



PRODUCT SHEET

	MACHINE TYPE	BUILD ENVELOPE (X x Y x Z mm)	MATERIAL NAME	DESCRIPTION	COLOUR	WALL THICKNESS	TOLERANCES	ELONGATION AT BREAK	E-MODULE	TENSILE STRENGTH	IMPACT STRENGTH	MIN. MATERIAL THICKNESS
SLA	Viper S12 <i>Very fine details and nice surface</i>	250 x 250 x 250 250 x 250 x 250	SOMOS Watershed XC 11122 Accura 25	Epoxy	Transparent White	0,05 / 0,1 mm 0,05 / 0,1 mm	Measures up to 50 mm: +/- 0,08 mm Measures above 50 mm: +/- 0,2 %	11-20 % 13-20 %	2650-2882 MPa 1590-1660 MPa	47-53 MPa 38 MPa	25 J/m 14-24 J/m	0,3 mm
	ProJet 6000 <i>Very fine details and nice surface</i>	250 x 250 x 250	Accura Xtreme	Epoxy	Grey	0,05 / 0,1 mm	Measures up to 50 mm: +/- 0,08 mm Measures above 50 mm: +/- 0,2 %	18 %	1890 MPa	41 MPa	44 J/m	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 PA 12	White	0,1 mm	Measure up to 50 mm: +/- 0,20 mm Measures above 50 mm: +/- 0,3 %	14 %	1586 MPa	43 MPa	32 J/m	X&Y: 0,6 mm Z: 0,3 mm
MJF	HP MJF 4200 & 4210 <i>Very strong and flexible material</i>	380 x 284 x 370	HP 3D HR PA12	Nylon PA 12	Mottled grey	0,08 mm	Measures up to 100 mm: +/- 0,20 mm Measures above 100 mm: +/- 0,2 % Z: +/- 0,4 %	X&Y: 20 % Z: 15 %	X&Y: 1700 MPa Z: 1800 MPa	48 MPa	3,5 kJ/m ²	0,3 mm
	HP MJF 580 <i>Very strong and flexible material</i>	332 x 190 x 248	HP 3D HR CB PA12	Nylon PA 12	Light grey and multi coloured	0,08 mm	Measures up to 100 mm: +/- 0,20 mm Measures above 100 mm: +/- 0,2 % Z: +/- 0,3 %	X&Y: 20 % Z: 14 %	X&Y: 1600 MPa Z: 1700 MPa	46 MPa	X&Y: 3,1 kJ/m ² Z: 2,8 kJ/m ²	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) FullCure 720 (Shore 83D) VeroClear 810 (Shore 83D)	Acrylic	Black Black Black Black Black Black Black Black-grey Dark grey Grey Light grey White Semi-transparent Transparent	0,016 mm 0,030 mm	Hard parts: Measures up to 50 mm: +/- 0,1 mm Measures above 50 mm: +/- 0,3 %	218 % 160 % 140 % 90 % 60 % 55 % 30 % 60-70 % 50-60 % 35-45 % 10-25 % 10-20 % 10-20 %	1,455 MPa 1750 MPa 2150 MPa 2350 MPa 2000-3000 MPa 2870 MPa 2495 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 60,3 MPa 49,8 MPa	21-40 J/m 22-35 J/m 22-35 J/m 20-30 J/m 20-30 J/m	0,6 mm

All values are guidelines, because final tolerances and material thickness are dependent on geometry and orientation in the machine. Large SLS- and MJF-parts can twist. For scale models in SLS and MJF the smallest recommended material thickness is: 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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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	Measures up to 50 mm: X&Y = +/- 0,15 mm Z = + 0,2 mm Measures above 50 mm: X&Y = +/- 0,3 %	6 %	2,200 MPa	33 MPa	106 J/m	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	Measures up to 50 mm: +/- 0,05-0,1 mm Measures above 50 mm: +/- 0,2 %	N/A	N/A	N/A		0,5 mm
PUR	PUR casting		55A 40-90A 68-80A 74-85A	Silicone Soft PUR Flexible PUR Hard PUR								

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