Fillamentum Fluorodur

(polyvinylidene fluoride)

Printing temperature: 250 – 270 °C
Heated bed temperature: 100 + °C
Speed: 20 – 40 mm/s
Part cooling fan: 0 – 15 %

Heated bed surface: mirror/glass, acrylic type
Adhesive: Dimafix Pen, PVA glue
Raft / skirt / brim: Large brim
Heated chamber / enclosure: recommended

Fluorodur is made using Kynar® PVDF by Arkema.

Adhesion - Large brim around the printed object is highly recommended. The best adhesion was achieved with Dimafix or PVA glue on clean glass or mirror. For the object bigger than 10 cm it is recommended to use printer with heated chamber.

Cooling - It is not recommended to use cooling fan to avoid warping of the printed object and to ensure proper layer adhesion. Only in the case of printing at higher speeds or overhangs/bridges, it is possible to use at maximum 15 % of part cooling fan.

Printed parts - If it's possible at construction, avoid sharp corners touching the build plate. It can increase the warping effect when printing PVDF.

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SAFETY RECOMMENDATION

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Don't harm yourself:

- avoid breathing of the released fumes
- follow the 3D printing recommendation
- harmful toxic fumes may be emitted when printing over the recommended temperature
- the temperature of the nozzle should not exceed 290 °C
- ventilate the room during printing
- printer with air filtration is appropriate (for example ACF filters)

Don't ruin your printer:

- avoid using stainless steel nozzle, but the brass one
- stainless steel parts may corrode when printing over the recommended temperature
- first heat up the bed, after temperature stabilization heat up the nozzle
- reduce material delay in the nozzle at melting temperatures
- clean the nozzle at the printing temperatures or lower – higher temperatures would cause degradation and possible release of harmful fumes

ENJOY YOUR PRINTING!

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