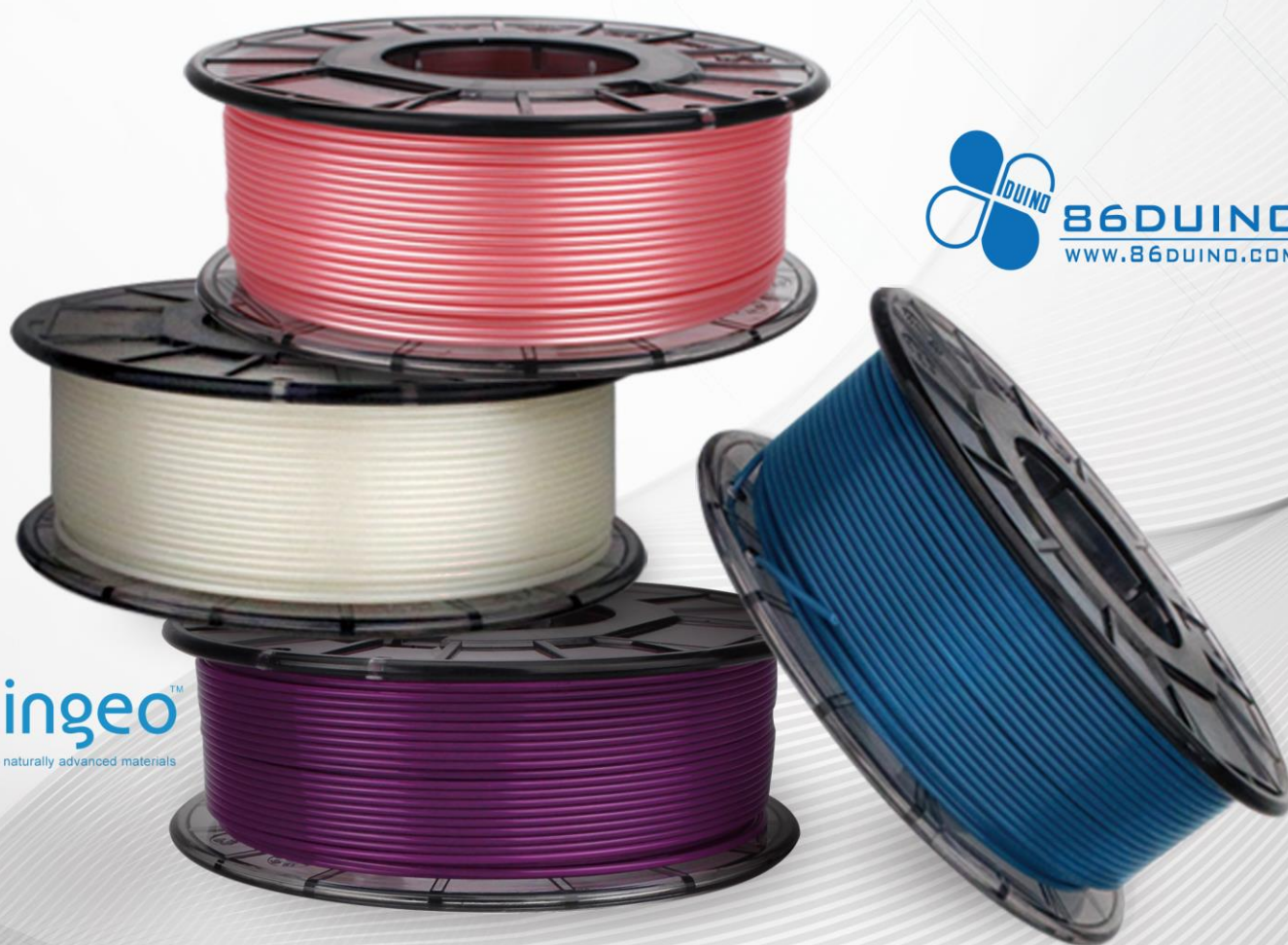


# 印匠の LINE

The Prime 3D Printing Filament

## User Manual

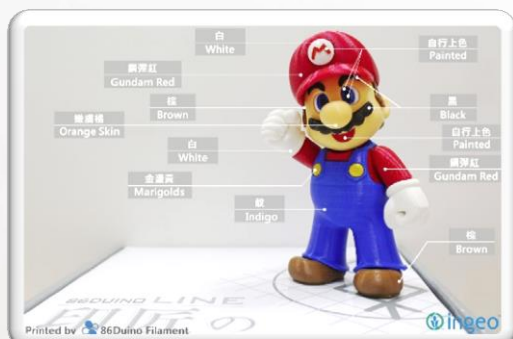
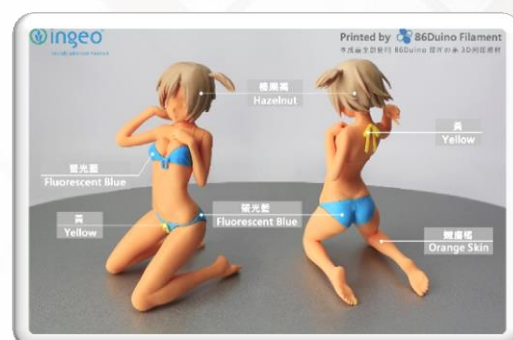
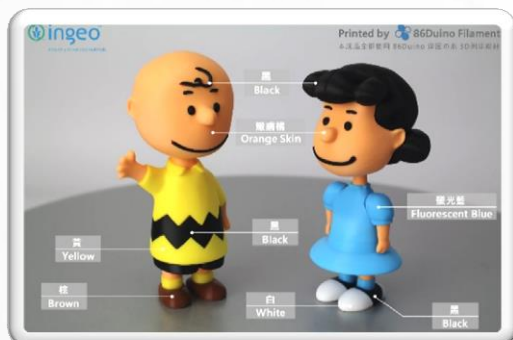


 **ingeo**<sup>TM</sup>  
naturally advanced materials

 **86DUINO**  
[WWW.86DUINO.COM](http://WWW.86DUINO.COM)

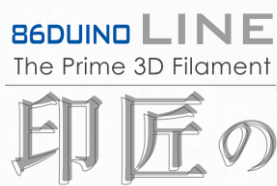
# 印匠のLINE

The Prime 3D Printing Filament



## About 印匠の糸

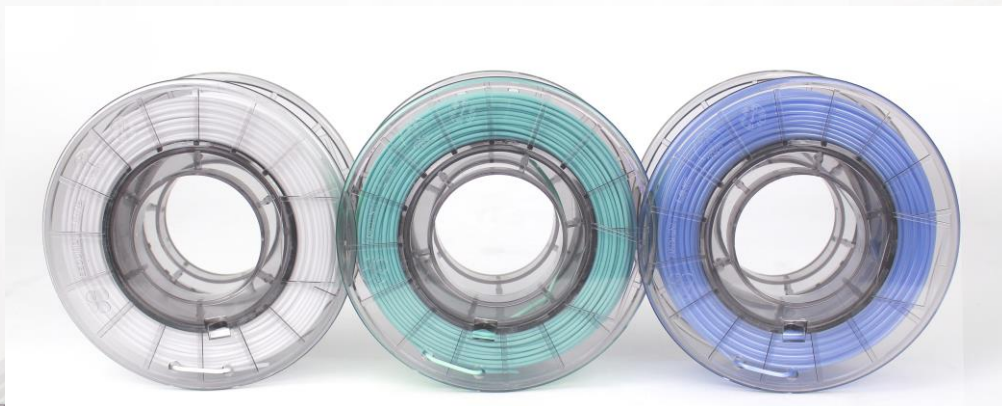
糸, fine silk, spun by a silkworm into a cocoon. Ten of these fine cocoons, carefully extracted, are called "silk." The idiom "each thread is looped and knotted" metaphorically describes something done very delicately and systematically, much like the intricacies of 3D printing, where the interplay is close and complex, orderly but not chaotic. Imagist Thread is produced and manufactured entirely in Taiwan.



The raw material is the American NatureWorks 3D850, 100% PLA material. It is never mixed or used with inferior materials for the sake of cutting prices or reducing costs, insisting on producing only high-quality 3D printing filaments. Imagist Thread is stable in diameter, neatly wound, full in color, carefully made, and environmentally friendly 3D printing filaments.

## Professional Production

We use Natureworks PLA raw material and source finest pigment, we can ensure the most consistent and highest quality for every spool filament.



## Organized Winding

Within special filament winding system, we provide excellent organized winding on spool, can avoid filament snapping and break when in printing, if the spool winding is not organized.



## Consistent Diameter and Roundness

Our filament extrusion line uses Micro Laser measurement system to control and check diameter and roundness during production, we guarantee each spool of 86Duino Line is produced with a precision tolerance by  $\pm 0.03\text{mm}$  on our 1.75mm PLA filament.



## Printing Tips

- This filament will run best at an extruder temperature of 190-210 °C
- Recommend use 86Duino tape or painter tape on the print bed to ensure the first layer of the print stick to the bed
- Clean nozzle after every use
- Clean the print bed after each day of printing
- Stability and higher print:
  - Speed of extruder set to 30-60mm/second
  - Infill at least 30%



| 顏色<br>Color | 英文名稱<br>English   | 訂購代號 / 1Kg<br>Supply Code / 1 Kg | 數量<br>Q' ty | 訂購代號 / 500g<br>Supply Code / 500g | 數量<br>Q' ty | 訂購代號 / 200g<br>Supply Code / 200g | 數量<br>Q' ty |
|-------------|-------------------|----------------------------------|-------------|-----------------------------------|-------------|-----------------------------------|-------------|
| 紅           | Red               | 86Duino-Line-C0R                 |             |                                   |             | 86Duino-Line-A0R                  |             |
| 橙           | Orange            | 86Duino-Line-CRG                 |             |                                   |             | 86Duino-Line-ARG                  |             |
| 黃           | Yellow            | 86Duino-Line-C0Y                 |             |                                   |             | 86Duino-Line-A0Y                  |             |
| 螢光綠         | Fluorescent Green | 86Duino-Line-C0G                 |             |                                   |             | 86Duino-Line-A0G                  |             |
| 螢光藍         | Fluorescent Blue  | 86Duino-Line-C0B                 |             |                                   |             | 86Duino-Line-A0B                  |             |
| 靛           | Indigo            | 86Duino-Line-C0D                 |             |                                   |             | 86Duino-Line-A0D                  |             |
| 紫           | Purple            | 86Duino-Line-C0P                 |             |                                   |             | 86Duino-Line-A0P                  |             |
| 黑           | Black             | 86Duino-Line-CBK                 |             |                                   |             | 86Duino-Line-ABK                  |             |
| 白           | White             | 86Duino-Line-C0W                 |             |                                   |             | 86Duino-Line-A0W                  |             |
| 粉紅          | Pink              | 86Duino-Line-CPN                 |             |                                   |             | 86Duino-Line-APN                  |             |
| 棕           | Brown             | 86Duino-Line-CBR                 |             |                                   |             | 86Duino-Line-ABR                  |             |
| 森林綠         | Forest Green      | 86Duino-Line-CFG                 |             |                                   |             | 86Duino-Line-AFG                  |             |
| 秋楓橘         | Maple Orange      | 86Duino-Line-CMO                 |             |                                   |             | 86Duino-Line-AMO                  |             |
| 透明          | Transparent       | 86Duino-Line-C0T                 |             | 86Duino-Line-B0T                  |             |                                   |             |
| 啞光黑         | Extinction Black  | 86Duino-Line-CEK                 |             |                                   |             |                                   |             |
| 青           | Cyan              | 86Duino-Line-CYN                 |             |                                   |             |                                   |             |
| 洋紅          | Magenta           | 86Duino-Line-CMT                 |             |                                   |             |                                   |             |
| 象牙白         | Ivory White       | 86Duino-Line-CIW                 |             |                                   |             |                                   |             |
| 簡約灰         | Simple Grey       | 86Duino-Line-CSG                 |             |                                   |             |                                   |             |
| 冰河銀         | Glacier Silver    | 86Duino-Line-CGS                 |             |                                   |             |                                   |             |
| 夜光綠         | Luminous Green    |                                  |             | 86Duino-Line-B0L                  |             | 86Duino-Line-A0L                  |             |
| 金           | Golden            |                                  |             | 86Duino-Line-BGD                  |             |                                   |             |
| 石英粉         | Rose Quartz       |                                  |             | 86Duino-Line-BRQ                  |             | 86Duino-Line-ARQ                  |             |
| 靜謐藍         | Serenity          |                                  |             | 86Duino-Line-BSR                  |             | 86Duino-Line-ASR                  |             |
| 蘭花紫         | Radiant Orchid    |                                  |             | 86Duino-Line-BRP                  |             | 86Duino-Line-ARP                  |             |
| 蘋果綠         | Apple Green       |                                  |             | 86Duino-Line-BAG                  |             | 86Duino-Line-AAG                  |             |
| 大理石         | Marble            |                                  |             | 86Duino-Line-B0M                  |             |                                   |             |
| 鐵金屬         | Iron              |                                  |             |                                   |             |                                   |             |
| 薩克綠         | Zaku Green        |                                  |             | 86Duino-Line-BZG                  |             |                                   |             |
| 鋼彈紅         | Gundam Red        |                                  |             | 86Duino-Line-BGR                  |             |                                   |             |
| 台灣紅         | Taiwan Red        |                                  |             | 86Duino-Line-BTR                  |             |                                   |             |
| 湖水綠         | Green Lake        |                                  |             | 86Duino-Line-BGL                  |             |                                   |             |
| 嫩膚橘         | Orange Skin       |                                  |             | 86Duino-Line-BRS                  |             |                                   |             |
| 牛仔藍         | Denim Blue        |                                  |             | 86Duino-Line-BDB                  |             | 86Duino-Line-ADB                  |             |



| 顏色<br>Color | 英文名稱<br>English      | 訂購代號 / 1Kg<br>Supply Code / 1 Kg | 數量<br>Q' ty | 訂購代號 / 500g<br>Supply Code / 500g | 數量<br>Q' ty | 訂購代號 / 200g<br>Supply Code / 200g | 數量<br>Q' ty |
|-------------|----------------------|----------------------------------|-------------|-----------------------------------|-------------|-----------------------------------|-------------|
| 珠貝白         | Pearl White          |                                  |             | 86Duino-Line-BPW                  |             | 86Duino-Line-APW                  |             |
| 榛果褐         | Hazelnut             |                                  |             | 86Duino-Line-BHN                  |             | 86Duino-Line-AHN                  |             |
| 天堂藍         | Paradise Blue        |                                  |             | 86Duino-Line-BPB                  |             | 86Duino-Line-APB                  |             |
| 赤褐銅         | Terracotta<br>Copper |                                  |             | 86Duino-Line-BTC                  |             | 86Duino-Line-ATC                  |             |
| 冰澗藍         | Ice Steam<br>Blue    |                                  |             | 86Duino-Line-BIB                  |             | 86Duino-Line-AIB                  |             |
| 櫻花粉         | Cherry<br>Blossom    |                                  |             | 86Duino-Line-BCB                  |             | 86Duino-Line-ACB                  |             |
| 沙土色         | Desert Sand          |                                  |             | 86Duino-Line-BDS                  |             | 86Duino-Line-ADS                  |             |
| 榮光銀         | Glory Silver         |                                  |             | 86Duino-Line-XBLS                 |             | 86Duino-Line-XALS                 |             |
| 軍規綠         | Mil Spec<br>Green    |                                  |             | 86Duino-Line-XBIG                 |             | 86Duino-Line-XAIG                 |             |
| 天照藍         | Light Sky Blue       |                                  |             | 86Duino-Line-XBSB                 |             | 86Duino-Line-XASB                 |             |
| 輝澄金         | Radiance Org<br>Gold |                                  |             | 86Duino-Line-XBRR                 |             | 86Duino-Line-XARR                 |             |
| 中國藍         | China Blue           |                                  |             | 86Duino-Line-XBHB                 |             | 86Duino-Line-XAHB                 |             |
| 狂野紫         | Wild Purple          |                                  |             | 86Duino-Line-XBWP                 |             | 86Duino-Line-XAWP                 |             |
| 沙漠金         | Desert Gold          |                                  |             | 86Duino-Line-XBDG                 |             | 86Duino-Line-XADG                 |             |
| 火舞紅         | Fire Dance<br>Red    |                                  |             | 86Duino-Line-XBFD                 |             | 86Duino-Line-XAFD                 |             |
| 芒果青         | Green Mango          |                                  |             | 86Duino-Line-XBGM                 |             |                                   |             |
| 玫瑰岩         | Rose Rock            |                                  |             | 86Duino-Line-XBRK                 |             |                                   |             |

Note:

1. 200g package filament length around 70 meters
2. 500g package filament length around 169 meters
3. 1.0kg package filament length around 342 meters



## 1.0 KG Package

C1



紅 Red (Supply Code : 86Duino-Line-C0R)  
Material : NatureWorks 3D850 PLA  
Pantone : 032C  
Diameter : 1.75mm  
**Net Weight : 1.0kg** / Gross Weight : 1.35kg  
Length: 342 Meters  
Spool : 200mm (D) x 82mm (W) x 52mm (Hole)  
Nozzle Temp. : 195℃ ~ 210℃

C2



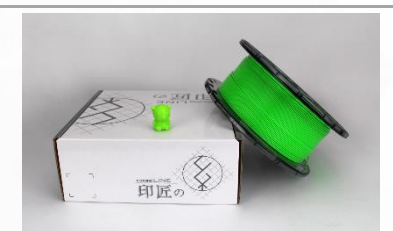
橙 Orange (Supply Code : 86Duino-Line-CRG)  
Material : NatureWorks 3D850 PLA  
Pantone: 1495C  
Diameter : 1.75mm  
**Net Weight : 1.0kg** / Gross Weight : 1.35kg  
Length: 342 Meters  
Spool : 200mm (D) x 82mm (W) x 52mm (Hole)  
Nozzle Temp. : 195℃ ~ 210℃

C3



黄 Yellow (Supply Code : 86Duino-Line-C0Y)  
Material : NatureWorks 3D850 PLA  
Pantone : 101C  
Diameter : 1.75mm  
**Net Weight : 1.0kg** / Gross Weight : 1.35kg  
Length: 342 Meters  
Spool : 200mm (D) x 82mm (W) x 52mm (Hole)  
Nozzle Temp. : 195℃ ~ 210℃

C4



螢光綠 F. Green (Supply Code : 86Duino-Line-C0G)  
Material : NatureWorks 3D850 PLA  
Pantone : 2420C  
Diameter : 1.75mm  
**Net Weight : 1.0kg** / Gross Weight : 1.35kg  
Length: 342 Meters  
Spool : 200mm (D) x 82mm (W) x 52mm (Hole)  
Nozzle Temp. : 195℃ ~ 210℃

C5



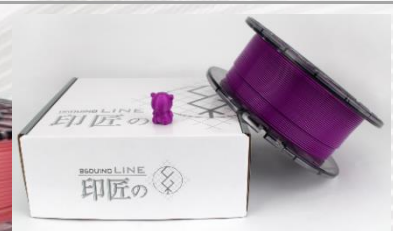
螢光藍 F. Blue (Supply Code : 86Duino-Line-C0B)  
Material : NatureWorks 3D850 PLA  
Pantone : 2171C  
Diameter : 1.75mm  
**Net Weight : 1.0kg** / Gross Weight : 1.35kg  
Length: 342 Meters  
Spool : 200mm (D) x 82mm (W) x 52mm (Hole)  
Nozzle Temp. : 195℃ ~ 210℃

C6



靛 Indigo (Supply Code : 86Duino-Line-C0D)  
Material : NatureWorks 3D850 PLA  
Pantone : 286C  
Diameter : 1.75mm  
**Net Weight : 1.0kg** / Gross Weight : 1.35kg  
Length: 342 Meters  
Spool : 200mm (D) x 82mm (W) x 52mm (Hole)  
Nozzle Temp. : 195℃ ~ 210℃

C7



紫 Purple (Supply Code : 86Duino-Line-C0P)  
Material : NatureWorks 3D850 PLA  
Diameter : 1.75mm  
Pantone : 2613C  
**Net Weight : 1.0kg** / Gross Weight : 1.35kg  
Length: 342 Meters  
Spool : 200mm (D) x 82mm (W) x 52mm (Hole)  
Nozzle Temp. : 195℃ ~ 210℃



|     |                                                                                     |                                                                                                                                                                                                                                                                                                           |
|-----|-------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| C8  |    | <p>黒 Black (Supply Code : 86Duino-Line-CBK)<br/> Material : NatureWorks 3D850 PLA<br/> Pantone : Black<br/> Diameter : 1.75mm<br/> <b>Net Weight : 1.0kg</b> / Gross Weight : 1.35kg<br/> Length: 342 Meters<br/> Spool : 200mm (D) x 82mm (W) x 52mm (Hole)<br/> Nozzle Temp. : 195℃ ~ 210℃</p>          |
| C9  |    | <p>白 White (Supply Code : 86Duino-Line-C0W)<br/> Material : NatureWorks 3D850 PLA<br/> Pantone : White<br/> Diameter : 1.75mm<br/> <b>Net Weight : 1.0kg</b> / Gross Weight : 1.35kg<br/> Length: 342 Meters<br/> Spool : 200mm (D) x 82mm (W) x 52mm (Hole)<br/> Nozzle Temp. : 195℃ ~ 210℃</p>          |
| C10 |    | <p>粉紅 Rose Pink (Supply Code : 86Duino-Line-CPN)<br/> Material : NatureWorks 3D850 PLA<br/> Pantone : 2045C<br/> Diameter : 1.75mm<br/> <b>Net Weight : 1.0kg</b> / Gross Weight : 1.35kg<br/> Length: 342 Meters<br/> Spool : 200mm (D) x 82mm (W) x 52mm (Hole)<br/> Nozzle Temp. : 195℃ ~ 210℃</p>     |
| C11 |   | <p>棕 Brown (Supply Code : 86Duino-Line-CBR)<br/> Material : NatureWorks 3D850 PLA<br/> Pantone : 7568C<br/> Diameter : 1.75mm<br/> <b>Net Weight : 1.0kg</b> / Gross Weight : 1.35kg<br/> Length: 342 Meters<br/> Spool : 200mm (D) x 82mm (W) x 52mm (Hole)<br/> Nozzle Temp. : 195℃ ~ 210℃</p>          |
| C12 |  | <p>森林緑 Forest Green (Supply Code : 86Duino-Line-CFG)<br/> Material : NatureWorks 3D850 PLA<br/> Pantone : 349CC<br/> Diameter : 1.75mm<br/> <b>Net Weight : 1.0kg</b> / Gross Weight : 1.35kg<br/> Length: 342 Meters<br/> Spool : 200mm (D) x 82mm (W) x 52mm (Hole)<br/> Nozzle Temp. : 195℃ ~ 210℃</p> |
| C13 |  | <p>透明 Transparent (Supply Code : 86Duino-Line-COT)<br/> Material : NatureWorks 3D850 PLA<br/> Pantone :<br/> Diameter : 1.75mm<br/> <b>Net Weight : 1.0kg</b> / Gross Weight : 1.35kg<br/> Length: 342 Meters<br/> Spool : 200mm (D) x 48mm (W) x 52mm (Hole)<br/> Nozzle Temp. : 195℃ ~ 210℃</p>         |
| C14 |  | <p>秋楓橘 Maple Orange (Supply Code : 86Duino-Line-CMO)<br/> Material : NatureWorks 3D850 PLA<br/> Pantone :<br/> Diameter : 1.75mm<br/> <b>Net Weight : 1.0kg</b> / Gross Weight : 1.35kg<br/> Length: 342 Meters<br/> Spool : 200mm (D) x 48mm (W) x 52mm (Hole)<br/> Nozzle Temp. : 195℃ ~ 210℃</p>       |

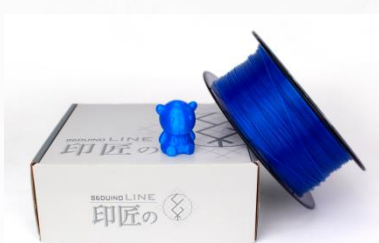


C15



啞光黒 Extinction Black (Supply Code : 86Duino-Line-CEK)  
Material : NatureWorks 3D850 PLA  
Pantone :  
Diameter : 1.75mm  
**Net Weight : 1.0kg** / Gross Weight : 1.35kg  
Length: 342 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 195℃ ~ 210℃

C16



青 Cyan (Supply Code : 86Duino-Line-CYN)  
Material : NatureWorks 3D850 PLA  
Pantone :  
Diameter : 1.75mm  
**Net Weight : 1.0kg** / Gross Weight : 1.35kg  
Length: 342 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 195℃ ~ 210℃

C17



洋紅 Magenta (Supply Code : 86Duino-Line-CMT)  
Material : NatureWorks 3D850 PLA  
Pantone :  
Diameter : 1.75mm  
**Net Weight : 1.0kg** / Gross Weight : 1.35kg  
Length: 342 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 195℃ ~ 210℃

C18



象牙白 Ivory White (Supply Code : 86Duino-Line-CIW)  
Material : NatureWorks 3D850 PLA  
Pantone :  
Diameter : 1.75mm  
**Net Weight : 1.0kg** / Gross Weight : 1.35kg  
Length: 342 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 195℃ ~ 210℃

C19



簡約灰 Simple Grey (Supply Code : 86Duino-Line-CSG)  
Material : NatureWorks 3D850 PLA  
Pantone : 642C  
Diameter : 1.75mm  
**Net Weight : 1.0kg** / Gross Weight : 1.35kg  
Length: 342 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 195℃ ~ 210℃

C20



冰河銀 Glacier Silver (Supply Code : 86Duino-Line-BGS)  
Material : NatureWorks 3D850 PLA  
Pantone : 877C  
Diameter : 1.75mm  
**Net Weight : 1.0kg** / Gross Weight : 1.35kg  
Length: 342 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 195℃ ~ 210℃



## 500g Package

B1



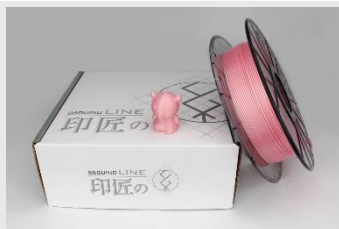
透明 Transparent (Supply Code : 86Duino-Line-B0T)  
Material : NatureWorks 3D850 PLA  
Pantone :  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 195℃ ~ 210℃

B2



金 Golden (Supply Code : 86Duino-Line-BGD)  
Material : NatureWorks 3D850 PLA  
Pantone : 871C  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 195℃ ~ 210℃

B3



石英粉 Rose Quartz (Supply Code : 86Duino-Line-BRQ)  
Material : NatureWorks 3D850 PLA  
Pantone : 203C  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 195℃ ~ 210℃

B4



静謐藍 Serenity (Supply Code : 86Duino-Line-BSR)  
Material : NatureWorks 3D850 PLA  
Pantone : 2128C  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 195℃ ~ 210℃

B5



蘭花紫 Radiant Orchid (Supply Code : 86Duino-Line-BRP)  
Material : NatureWorks 3D850 PLA  
Pantone : 2562C  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 195℃ ~ 210℃

B6



蘋果綠 Apple Green (Supply Code : 86Duino-Line-BAG)  
Material : NatureWorks 3D850 PLA  
Pantone : 587C  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 195℃ ~ 210℃

B7

停產 / Phase out

覆盆子 Raspberry (Supply Code : 86Duino-Line-BRB)

B8

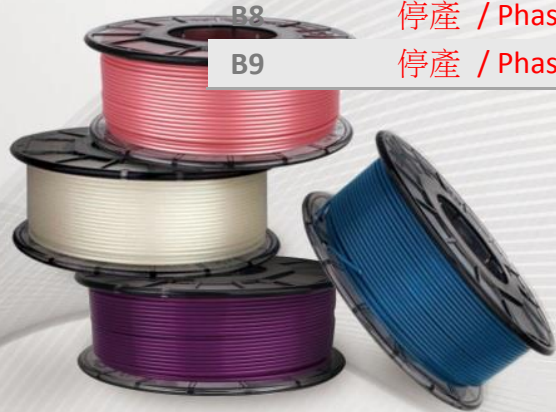
停產 / Phase out

薰衣草 Lavender (Supply Code : 86Duino-Line-BLV)

B9

停產 / Phase out

薄荷綠 Mint Green (Supply Code : 86Duino-Line-BMG)



**B10**



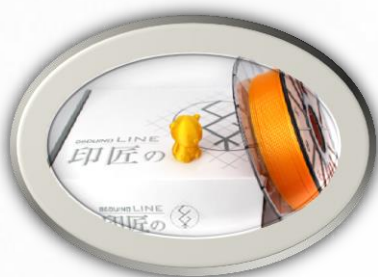
薩克綠 Zaku Green (Supply Code : 86Duino-Line-BZG)  
Material : NatureWorks 3D850 PLA  
Pantone : 574C  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 195°C ~ 210°C

**B11**



鋼彈紅 Gundam Red (Supply Code : 86Duino-Line-BGR)  
Material : NatureWorks 3D850 PLA  
Pantone : 200C  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 195°C ~ 210°C

**B12**



金盞黃 Marigolds (Supply Code : 86Duino-Line-BMY)  
Material : NatureWorks 3D850 PLA  
Pantone : 2010C  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 195°C ~ 210°C

停產 / Phase out

**B13**



台灣紅 Taiwan Red (Supply Code : 86Duino-Line-BTR)  
Material : NatureWorks 3D850 PLA  
Pantone : 213C  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 195°C ~ 210°C

**B14**



湖水綠 Green Lake (Supply Code : 86Duino-Line-BGL)  
Material : NatureWorks 3D850 PLA  
Pantone : 3258C  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 195°C ~ 210°C

**B15**



嫩膚橘 Orange Skin (Supply Code : 86Duino-Line-BRS)  
Material : NatureWorks 3D850 PLA  
Pantone : 713C  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 195°C ~ 210°C

**B16**



牛仔藍 Demin Blue (Supply Code : 86Duino-Line-BDB)  
Material : NatureWorks 3D850 PLA  
Pantone : 2391C  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)



B17



停産 / Phase out

Nozzle Temp. : 195°C ~ 210°C

簡約灰 Simple Grey (Supply Code : 86Duino-Line-BSG)

Material : NatureWorks 3D850 PLA

Pantone : 642C

Diameter : 1.75mm

~~Net Weight : 500g~~ / Gross Weight : 0.75kg

Length: 169 Meters

Spool : 200mm (D) x 48mm (W) x 52mm (Hole)

~~Nozzle Temp. : 195°C ~ 210°C~~

B18



大理石 Marble (Supply Code : 86Duino-Line-B0M)

Material : NatureWorks 3D850 PLA

Pantone :

Diameter : 1.75mm

**Net Weight : 500g** / Gross Weight : 0.75kg

Length: 169 Meters

Spool : 200mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C

B19



珠貝白 Pearl White (Supply Code : 86Duino-Line-BPW)

Material : NatureWorks 3D850 PLA

Pantone :

Diameter : 1.75mm

**Net Weight : 500g** / Gross Weight : 0.75kg

Length: 169 Meters

Spool : 200mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C

B20



榛果褐 Hazlnut (Supply Code : 86Duino-Line-BHN)

Material : NatureWorks 3D850 PLA

Pantone : 2311C

Diameter : 1.75mm

**Net Weight : 500g** / Gross Weight : 0.75kg

Length: 169 Meters

Spool : 200mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C

B21



天堂藍 Paradise Blue (Supply Code : 86Duino-Line-BPB)

Material : NatureWorks 3D850 PLA

Pantone : 324C

Diameter : 1.75mm

**Net Weight : 500g** / Gross Weight : 0.75kg

Length: 169 Meters

Spool : 200mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C

B22



冰河銀 Glacier Silver (Supply Code : 86Duino-Line-BGS)

Material : NatureWorks 3D850 PLA

Pantone : 877C

Diameter : 1.75mm

~~Net Weight : 500g~~ / Gross Weight : 0.75kg

Length: 169 Meters

Spool : 200mm (D) x 48mm (W) x 52mm (Hole)

~~Nozzle Temp. : 195°C ~ 210°C~~

停産 / Phase out

B23



赤褐銅 Terracotta Copper (Supply Code : 86Duino-Line-BTC)

Material : NatureWorks 3D850 PLA

Pantone : 7628C

Diameter : 1.75mm

**Net Weight : 500g** / Gross Weight : 0.75kg

Length: 169 Meters

Spool : 200mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C



**B24**



冰潤藍 Ice Steam Blue (Supply Code : 86Duino-Line-BIB)  
Material : NatureWorks 3D850 PLA  
Pantone : 2975C  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 195℃ ~ 210℃

**B25**



櫻花粉 Cherry Blossom (Supply Code : 86Duino-Line-BCB)  
Material : NatureWorks 3D850 PLA  
Pantone : 210C  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 195℃ ~ 210℃

**B26**



沙土色 Desert Sand (Supply Code : 86Duino-Line-BDS)  
Material : NatureWorks 3D850 PLA  
Pantone : 7508C  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 195℃ ~ 210℃

**B27**



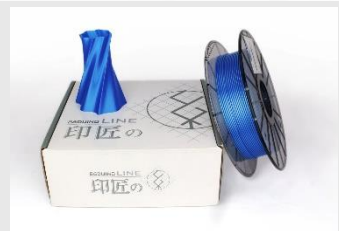
榮光銀 Glory Silver (Supply Code : 86Duino-Line-XBLS)  
Material : Ciao Plas  
Pantone :  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 210℃ ~ 225℃

**B28**



軍規綠 Mil Spec Green (Supply Code : 86Duino-Line-XBIG)  
Material : Ciao Plas  
Pantone :  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 210℃ ~ 225℃

**B29**



天照藍 Light Sky Blue (Supply Code : 86Duino-Line-XBSB)  
Material : Ciao Plas  
Pantone :  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 210℃ ~ 225℃

**B30**



輝澄金 Radiance Org Gold (Supply Code : 86Duino-Line-XBRR)  
Material : Ciao Plas  
Pantone :  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 210℃ ~ 225℃



**B31**



中國藍 China Blue (Supply Code : 86Duino-Line-XBHB)  
Material : Ciao Plas  
Pantone :  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 210°C ~ 220°C

**B32**



狂野紫 Wild Purple (Supply Code : 86Duino-Line-XBWP)  
Material : Ciao Plas  
Pantone :  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 210°C ~ 225°C

**B33**



沙漠金 Desert Gold (Supply Code : 86Duino-Line-XBDG)  
Material : Ciao Plas  
Pantone :  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 210°C ~ 225°C

**B34**



火舞紅 Fire Dance Red (Supply Code : 86Duino-Line-XBFD)  
Material : Ciao Plas  
Pantone :  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 210°C ~ 225°C

**B35**



芒果青 Green Mango (Supply Code : 86Duino-Line-XBGM)  
Material : Ciao Plas  
Pantone :  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 210°C ~ 225°C

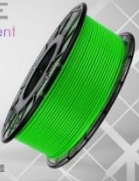
**B36**



玫瑰岩 Rose Rock (Supply Code : 86Duino-Line-XBRK)  
Material : Ciao Plas  
Pantone :  
Diameter : 1.75mm  
**Net Weight : 500g** / Gross Weight : 0.75kg  
Length: 169 Meters  
Spool : 200mm (D) x 48mm (W) x 52mm (Hole)  
Nozzle Temp. : 210°C ~ 225°C

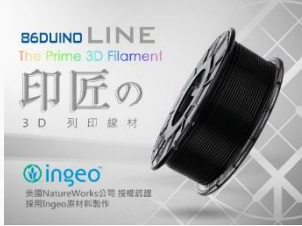


## 200g Package

|    |                                                                                                                                                                                                           |                                                                                                                                                                                                                                                                                              |
|----|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| A1 |  <p>86DUINO LINE<br/>The Prime 3D Filament<br/>印匠の<br/>3D 列印線材<br/>Ingeo<br/>美國NatureWorks公司 授權認證<br/>採用Ingeo原料和製作</p>   | <p>紅 Red (Supply Code : 86Duino-Line-A0R)<br/>Material : NatureWorks 3D850 PLA<br/>Pantone : 032C<br/>Diameter : 1.75mm<br/><b>Net Weight : 200g</b> / Gross Weight : 330g<br/>Length: 70 Meters<br/>Spool : 130mm (D) x 48mm (W) x 52mm (Hole)<br/>Nozzle Temp. : 195°C ~ 210°C</p>         |
| A2 |  <p>86DUINO LINE<br/>The Prime 3D Filament<br/>印匠の<br/>3D 列印線材<br/>Ingeo<br/>美國NatureWorks公司 授權認證<br/>採用Ingeo原料和製作</p>   | <p>橙 Orange (Supply Code : 86Duino-Line-ARG)<br/>Material : NatureWorks 3D850 PLA<br/>Pantone : 1495C<br/>Diameter : 1.75mm<br/><b>Net Weight : 200g</b> / Gross Weight : 330g<br/>Length: 70 Meters<br/>Spool : 130mm (D) x 48mm (W) x 52mm (Hole)<br/>Nozzle Temp. : 195°C ~ 210°C</p>     |
| A3 |  <p>86DUINO LINE<br/>The Prime 3D Filament<br/>印匠の<br/>3D 列印線材<br/>Ingeo<br/>美國NatureWorks公司 授權認證<br/>採用Ingeo原料和製作</p>   | <p>黃 Yellow (Supply Code : 86Duino-Line-A0Y)<br/>Material : NatureWorks 3D850 PLA<br/>Pantone : 101C<br/>Diameter : 1.75mm<br/><b>Net Weight : 200g</b> / Gross Weight : 330g<br/>Length: 70 Meters<br/>Spool : 130mm (D) x 48mm (W) x 52mm (Hole)<br/>Nozzle Temp. : 195°C ~ 210°C</p>      |
| A4 |  <p>86DUINO LINE<br/>The Prime 3D Filament<br/>印匠の<br/>3D 列印線材<br/>Ingeo<br/>美國NatureWorks公司 授權認證<br/>採用Ingeo原料和製作</p> | <p>螢光綠 F. Green (Supply Code : 86Duino-Line-A0G)<br/>Material : NatureWorks 3D850 PLA<br/>Pantone : 2420C<br/>Diameter : 1.75mm<br/><b>Net Weight : 200g</b> / Gross Weight : 330g<br/>Length: 70 Meters<br/>Spool : 130mm (D) x 48mm (W) x 52mm (Hole)<br/>Nozzle Temp. : 195°C ~ 210°C</p> |
| A5 |  <p>86DUINO LINE<br/>The Prime 3D Filament<br/>印匠の<br/>3D 列印線材<br/>Ingeo<br/>美國NatureWorks公司 授權認證<br/>採用Ingeo原料和製作</p> | <p>螢光藍 F. Blue (Supply Code : 86Duino-Line-A0B)<br/>Material : NatureWorks 3D850 PLA<br/>Pantone : 2171C<br/>Diameter : 1.75mm<br/><b>Net Weight : 200g</b> / Gross Weight : 330g<br/>Length: 70 Meters<br/>Spool : 130mm (D) x 48mm (W) x 52mm (Hole)<br/>Nozzle Temp. : 195°C ~ 210°C</p>  |
| A6 |  <p>86DUINO LINE<br/>The Prime 3D Filament<br/>印匠の<br/>3D 列印線材<br/>Ingeo<br/>美國NatureWorks公司 授權認證<br/>採用Ingeo原料和製作</p> | <p>靛 Indigo (Supply Code : 86Duino-Line-A0D)<br/>Material : NatureWorks 3D850 PLA<br/>Pantone : 286C<br/>Diameter : 1.75mm<br/><b>Net Weight : 200g</b> / Gross Weight : 330g<br/>Length: 70 Meters<br/>Spool : 130mm (D) x 48mm (W) x 52mm (Hole)<br/>Nozzle Temp. : 195°C ~ 210°C</p>      |
| A7 |  <p>86DUINO LINE<br/>The Prime 3D Filament<br/>印匠の<br/>3D 列印線材<br/>Ingeo<br/>美國NatureWorks公司 授權認證<br/>採用Ingeo原料和製作</p> | <p>紫 Purple (Supply Code : 86Duino-Line-A0P)<br/>Material : NatureWorks 3D850 PLA<br/>Pantone : 2613C<br/>Diameter : 1.75mm<br/><b>Net Weight : 200g</b> / Gross Weight : 330g<br/>Length: 70 Meters<br/>Spool : 130mm (D) x 48mm (W) x 52mm (Hole)<br/>Nozzle Temp. : 195°C ~ 210°C</p>     |



A8



黒 Black (Supply Code : 86Duino-Line-ABK)

Material : NatureWorks 3D850 PLA

Pantone : Black

Diameter : 1.75mm

Net Weight : 200g / Gross Weight : 330g

Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C

A9



粉紅 Pink (Supply Code : 86Duino-Line-APN)

Material : NatureWorks 3D850 PLA

Pantone : 2045C

Diameter : 1.75mm

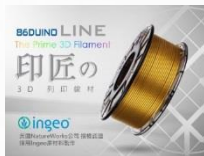
Net Weight : 200g / Gross Weight : 330g

Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C

A10



金 Golden (Supply Code : 86Duino-Line-AGD)

Material : NatureWorks 3D850 PLA

Pantone : 871C

Diameter : 1.75mm

Net Weight : 200g / Gross Weight : 330g

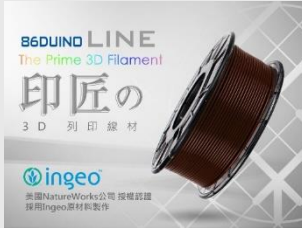
Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C

停産 / Phase out

A11



棕 Brown (Supply Code : 86Duino-Line-ABR)

Material : NatureWorks 3D850 PLA

Pantone : 7568C

Diameter : 1.75mm

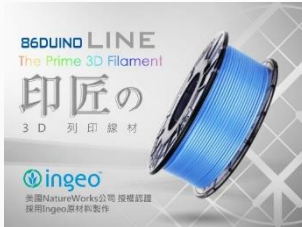
Net Weight : 200g / Gross Weight : 330g

Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C

A12



靜謐藍 Serenity (Supply Code : 86Duino-Line-ASR)

Material : NatureWorks 3D850 PLA

Pantone : 2128C

Diameter : 1.75mm

Net Weight : 200g / Gross Weight : 330g

Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C

A13



石英粉 Rose Quartz (Supply Code : 86Duino-Line-ARQ)

Material : NatureWorks 3D850 PLA

Pantone : 2562C

Diameter : 1.75mm

Net Weight : 200g / Gross Weight : 330g

Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C

A14



蘋果綠 Apple Green (Supply Code : 86Duino-Line-AAG)

Material : NatureWorks 3D850 PLA

Pantone : 587C

Diameter : 1.75mm

Net Weight : 200g / Gross Weight : 330g

Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C



A15



珠貝白 Pearl White (Supply Code : 86Duino-Line-APW)

Material : NatureWorks 3D850 PLA

Pantone :

Diameter : 1.75mm

Net Weight : 200g / Gross Weight : 330g

Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C

A16



榛果褐 Hazlnut (Supply Code : 86Duino-Line-AHN)

Material : NatureWorks 3D850 PLA

Pantone : 2311C

Diameter : 1.75mm

Net Weight : 200g / Gross Weight : 330g

Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C

A17



天堂藍 Paradise Blue (Supply Code : 86Duino-Line-APB)

Material : NatureWorks 3D850 PLA

Pantone : 324C

Diameter : 1.75mm

Net Weight : 200g / Gross Weight : 330g

Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C

A18



夜光綠 Luminous Green (Supply Code : 86Duino-Line-A0L)

Material : NatureWorks 3D850 PLA

Pantone :

Diameter : 1.75mm

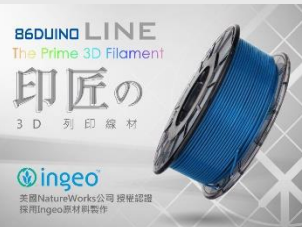
Net Weight : 200g / Gross Weight : 330g

Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C

A19



牛仔藍 Demin Blue (Supply Code : 86Duino-Line-ADB)

Material : NatureWorks 3D850 PLA

Pantone :

Diameter : 1.75mm

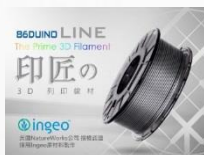
Net Weight : 200g / Gross Weight : 330g

Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C

A20



冰河銀 Glacier Silver (Supply Code : 86Duino-Line-AGS)

Material : NatureWorks 3D850 PLA

Pantone : 877C

Diameter : 1.75mm

Net Weight : 200g / Gross Weight : 330g

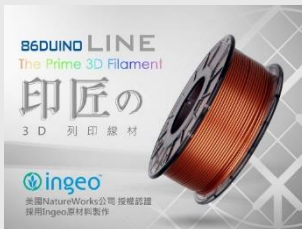
Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C

停產 / Phase out

A21



赤褐銅 Terracotta Copper (Supply Code : 86Duino-Line-ATC)

Material : NatureWorks 3D850 PLA

Pantone : 7628C

Diameter : 1.75mm

Net Weight : 200g / Gross Weight : 330g

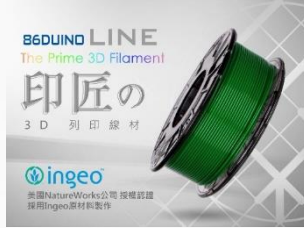
Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C



A22



森林綠 Forest Green (Supply Code : 86Duino-Line-AFG)

Material : NatureWorks 3D850 PLA

Pantone : 349C

Diameter : 1.75mm

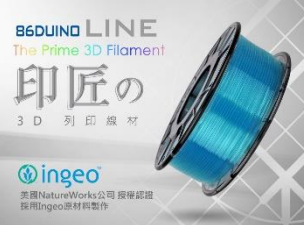
Net Weight : 200g / Gross Weight : 330g

Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C

A23



冰潤藍 Ice Steam Blue (Supply Code : 86Duino-Line-AIB)

Material : NatureWorks 3D850 PLA

Pantone : 2975C

Diameter : 1.75mm

Net Weight : 200g / Gross Weight : 330g

Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C

A24



櫻花粉 Cherry Blossom (Supply Code : 86Duino-Line-ACB)

Material : NatureWorks 3D850 PLA

Pantone : 210C

Diameter : 1.75mm

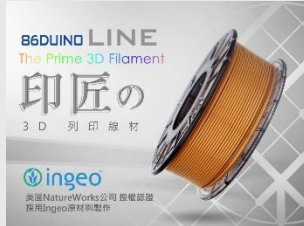
Net Weight : 200g / Gross Weight : 330g

Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C

A25



沙土色 Desert Sand (Supply Code : 86Duino-Line-ADS)

Material : NatureWorks 3D850 PLA

Pantone : 7508C

Diameter : 1.75mm

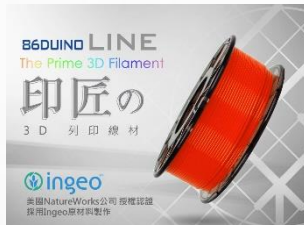
Net Weight : 200g / Gross Weight : 330g

Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C

A26



秋楓橘 Maple Orange (Supply Code : 86Duino-Line-AMO)

Material : NatureWorks 3D850 PLA

Pantone : 7508C

Diameter : 1.75mm

Net Weight : 200g / Gross Weight : 330g

Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 195°C ~ 210°C

A27



榮光銀色 Glory Silver (Supply Code : 86Duino-Line-XALS)

Material : Ciao Plas

Pantone :

Diameter : 1.75mm

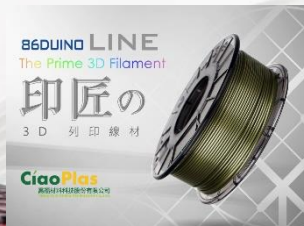
Net Weight : 200g / Gross Weight : 330g

Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 210°C ~ 225°C

A28



軍規綠 Mil Spec Green (Supply Code : 86Duino-Line-XAIG)

Material : Ciao Plas

Pantone :

Diameter : 1.75mm

Net Weight : 200g / Gross Weight : 330g

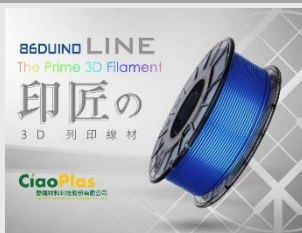
Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 210°C ~ 225°C



A29



天照藍 Light Sky Blue (Supply Code : 86Duino-Line-XASB)

Material : Ciao Plas

Pantone :

Diameter : 1.75mm

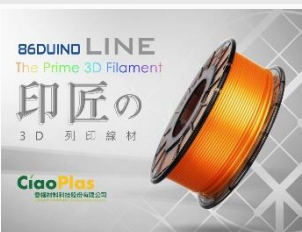
**Net Weight : 200g** / Gross Weight : 330g

Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 210°C ~ 225°C

A30



輝澄金 Radiance Org Gold (Supply Code : 86Duino-Line-XARR)

Material : Ciao Plas

Pantone :

Diameter : 1.75mm

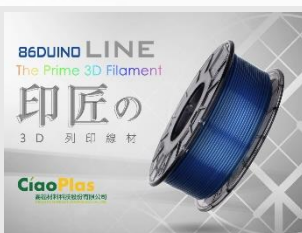
**Net Weight : 200g** / Gross Weight : 330g

Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 210°C ~ 225°C

A31



中國藍 China Blue (Supply Code : 86Duino-Line-XAHB)

Material : Ciao Plas

Pantone :

Diameter : 1.75mm

**Net Weight : 200g** / Gross Weight : 330g

Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 210°C ~ 225°C

A32



狂野紫 Wild Purple (Supply Code : 86Duino-Line-XAWP)

Material : Ciao Plas

Pantone :

Diameter : 1.75mm

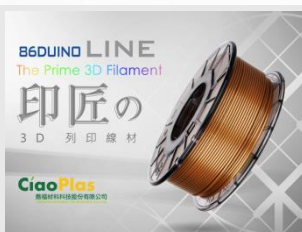
**Net Weight : 200g** / Gross Weight : 330g

Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 210°C ~ 225°C

A33



沙漠金 Desert Gold (Supply Code : 86Duino-Line-XADG)

Material : Ciao Plas

Pantone :

Diameter : 1.75mm

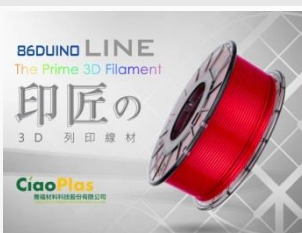
**Net Weight : 200g** / Gross Weight : 330g

Length: 70 Meters

Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 210°C ~ 225°C

A34



火舞紅 Fire Dance Red (Supply Code : 86Duino-Line-XAFD)

Material : Ciao Plas

Pantone :

Diameter : 1.75mm

**Net Weight : 200g** / Gross Weight : 330g

Length: 70 Meters

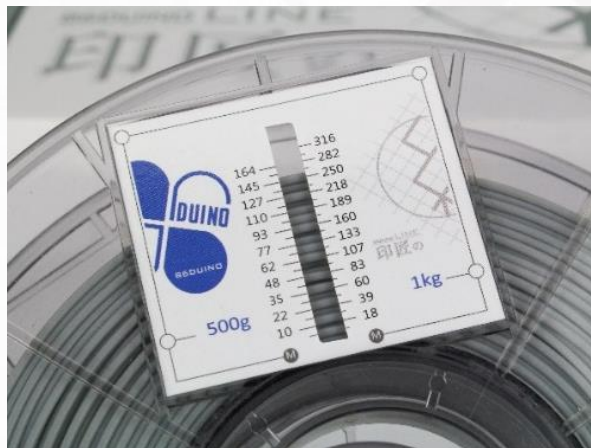
Spool : 130mm (D) x 48mm (W) x 52mm (Hole)

Nozzle Temp. : 210°C ~ 225°C



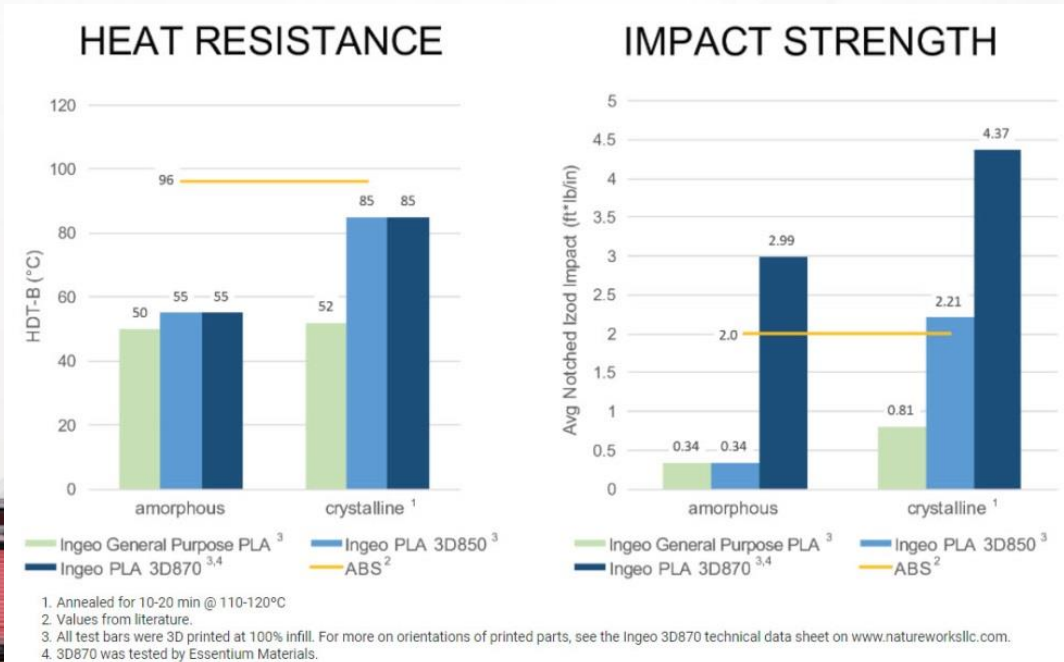
# 印匠のLINE

The Prime 3D Printing Filament



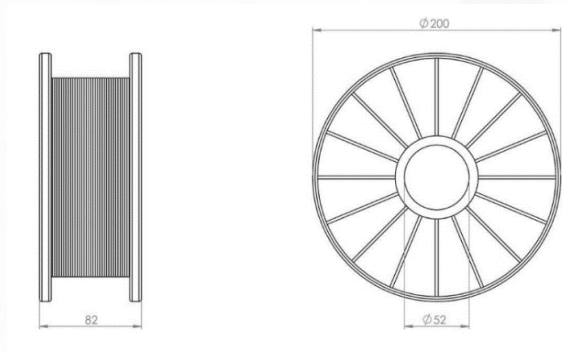
## NatureWorks Ingeo 3D850 PLA Filament

Ingeo 3D850 PLA Formulation for 3D Filament Offers Heat and Impact Resistance Rivaling ABS and Processes and Prints with the Ease of PLA

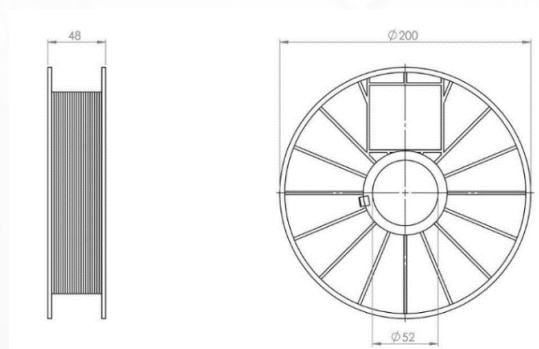




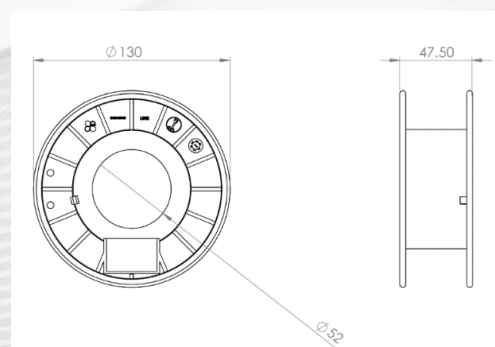
## 1.0 KG Spool Dimension



## 500g Spool Dimension



## 200g Spool Dimension



# 印匠のLINE

The Prime 3D Printing Filament



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