

Design Guidelines

TPE (SLS)	
Maximum bounding box	190 × 190 × 290 mm
Minimum bounding box	$X + Y + Z \geq 15$ mm
Minimum supported wall thickness	0.8 mm (Bead blasted & Polished) 1.0 mm (Smooth)
Minimum unsupported wall thickness	0.8 mm (Bead blasted & Polished) 1.0 mm (Smooth)
Minimum supported wires	1.0 mm
Minimum unsupported wires	1.0 mm
Embossed details	0.8 mm high and wide
Engraved details	0.8 mm deep and wide
Single escape holes diameter	5.0 mm
Multiple escape holes diameter	5.0 mm
Clearance	2.0 mm
Sprues	2.0 mm thick, attached in at least 2 places per part.
Interlocking	Yes
Enclosed	Yes
Multiple parts in file	Up to 250 (Bead blasted & Polished) Up to 10 (Smooth)
Accuracy	± 0.25 mm , then $\pm 0.5\%$ of longest axis