

Design Guidelines

PA12 Nylon (SLS)	
Maximum bounding box	650 × 350 × 550 mm (Bead blasted white) 345 × 375 × 440 mm (Smooth White) 180 × 230 × 320 mm (Bead blasted & Smooth Black) 200 × 150 × 150 mm (Polished & Dyed Colors) [Parts over 330 mm long in any direction may have a visible line due to our dual laser printer]
Minimum bounding box	X + Y + Z ≥ 7.5 mm (Natural) X + Y + Z ≥ 25.0 mm and axes must be ≥ 2.5 mm (Processed) 10 x 10 x 10 mm (Smooth)
Minimum supported wall thickness	0.8 mm (Bead blasted & Polished) 1.5 mm (Smooth)
Minimum unsupported wall thickness	0.8 mm (Bead blasted & Polished) 1.5 mm (Smooth)
Minimum supported wires	0.8 mm (Bead blasted) 0.9 mm (Polished) 1.5 mm (Smooth)
Minimum unsupported wires	1.0 mm (Bead blasted and Polished) 1.5 mm (Smooth)
Embossed details	0.2 mm high & wide for details (Bead blasted & Polished) 0.3 mm high & 0.5 mm wide for details (Smooth) 0.5 mm high & wide for text (All)
Engraved details	0.2 mm deep & wide for details (Bead blasted & Polished) 0.3 mm deep & 0.4 mm wide for details (Smooth) 0.5 mm deep & wide for text (All)
Single escape holes diameter	4.0 mm (Bead blasted & Polished) 10.0 mm (Smooth)
Multiple escape holes diameter	2.0 mm (Bead blasted & Polished) 8.0 mm (Smooth)
Clearance	0.5 mm (Bead blasted & Polished) 10.0 mm (Smooth)
Sprues	2.0 mm thick, attached in at least 2 places per part.
Interlocking	Yes (Bead blasted & Polished) No (Smooth)
Enclosed	Yes (Bead blasted & Polished) No (Smooth)
Multiple parts in file	Up to 250 (Bead blasted & Polished) Up to 10 (Smooth)
Accuracy	± 0.15 mm, ± 0.15% of longest axis