament comes out clean.



Bed and Storage Temperature

Because AmazonBasics filament is known as a low-warping material, processing does not require a closed pressure chamber. (For ABS this is still advised.) For more adhesion on the print bed, you can brush it with an adhesion stick or spray with hair spray.

NOTICE The optimal printing and bed temperatures are located on the spool label!



Feedback and Help

Love it? Hate it? Let us know with a customer review.

AmazonBasics is committed to delivering customer-driven products that live up to your high standards. We encourage you to write a review sharing your experiences with the product.



US: amazon.com/review/review-your-purchases#

UK: amazon.co.uk/review/review-your-purchases#



US: amazon.com/gp/help/customer/contact-us

UK: amazon.co.uk/gp/help/customer/contact-us

amazonbasics

amazon.com/AmazonBasics

MADE IN THE NETHERLANDS

FABRIQUÉ AUX PAYS-BAS

HERGESTELLT IN DEN NIEDERLANDEN

PRODOTTO NEI PAESI BASSI

HECHO EN LOS PAÍSES BAJOS

GEMAAKT IN NEDERLAND

オランダ製

V01-08/19