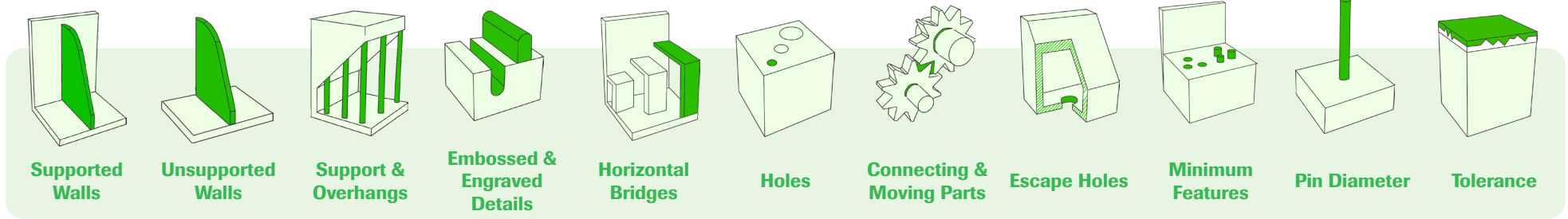


3D PRINTING GUIDELINES FOR EVERY TECHNOLOGY



	Supported Walls	Unsupported Walls	Support & Overhangs	Embossed & Engraved Details	Horizontal Bridges	Holes	Connecting & Moving Parts	Escape Holes	Minimum Features	Pin Diameter	Tolerance
SLS	P1XX 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	P1XX 0.5 mm P3XX 0.6 mm P5XX 0.5 mm P7XX 0.6 mm	> 1 mm diameter < 15 mm height	Minimum ± 0.2 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 ± 0.2 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 ± 0.2 mm & ± 0.25% of dimension
FDR	0.2 mm	0.4 mm	N/A	0.4mm 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	1-3 mm ± 0.08 mm; 4-6 mm ± 0.11 mm; 7-10 mm ± 0.14 mm; 11-18 mm ± 0.17 mm; 19-30 mm ± 0.20 mm; 31-50 mm ± 0.23 mm
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

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