

Fillamentum Timberfill®

(mixture of biopolymers filled with 15 % of natural fibers)

Printing temperature: 165 – 185 °C

Heated bed temperature: 40 – 55 °C

Speed: 40 – 60 mm/s

Part cooling fan: 100 %

Heated bed surface: PEI, mirror/glass, Kapton, Blue tape, LockPAD

Adhesive: Magigoo, 3DLac, PVA glue

Raft / skirt / brim: Skirt

Heated chamber / enclosure: not needed

Nozzle - We recommend using 0.5 mm nozzle for 1.75 mm filament and 0.6/0.8 mm nozzle for 2.85 mm filament for printing with Timberfill due to the fillers contained in the filament

Speed - It is better to use little bit higher speeds. Natural fibers may start to degrade/burn in slower speeds and that could lead into jams.

Storing - Airtight bag with desiccant.
In case of moist material, re-dry it in appropriate device. The conditions to achieve optimal level of moisture are 50 °C for 2–3 hours. Processing of moist filament may cause degradation of polymer chains, brittleness, poor layer adhesion, stringing, oozing etc.