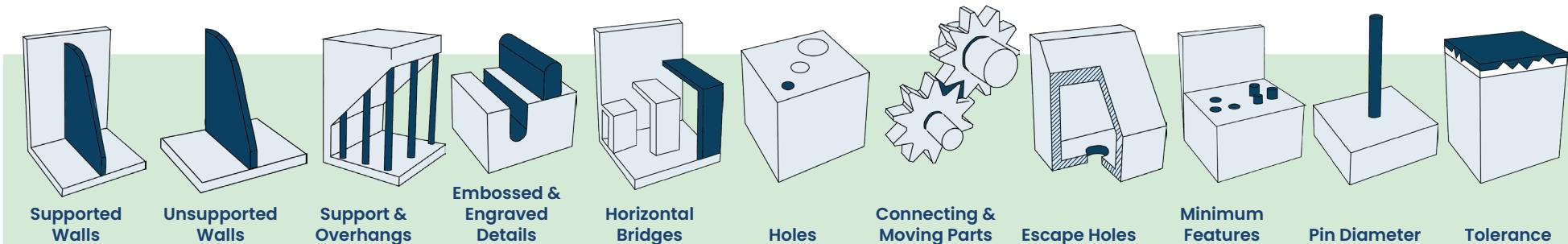


3D printing guidelines for every technology



	Supported Walls	Unsupported Walls	Support & Overhangs	Embossed & Engraved Details	Horizontal Bridges	Holes	Connecting & Moving Parts	Escape Holes	Minimum Features	Pin Diameter	Tolerance
SLS	PIXX 0.6 mm P3XX 0.8 mm P5XX 0.6 mm P7XX 0.8 mm	1 mm	N/A	1 mm width & height	N/A	> Ø1.5 mm depending on thickness	> 0.3 mm for moving parts; > 0.1 mm for connection assemblies; > 0.5 mm radial	> 12 mm multiple holes are preferred	PIXX 0.5 mm P3XX 0.6 mm P5XX 0.5 mm P7XX 0.6 mm	> 1 mm diameter < 15 mm height	Minimum ± 0.3 mm & ± 0.25% of dimension
SAF™	0.8 mm	1 mm	N/A	1 mm width & height	N/A	> Ø1.5 mm depending on thickness	> 0.3 mm for moving parts; > 0.1 mm for connection assemblies; > 0.5 mm radial	> 12 mm multiple holes are preferred	2 mm	> 2 mm diameter < 15 mm height	Minimum ± 0.3 mm & ± 0.25% of dimension
MJF	0.5 mm	1 mm	N/A	0.4 mm width & height	N/A	> Ø0.8 mm depending on thickness	> 0.3 mm for moving parts; > 0.3 mm for connection assemblies; > 0.3 mm radial	> 6 mm multiple holes are preferred	0.5 mm	> 1 mm diameter < 15 mm height	Minimum ± 0.3 mm & ± 0.25% of dimension
FDR	0.2 mm	0.4 mm	N/A	0.4 mm width & height	N/A	> Ø0.6 mm depending on thickness	> 0.3 mm for moving parts; > 0.1 mm for connection assemblies; > 0.5 mm radial	> 6 mm multiple holes are preferred	0.25 mm	> 0.5 mm diameter < 15 mm height	Minimum ± 0.2 mm & ± 0.2% of dimension
SLA	HR 0.25 mm NR 0.5 mm	HR 0.5 mm NR 1 mm	Support ≤ 30°	0.4 mm width & height	N/A	> Ø0.5 mm depending on thickness	> 0.1 mm for moving parts > 0.1 mm for connections	> 3 mm multiple holes are preferred	0.25 mm	> 0.5 mm diameter < 15 mm height	Minimum ± 0.1 mm & ± 0.15% of dimension
PolyJet™	0.8 mm	1 mm	Support always required	0.5 mm width & height	N/A	> Ø0.5 mm	> 0.2 mm for moving parts; > 0.1 mm for connection assemblies; > 0.8 mm radial	> 20 mm multiple holes are preferred	0.5 mm	> 1 mm diameter < 15 mm height	Minimum ± 0.2 mm & ± 0.25% of dimension
FDM	0.8 mm	1 mm	Support ≤ 45°	0.6 mm width & height	10 mm	> Ø2 mm	> 0.5 mm	> 20 mm	2 mm	> 3 mm diameter < 15 mm height	Minimum ± 0.2 mm & ± 0.25% of dimension