

# SAFETY RECOMMENDATIONS FOR VINYL 303

## Don't harm yourself:

- avoid breathing of toxic fumes
- harmful toxic fumes are emitted
- ventilate the room during printing
- printer with air filtration is appropriate (for example HEPA filters)
- pregnant women should stay away when Vinyl 303 is processed

## Don't ruin your printer:

- don't use stainless steel nozzle, but the brass one
- stainless steel parts may corrode
- it is better to use Bowden type of printer

## Good printing results:

- nozzle temperature: 215 - 230 °C, don't use higher than 235 °C
- bed temperature: 80 °C
- printing speed: 40 - 60 mm/s
- bed adhesive: Magigoo, PVA based glue
- minimum layer height: 0.15 mm
- control printing of first layers - if it doesn't look well, turn off the printer and change the settings of first layer
- printing of PVC is recommended for experienced printers, not for beginners!

## Avoid clogging:

- first heat up the bed, after temperature stabilization heat up the nozzle
- reduce material delay in the nozzle, at elevated temperatures keep feeding or set removing of filament immediately after printing is finished
- the bed must be well calibrated - low level of nozzle may cause low flow and clogging
- clean the nozzle at the printing temperatures or lower - higher temperatures would cause clogging

**ENJOY YOUR PRINTING!**