

# Fillamentum Fluorodur

(polyvinylidene fluoride)

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**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

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- 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.