

## HD PLA fiberlogy - annealing instruction

1. Print your project.
  - Printing temperature: 200°C – 220°C
  - Bed temperature: 50°C – 70°C (heating is not required if you are using plates, tapes or glue that increase the adhesion)
2. Place your a ready-made printout (with supports and raft) on a flat surface in a cool chamber.
3. The printout should be placed equally away from lower and upper heater.
4. Heat it gradually up to the temperature of 80°C.
5. Anneal your printout for about 15 minutes in 80°C.

**WARNING:** *The temperature in the chamber must be precisely maintained. It is recommended to measure the temperature with an additional digital thermometer with a probe that can be placed inside the oven. It is essential to keep an eye on the print and temperature during the heating process. In the case of massive printouts, you can gradually raise the temperature to 120 ° C or extend the heating time.*
6. After annealing process the printout must be taken out and cannot be touched until it cools down.
7. Remove supports and raft.
8. Now you can enjoy a ready-made product which gained mechanical strength similar to ABS and the temperature resistance up to 140°C.

### **IMPORTANT!**

1. We do not recommend annealing products with thin walls and wide-stretching geometry without any supports.
2. Please check whether temperature in the oven corresponds to the real temperature.
3. Shrinkage during annealing process will be performed and unfortunately this can not be avoided. Here appears a kind of reconstruction of the internal structure of the material, as it happens in the steel during hardening process. The amount of shrinkage is dependent on the used infill. The larger infill the relatively smaller should be the effect of contraction. Please experimentally choose the printing scale so that after annealing you will receive the required dimensions.
4. Always run the process on a test printout before annealing the right product.

If you have any doubts or questions, please don't hesitate to contact us  
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