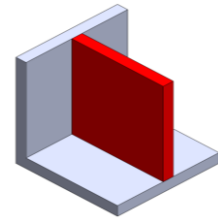


Design Guideline FDM

Supported Walls

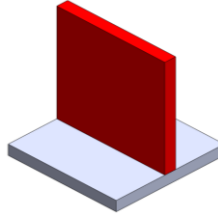
Walls that are connected to the surrounding of the part on at least two sides.



1.0[mm]

Unsupported Walls

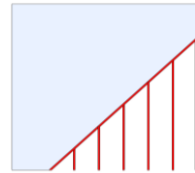
Unsupported walls are connected to the surrounding of the part on less than two sides.



1.0[mm]

Support & Overhangs

The maximum angle a wall can be printed at without requiring support.



45° angle

Embossed & Engraved Details

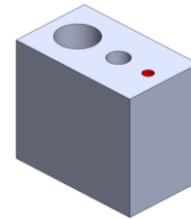
Features on the model that are raised or recessed below the model surface.



Min. 1.0[mm] embossed
Min. Font 14pt
Clearly legible font depends strongly on the font type

Holes

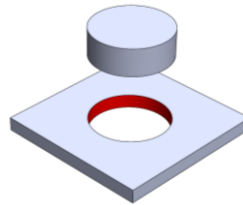
The minimum diameter to successfully manufacture a hole.



2.0[mm] highly depends on the hole length and surrounding wall thickness

Connecting / Moving Parts

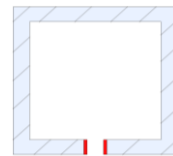
The recommended clearance between two moving or connecting parts.



0.5[mm]

Escape Holes

The minimum diameter of escape holes to allow the removal of the material.

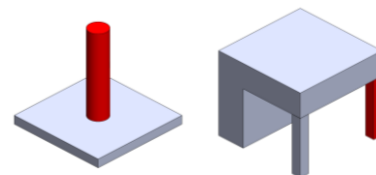


Not required

Pin Diameter / Minimum Features

The minimum diameter a pin can be printed at.

The recommended minimum size of a feature to ensure it will not fail to manufacture.



Min. pin diameter: 3.0[mm]
Min. features: 2.0[mm]

Post Treatment

[Chemical surface smoothing](#)

[Paint finishing](#)

[Infiltrating with epoxy resin](#)