NonOilen®

(polylactic acid and polyhydroxy butyrate compound)

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

Adhesion - It is recommended to use 3Dlac or PVA glue as a separator of the object from the hotbed. NonOilen® 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.

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NonOilen®

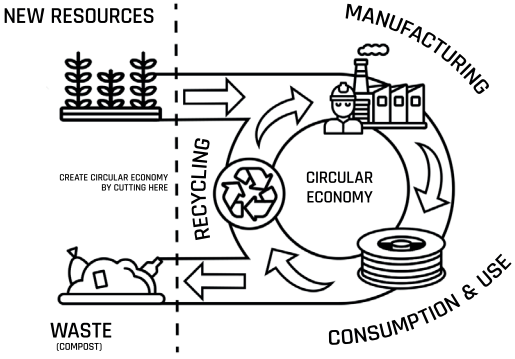
NonOilen® is revolutionary material.

This material perfectly fits the circular economy by:

- being **100% bio-based** – the beginning of the circle starts from the soil, it means that some plant consumed CO_2 from the environment first,
- being **recyclable** many times with little loss of the properties.

Thanks to these, you can **cut the source** of input materials and reuse the material itself.

Once the lifetime is over, it is **100% biodegradable** in industrial compost. Here the circle is closing, and **the nutrient** isolated from the soil are **returned for the nature**.



To support the circular economy, please:

- **think before you print** – minimise the disposable goods, design the functional objects, reduce the waste
- **reuse the printed object** – it has great properties, it can be cleaned in the dishwasher, and it resists to water
- **recycle the material** – you can send it to Fillamentum, and we will exploit the polymer
- **or dispose the material into biowaste** – if the recycling is not effective, put NonOilen® into biowaste
- **do not put it into plastic waste**, it would not be separated correctly, but incinerated
- **recycle the spool** – it is made of recycled PP, which has specific grey colour to be easily recognised on the sorting line and ensures good separation in the waste
- **recycle the bag** – it is plastic foil coated with aluminium, which can be thrown away into the plastic waste
- **recycle the box** – it is made of the recycled paper and it can be recycled again

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