

Design Rules

Have a look at the following standard considerations when you are designing a piece which needs to be manufactured by each process:

- **Stereolithography (SLA)**



When you print mechanical systems, please consider the indicated air gap.



We must ensure that this situation would not happen.



Minimum Width: 0.2 mm



Hole flow

Minimum diameter: 8mm

In the case of hollow parts, the support material has been added inside it. The part must have at least one hole flow with the minimum diameter value. A bigger part would need more number of holes and / or its diameter has to be bigger.

Note: You can create gaps to minimize the effect of these holes on the aesthetic / part functionality.

Service details:

Max Build Volume: **380x380x250mm**

Tolerance/ Precision: **0.025 -0.05mm**

Available materials: (**deverá estar linkado para a página dos materiais**) **Visijet SL Flex; Visijet SL Clear**

Minimum order amount: **No**

Base fixed cost per build: **None**

Parts are quoted by: **Build Volume +Support structure volume+Machine hours**

• Micro SLA

This technology of 3D print is ideal for small, precise, detail-rich parts and casting patterns such as jewelry, electronic components and dental wax-ups. Our machine can prints 30 micron layers at a 585 dpi resolution resulting from fine feature-details reflecting true-to-CAD accuracy.

Service details:

Max Build Volume: **43x27x150 mm**

Tolerance / Precision: **0.056mm**

Available materials: **VisiJet FTX Green**

Minimum order amount: **No**

Base fixed cost per build: **No**

Parts are quoted by: **Building volume + Support structure volume + Machine hours**

• **Polyjet**



Minimum wall thickness of material: 1mm

Digital ABS: 2mm



Air gap

Linear motions: 0.3mm

Gears: 0.8 mm

Note: These figures are approximate for the project parts created by this technology. The ability allows us to have finer details on the product, the cleanliness of them may reduce problems



We must ensure that this situation would not happen.



Embossing: Minimum Deep: 0.5mm

Minimum Width: 0.2mm



Hole flow

Minimum diameter: 10.mm

Note: In the case of hollow parts, the support material has been added inside it. The part must have at least one drain hole with the diameter value. A bigger part would need more number of holes and / or its diameter has to be bigger.

Service details:

Max Build Volume: **500x400x200 mm**

Tolerance / Precision: **0.016mm**

Available materials: **Digital ABS**

Vero White and Black (rigid opaque);

Tango Black; TangoPlus (rubber-like)

Durus Black (polypropilene-like)

Dental-Biocompatible

Minimum order amount: **No**

Base fixed cost per build: **None**

Parts are quoted by: **Build volume + Support structure volume +Machine hours**

• **3D Color Prints**



Minimum wall thickness of material: 1mm



Air gap: 0.6mm

Note: When you print mechanical systems, please consider the indicated air gap.



We must ensure that this situation would not happen.



Embossing: Minimum Deep: 0.2mm

Minimum Width: 0.2mm



Minimum diameter hole 1: 4mm

2 or more holes: 2 mm

Note: In the case of hollow parts, dust can be accumulated in the inner part. So In the part, you must have at least one hole flow with the minimum diameter value. A bigger part would need more number of holes and / or its diameter has to be bigger. If your part has more than one hole, you can reduce the diameter to half.

Service details:

Max Build Volume: **203x254x203 mm**

Tolerance / Precision: **0.1mm**

Available materials: Visijet C4 Spectrum with up to 1 million colors

Minimum order amount: **No**

Base fixed cost per build: **No**

Parts are quoted: by **Build volume +Support structure volume+ Machine hours**



- **If you have questions, please do not hesitate to contact us.**