



PRODUCT SHEET

	MACHINE TYPE	BUILD ENVELOPE (X x Y x Z mm)	MATERIAL NAME	DESCRIPTION	COLOUR	LAYER THICKNESS	TOLERANCES	ELONGATION AT BREAK	E-MODULE	TENSILE STRENGTH	MIN. MATERIAL THICKNESS
SLA	Viper SLA <i>Very fine details and nice surface</i>	250 x 250 x 250 250 x 250 x 250 250 x 250 x 70	SOMOS WaterShed XC 11122 ACCURA 25	Epoxy	Transparent White	0,05 / 0,1 mm 0,05 / 0,1 mm	Tolerance up to 50 mm +/- 0,08 mm Per following 50 mm +/- 0,2 %	11-20 % 13-20 %	2650-2882 MPa 1590-1660 MPa	47-53 MPa 38 MPa	0,3 mm
SLS	SLS HQ HS sPro 60 HS <i>Very strong and flexible material</i>	320 x 270 x 360	DURAFORM PA	Nylon PA12	White	0,1 mm	Tolerance up to 50 mm +/- 0,15 mm Per following 50 mm +/- 0,3 %	14 %	1586 MPa	43 MPa	X&Y = 0,6 mm Z = 0,3 mm
MJF	HP MJF 4200 <i>Very strong and flexible material</i>	380 x 284 x 380	HP 3D High Reusability PA12	Nylon PA12	Grey Black	0,08 mm	+/- 0,2 mm	X&Y: 20 % Z: 15 %	X&Y: 1700 MPa Z: 1800 MPa	48 MPa	0,3 mm
POLYJET	Connex 500 <i>Up to 11 components in the same part</i>	500 x 400 x 200	TangoBlack+ (Shore 27A) DM 9840 (Shore 40A) DM 9850 (Shore 50A) DM 9860 (Shore 60A) DM 9870 (Shore 70A) DM 9885 (Shore 85A) DM 9895 (Shore 95A) DM 8530 DM 8520 DM 8510 VeroWhite+ (Shore 83D)	Acrylic	Black Black Black Black Black Black Black-grey Dark grey Grey Light grey White	0,016 mm 0,030 mm	Hard parts: Tolerance up to 50 mm +/- 0,1 mm Per following 50 mm +/- 0,3 %	218 % 160 % 140 % 90 % 60 % 55 % 30 % 60-70 % 50-60 % 35-45 % 10-25 %	1750 MPa 2150 MPa 2350 MPa 2000-3000 MPa	1,455 MPa 1 MPa 1 MPa 3 MPa 3 MPa 6 MPa 20 MPa 39 MPa 44 MPa 49 MPa 55-60 MPa	0,6 mm
	Eden 500V <i>Hard and rubber like with a nice surface</i>	500 x 400 x 200	TangoBlack+ (Shore 27A) FullCure 720 (Shore 83D) VeroClear 810 (Shore 83D)	Acrylic	Black Semi-transparent Transparent	0,016 mm 0,030 mm	Tolerance up to 50 mm +/- 0,1 mm Per following 50 mm +/- 0,3 %	218 % 10-20 % 10-20 %	2870 MPa 2495 MPa	1,455 MPa 60,3 MPa 49,8 MPa	0,6 mm
	Eden 260 <i>Material with a nice surface</i>	250 x 250 x 200	FullCure 720 (Shore 83D) VeroWhite+ (Shore 83D) VeroGray 850 (Shore 83D)	Acrylic	Semi-transparent White Grey	0,016 mm	Tolerance up to 50 mm +/- 0,1 mm Per following 50 mm +/- 0,3 %	20 % 20 % 15 %	2870 MPa 2495 MPa 3000 MPa	60 MPa 50 MPa 60 MPa	0,6 mm
FDM	STRATASYS Dimension SST1200es <i>Strong and functional parts</i>	254 x 254 x 305	ABSplus™	ABS	Ivory, white, black, grey, red, blue, olive green, orange and yellow	0,254 mm 0,330 mm	Tolerance up to 50 mm X&Y = +/- 0,15 mm Z = + 0,2 mm Per following 50 mm X&Y = +/- 0,3 %	6 %	2,200 MPa	33 MPa	1,27 mm
WAX	Projet CPX 3000 Plus <i>Very fine details, perfect for lost wax</i>	XHD: 203 x 178 x 152 UHD: 203 x 178 x 152 HD: 298 x 185 x 203	VisiJet M3 Hi-cast	Wax	Blue	0,016 mm 0,020 mm 0,033 mm	Tolerance up to 50 mm +/- 0,05-0,1 mm Per following 50 mm +/- 0,2 %	N/A	N/A	N/A	0,5 mm

All values are guide lines within the build envelope, because final tolerances and material thickness are dependent on geometry and orientation in the machine. Large SLS-parts can twist. For scale models in SLS I the smallest recommended material thickness: X=1,0 mm. / Y=1,0 mm. / Z=1,0 mm (thicker for larger areas). The CAD files will NOT be checked for clearance, because we assume that the customers 3D files takes the tolerances for the decided technology into account. We recommend the customer to take a dialogue with us regarding tolerances etc. before ordering 3D Print.



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PLASTER	ZPrinter Z650 <i>Can be printed in different colours</i>	250 x 380 x 200	Visijet PXL Core (Shore 81D)	Plaster	390.000 colours	0,1 mm	Tolerance up to 50 mm +/- 0,3 mm Per following 50 mm +/- 0,3 %	0,2 %	N/A	4 MPa	1,5 mm
DLP	Envisiontec-Perfactory DDSP <i>Very fine details and surface</i>	100 x 75 x 100	E-shell 200 Pink Biocompatible	Epoxy	Skintone	0,1 mm	Tolerance up to 50 mm +/- 0,08 mm Per following 50 mm +/- 0,2 %	6 %	2400 MPa	57,8 MPa	0,4 mm
	PUR casting		55A 40-90A 68-80D 74-85D	Silicone Soft PUR Flexible PUR Hard PUR							

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