

snapmaker

PLA Translucent User Guide

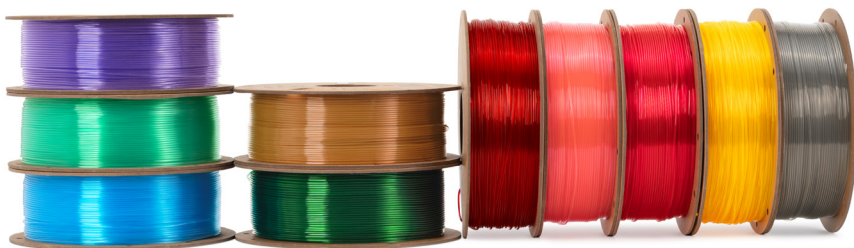


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Snapmaker PLA Translucent is a printing filament compatible with the full range of Snapmaker 3D printers and most mainstream FDM (Fused Deposition Modeling) 3D printers on the market. This guide covers the filament's technical specifications, usage procedure, storage instructions, common issues and troubleshooting, and safety precautions.

1 Product Overview

Snapmaker PLA Translucent is a translucent filament designed for lighting and visual expression, delivering soft, uniform light diffusion that gives prints a frosted glass-like appearance under illumination. It retains PLA's easy-to-print nature, ensuring high success rates even for beginners, while its optimized formulation reduces stringing for a smooth, refined surface. Available in a variety of vibrant translucent colors, it meets diverse creative needs. Compared to standard PLA, this material is ideal for applications where both aesthetics and light effects are critical.



2 Specifications

Subjects	Data
Diameter	1.75 mm $\pm$ 0.03 mm
Net Filament Weight	1 kg
Length	337 m
Spool Material	Cardboard Spool
Spool Size	Diameter: 200 mm; Height: 66 mm

Recommended Printing Settings

Subjects	Data
Drying Settings Before Printing	50°C for 6 h
Printing and Storage Humidity	< 20% RH (Sealed, with Desiccant)
Nozzle Size	0.2 / 0.4 / 0.6 / 0.8 mm
Nozzle Temperature	190–230°C
Bed Type	Textured PEI Plate, Smooth PEI Plate, Graphic Effect Steel Plate (Carbon-Fiber Textured)
Bed Surface Preparation	Glue
Bed Temperature	35–70°C
Cooling Fan	ON
Printing Speed	< 200 mm/s
Retraction Length	0.2–0.6 mm
Retraction Speed	20–30 mm/s
Chamber Temperature	25–45°C
Max Overhang Angle	60°
Max Bridging Length	$\leq$ 30 mm
Support Material	PLA

Physical Properties

Subjects	Testing Methods	Data
Density	ISO 1183, GB/T 1033	1.238 ± 0.002 g/cm ³
Melt Index	210°C, 2.16 kg	10.65 ± 0.521 g/10 min
Melting Temperature	DSC, 10°C/min	N/A
Glass Transition Temperature	DSC, 10°C/min	60°C
Decomposition Temperature	TGA, 20°C/min	N/A
Crystallization Temperature	DSC, 10°C/min	N/A
Vicat Softening Temperature	ISO 306, GB/T 1633	62°C
Heat Deflection Temperature	ISO 75, 1.8 MPa	52.9°C
Heat Deflection Temperature	ISO 75, 0.45 MPa	54.3°C
Saturated Water Absorption Rate	23°C, 70% RH	0.41%

Mechanical Properties

Subjects	Testing Methods	Data
Young's Modulus (X-Y)	ISO 527, GB/T 1040	3433.71 ± 67.310 MPa
Young's Modulus (Z)	ISO 527, GB/T 1040	3077.50 ± 49.116 MPa
Tensile Strength (X-Y)	ISO 527, GB/T 1040	54.83 ± 1.357 MPa
Tensile Strength (Z)	ISO 527, GB/T 1040	37.00 ± 0.519 MPa
Breaking Elongation Rate (X-Y)	ISO 527, GB/T 1040	4.71 ± 1.827%
Breaking Elongation Rate (Z)	ISO 527, GB/T 1040	1.76 ± 0.175%
Bending Modulus (X-Y)	ISO 178, GB/T 9341	3295.13 ± 121.030 MPa

(continued)

Bending Modulus (Z)	ISO 178, GB/T 9341	3179.77 ± 117.829 MPa
Bending Strength (X-Y)	ISO 178, GB/T 9341	93.60 ± 0.511 MPa
Bending Strength (Z)	ISO 178, GB/T 9341	64.52 ± 0.349 MPa
Impact Strength (X-Y)	ISO 179, GB/T 1043	17.47 ± 0.615 kJ/m ² 2.82 ± 0.074 kJ/m ² (Notched)
Impact Strength (Z)	ISO 179, GB/T 1043	1.65 ± 0.46 kJ/m ² (Notched)

Other Physical and Chemical Properties

Subjects	Data
Odor	Odorless
Composition	Poly(lactic Acid (PLA)
Skin Hazards	N/A
Chemical Stability	Stable under normal conditions
Solubility	Insoluble in Water
Resistance to Acid	Weak Acids: Good
Resistance to Alkali	Non-Resistant
Resistance to Organic Solvent	Non-Resistant
Resistance to Oil and Grease	Fair
Flammability	Flammable
Combustion Products	Water, Carbon Oxides
Odor of Combustion Products	Odorless

Specimen Printing Conditions

Subjects	Data
Nozzle Temperature	230°C
Bed Temperature	55°C
Printing Speed	50 mm/s
Infill Density	100%



Based on 0.4 mm nozzle. Printing conditions may vary with different nozzle diameters.

Disclaimer

The performance and printing parameters of the aforementioned filaments are obtained by Snapmaker through testing filament samples with sample 3D printers. All data provided is for reference and comparison purposes only, and does not constitute design specifications or any warranty of quality. Actual 3D printing quality and final part performance are subject to various factors including, but not limited to, printer equipment, model design, environmental conditions, and printing parameters. Users shall independently evaluate the compliance and safety of printed models and finished parts, including legal compliance, application safety, and structural reliability. Snapmaker shall not be held liable for any direct or indirect losses arising from the use of the aforementioned filaments, including equipment damage, print failure, personal injury, and property damage.

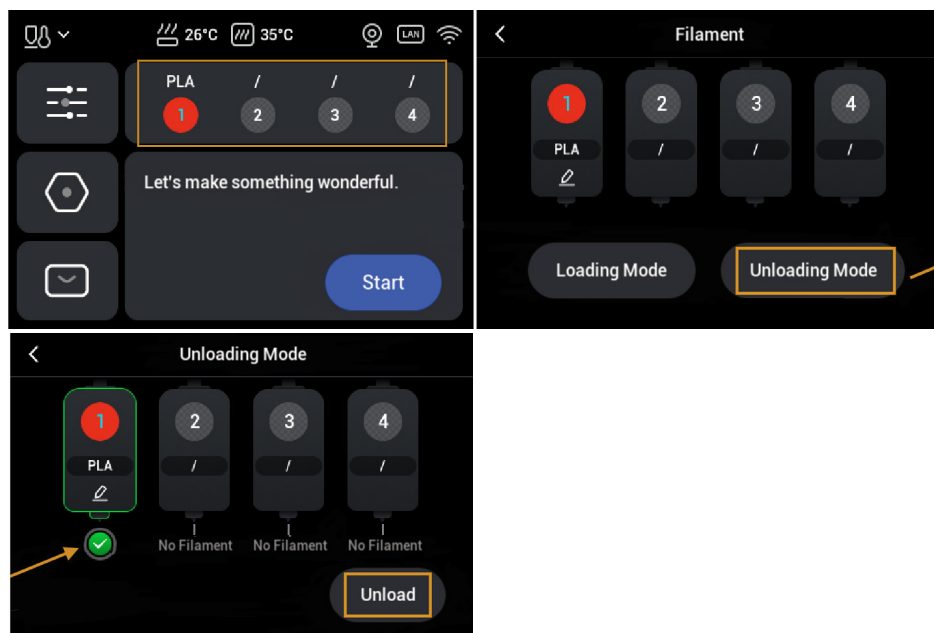
3 Usage Procedure



This section demonstrates the usage procedure using the Snapmaker U1 model.

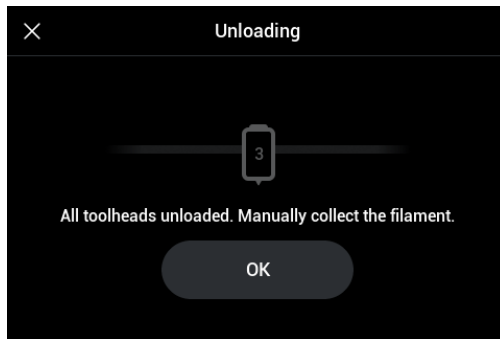
Filament Unloading

1. On the touchscreen main interface, navigate to the Filament page. Tap **Unloading Mode**. Select all toolheads requiring unloading, then tap **Unload**.



2. The printer will extract the selected toolhead and automatically heat the nozzle.

3. Once all unloading is complete, tap **OK**.



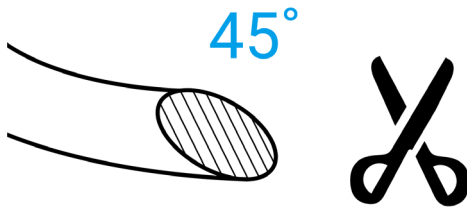
4. Rotate the spool to retract the filament from the tube until it is fully withdrawn.
5. Thread the end of the filament through the two locking holes on the spool to prevent loosening or tangling.



6. Remove the spool from the spool holder.
7. Repeat the steps above until all intended filaments have been successfully retrieved.

Filament Loading

1. Trim the end of the filament to an approximately 45° angle using diagonal pliers.



This reduces feeding resistance and improves loading reliability.

2. Mount the filament spool on the spool holder. Make sure the filament can be pulled tangentially from the bottom of the spool.

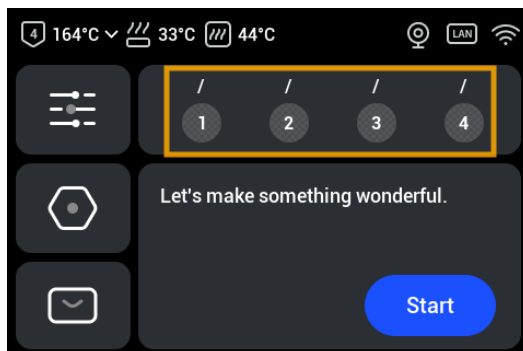


3. Insert the filament into the feeder until the white indicator light turns on.

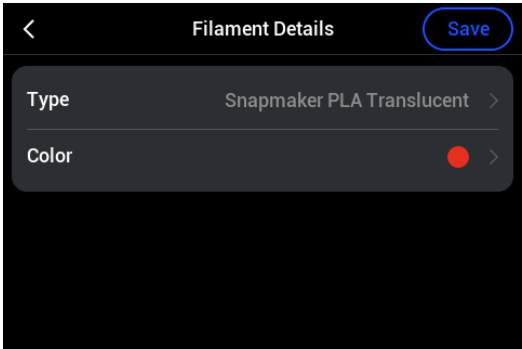


If the feeder's white light is blinking, feeding is still in progress.
If the white light remains steady, pre-loading is complete.

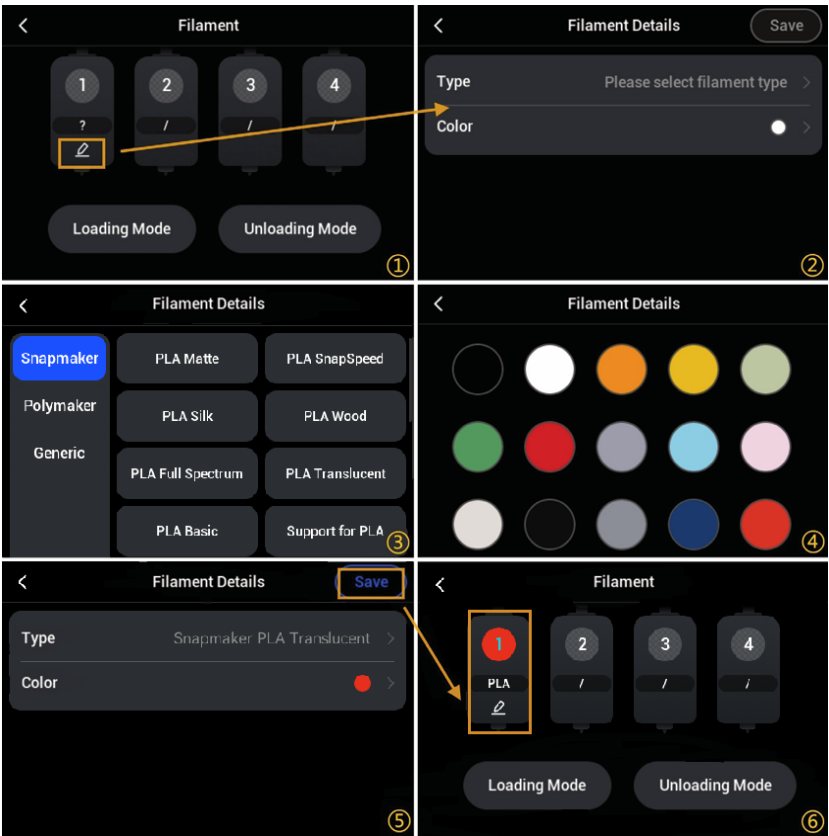
4. On the touchscreen main interface, navigate to the Filament page to edit filament information.



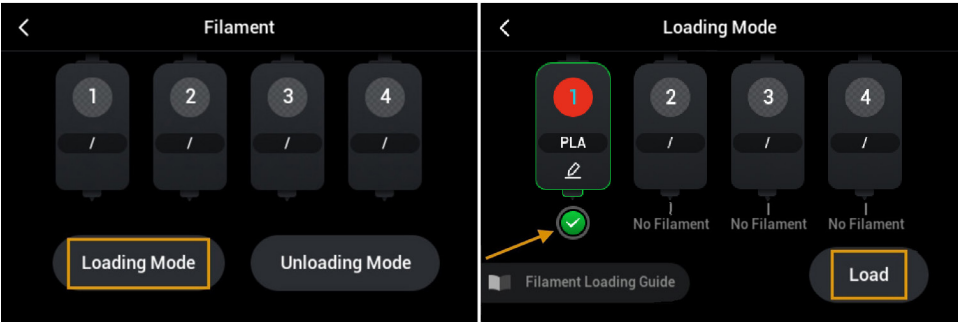
If using RFID-equipped Snapmaker official filament, the device will automatically recognize the filament information; no manual editing is needed.



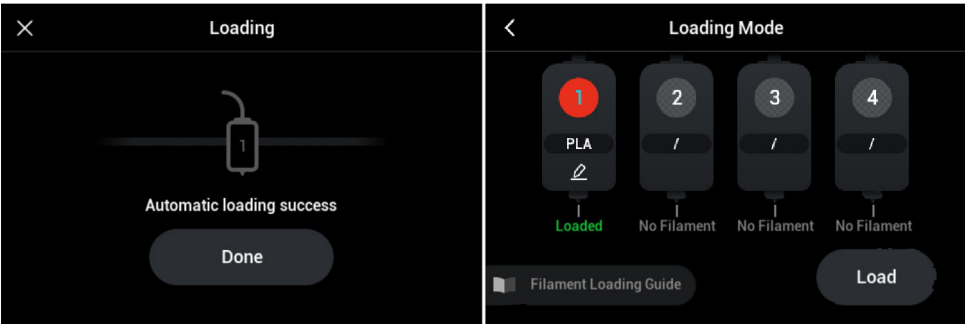
For third-party filament or Snapmaker filament without RFID, manual editing is required. Tap the icon below the corresponding filament, select filament type and color, and tap **Save**.



5. On the Filament page, tap **Loading Mode**, select the corresponding filament, and tap **Load**.



6. The printer will automatically perform the following steps: extract the toolhead, feed filament into the nozzle, heat the nozzle, extrude filament, and cleanse old material from the toolhead. Upon completion, tap **Done** on the screen.



The filament status is now updated to **Loaded**.

Test Print and Final Print

1. Test Print: Before printing a final part, it is recommended to print a small test model (e.g., a 20 mm × 20 mm × 20 mm calibration cube) to verify smooth extrusion, proper formation, and nozzle condition. Proceed to the final print only if no abnormalities are observed.

2. Final Print: Import the model file into the 3D printer and start the printing process. Ensure the filament spool is securely positioned to prevent it from falling off the spool holder during printing, which could disrupt the process.

Printing Tips

1. Drying & Storage

- **Pre-Drying:** PLA Translucent has low moisture sensitivity and generally does not require drying. However, pre-drying is recommended for optimal print results. The recommended setting is 50°C for 6 hours.
- **Storage:** When not in use, keep the filament away from direct sunlight in a sealed container with desiccant.

2. Printing

- **Moisture Troubleshooting:** If you hear popping or crackling sounds during extrusion, accompanied by excessive bubbles on the print surface and reduced translucency, the filament is damp. Please dry it before printing.

- **Achieving Maximum Translucency:** If you want your prints to be highly translucent, you can apply the following *settings*. (*Note: Achieving glass-like transparency is inherently challenging with FDM 3D printing, especially for complex geometries.*)

- **Reduce all speed settings and set them to the same value.** (*Note: This will increase total print time.*)
- **Slightly increase the nozzle temperature.**
- **Slightly lower the layer height.**
- **Slightly increase the Flow Ratio.**
- **Turn off all cooling fans** to prevent uneven shrinkage caused by over-cooling.

- Infill Settings:

- **For shell-like models** (e.g., translucent lampshades): Enable Spiral Vase mode for optimal clarity.
- **For solid models with a certain thickness:** Increase the infill density as needed to reduce light scattering caused by internal gaps. A 100% infill density can further reduce internal gaps but will significantly increase printing time and material consumption.

4 Storage Instructions

The storage environment significantly affects the performance of 3D printing filament. Follow these guidelines to extend the filament's usable life:

1. Storage Environment: PLA softens under prolonged sunlight exposure and is not resistant to water or corrosion. Store PLA filament and printed parts in a dry, cool, well-ventilated area, away from direct sunlight, high temperature, and high humidity (recommended ambient temperature: 5–30°C, humidity $\leq$ 20%). Keep away from open flames, heat sources (e.g., heaters, ovens), and corrosive substances.

2. Unopened Filament: Keep the filament sealed in its original packaging to prevent moisture absorption and contamination. Performance may degrade and printing issues may arise if stored for excessively long periods. Use the filament promptly after purchase.

3. Opened Filament: Reseal any unused filament immediately, placing it in a sealed bag or dedicated storage box. Adding desiccants (e.g., silica gel) is recommended to improve moisture protection. It is advisable to use the opened filament within 3 months to avoid moisture absorption and oxidation. In humid regions, use the filament as soon as possible or ensure it is properly sealed.

4. Spool Care: Avoid dropping, crushing, or bumping the spool to prevent deformation which could cause filament tangling. If tangles occur, do not pull aggressively. Gently untangle the filament before use to prevent breakage.

5 Common Issues and Troubleshooting

Common Issue	Potential Cause	Recommended Solution
No extrusion/filament breakage	1. Filament absorbed moisture/clumped. 2. Nozzle temperature too low, filament not fully melted. 3. Extruder gear pressure insufficient or slipping. 4. Nozzle clogged.	1. Dry the filament. 2. Increase nozzle temperature by 5–10°C. 3. Adjust extruder gear tension; clean debris from the gear. 4. Clear nozzle clogs using appropriate tools.
Bubbles or stringing on surface	1. Filament absorbed moisture. 2. Nozzle temperature too high. 3. Cooling fan off or inadequate airflow.	1. Dry the filament. 2. Decrease nozzle temperature by 5–10°C. 3. Turn on cooling fan and adjust fan speed.
Edge warping/part detaching from bed	1. Bed temperature too low. 2. Bed surface not clean, poor adhesion. 3. Large temperature fluctuations or drafts in printing environment. 4. Filament shrinkage rate too high.	1. Increase bed temperature. 2. Clean bed with ethyl alcohol; apply dedicated bed adhesive if needed. 3. Maintain stable ambient temperature, avoid drafts. 4. Adjust print parameters, reduce cooling fan speed.
Filament tangle/feeding jam	1. Knots and Tangles. 2. Spool placed at an incorrect angle. 3. Filament kinked or damaged.	1. Untangle the knots, straighten the filament end, and secure the end in the spool's locking holes. 2. Adjust spool placement angle to ensure smooth feeding. 3. Cut away damaged/kinked sections and reload filament.
Weak layer adhesion/delamination	1. Nozzle temperature too low. 2. Printing speed too high. 3. Cooling fan speed too high.	1. Increase nozzle temperature. 2. Reduce printing speed. 3. Lower cooling fan speed appropriately.

6 Safety Precautions

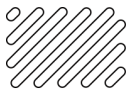
- 1. High-Temperature Protection:** During printing, the nozzle and molten filament reach extremely high temperatures. Do not touch the nozzle, filament guide tube, or freshly printed hot models to prevent burns. Children should be supervised by an adult at all times.
- 2. Environmental Safety:** Some materials may emit odors, ultrafine particles, or volatile substances when heated. It is recommended to use the device in a well-ventilated area.
- 3. Equipment Operation:** Strictly follow the printer's operating guidelines. Do not disassemble or modify the printer arbitrarily. When installing or changing filament, ensure the printer is powered off or in standby mode to prevent accidental injury.
- 4. Filament Usage:** Do not use damaged, deteriorated, or expired filament, as this may clog the nozzle, damage the printer, and compromise print quality. When cutting filament, use sharp cutters to ensure a clean, even cut.
- 5. Disposal:** Discard used filament and print waste in recyclable or general waste bins according to local regulations.

7 Additional Notes

1. This document is the user guide for Snapmaker PLA Translucent filament. For issues not covered in this guide, contact Snapmaker official customer support for professional technical assistance.
2. Regular printer maintenance (cleaning nozzle, extruder gear, and build plate) together with high-quality filament is recommended to improve printing outcomes and extend the lifespan of both the equipment and the filament.

8 After-sales Service

For questions regarding printing techniques or filament usage, please contact Snapmaker official customer support for one-on-one operational guidance.



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"The world is but a canvas to our imagination."

— Henry David Thoreau