



3DP Fundamentals

PRECISION

- Dimensional accuracy will vary based upon part size, geometry, and orientation. Our systems are designed to produce concept 3D models which do not typically require great precision.
- Plan for +/- .005 in
- NOTE: line-line design results in a press fit

FEATURE THICKNESS

- Preferred wall thickness = .06 in (1.5 mm)
- Min. recommended thickness = .04 in (1mm)
- NOTE: Appropriate wall thickness is entirely dependent on part geometry

PostPlate.STL

PostPlateHoles.STL

FinsStraight.STL

FinsRound.STL

MATERIAL PROPERTIES

- ABSplus-P430 / Ivory
- Tensile Strength = 4700 psi (33 Mpa)
- Elongation Strength = 6.0%
- MATERIAL PROPERTIES (106J/m)
- Flexural Strength = 8450 psi (58 Mpa)
- IZOP Impact, notched = 2.0 ft-lb/in
- Heat Deflection = 204°F (96°C)

CORE DENSITY

- Core density impacts print time
- Core density impacts material usage / cost

SolidCore.STL

HighDensity.STL

LowDensity.STL

Hollow.STL

SOLID CORE

Model = 1.64 in
Support = .35 in
Time = :47 min

HIGH DENSITY

Model = 1.36 in
Support = .35 in
Time = :41 min

LOW DENSITY

Model = .86 in
Support = .35 in
Time = :31 min

HOLLOW

Model = .53 in
Support = .35 in
Time = :24 min