

# NonOilen<sup>®</sup>

(polylactic acid and polyhydroxy butyrate compound)

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**Printing temperature:** 175 – 195 °C

**Heated bed temperature:** 0 – 50 °C

**Speed:** 20 – 50 mm/s

**Part cooling fan:** 100 %

**Heated bed surface:** PEI, mirror/glass, LockPAD

**Adhesive:** 3DLac, PVA glue

**Raft / skirt / brim:** skirt

**Heated chamber / enclosure:** not needed

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- Adhesion** - It is recommended to use 3DLac or PVA glue as a separator of the object from the hotbed. NonOilen<sup>®</sup> can stick to the hotbed too much and it can damage the printed part or hotbed surface during removal.
- Overhangs** - It is recommended to use lower layer heights for overhangs higher than 50°. To achieve the best results, use a part cooling fan at 100 %.
- Printing** - The printing temperature should be set around 180 °C because under higher temperatures, the surface is rough, and stringing occurs due to high flow. Do not exceed 210 °C where the material can start degrading.