



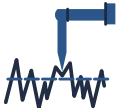
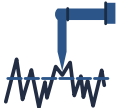




DESIGN GUIDELINES

LASER POWDER BED FUSION & BINDER JETTING



IT CLASS	 IT class 11-13	 IT class 14
WALL THICKNESS	 Wall thickness >0,5 mm	 Wall thickness 1.5 - 30 mm
SURFACE QUALITY	 Surface: Rz<50 µm	 Surface: Rz 45 µm
PART SIZE	 Compact & complex design	 Recommended maximum green part size ~ 100 x 100 max. 80 mm
	<ul style="list-style-type: none"> > Self-supporting angle >45° > Sharp edges to prefer against radius > Min. holes diameter > 0,5 mm > Holes diameter > 10 mm in horizontal orientation require supports > Fragile details possible (≥0,4 mm depending on dimensions and materials) > Aspect ratio: height of the wall / wall thickness ≤ 40:1 if t>1 mm <p>Large scaled parts have larger distortion</p>	<ul style="list-style-type: none"> > No support structure for overhangs at printing > Radii at corners/chamfers preferred 0,5 mm > Hole aspect ratio 10:1 / Min. hole diameter 1 mm > Pin aspect ratio 5:1 / Min. pin diameter 1,5 mm > Embossed / engraved structures > 0,5 mm > Min. thickness for supported/ unsupported walls 0,5/1,0 mm > Inner cavities possible with intake and exhaust hole > Sinter: flat surface for sinter placing preferred / Setter can be offered as printed in / life / ceramic > Distortion depended of size and geometry

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