

Design Guidelines

PA12 Nylon (MJF)	
Maximum bounding box	284 x 380 x 380 mm (Bead blasted and Black Smooth) 210 x 210 x 360 mm (Black Natural)
Minimum bounding box	4 x 4 x 1 mm or X + Y + Z > 9 mm (Bead blasted and dyed Black) 10 x 10 x 10 mm (Smooth)
Minimum supported wall thickness	0.4 mm (Bead blasted) 1.5 mm (Smooth)
Minimum unsupported wall thickness	0.5 mm (Bead blasted) 1.5 mm (Smooth)
Minimum supported wires	0.8 mm (Bead blasted) 1.5 mm (Smooth)
Minimum unsupported wires	0.9 mm (Bead blasted) 1.5 mm (Smooth)
Embossed details	0.2 mm high & wide (Bead blasted) 0.3 mm high & 0.5 mm wide (Smooth) (0.4 mm high & wide for readable text, logos, and icons)
Engraved details	0.2 mm deep & wide (Bead blasted) 0.3 mm deep & 0.5 mm wide (Smooth) (0.4 mm deep & wide for readable text, logos, and icons)
Single escape holes diameter	4.0 mm (Bead blasted) 10.0 mm (Smooth)
Multiple escape holes diameter	2.0 mm (Bead blasted) 8.0 mm (Smooth)
Clearance	0.6 mm (Bead blasted) 5.0 mm (Smooth)
Sprues	2 mm thick, attached in at least 2 places per part
Interlocking	Yes (Bead blasted) No (Smooth)
Enclosed	Yes
Multiple parts in file	Up to 250 (Bead blasted) Up to 10 (Smooth)
Accuracy	Bead blasted: ± 0.2 mm $\pm 0.5\%$ of the length Smooth: $\pm 0.4\%$ (with a lower limit of ± 0.2 mm)