

# MATERIALS COMPARISON - Design guidelines

## Resins



A brand of BASF - We create chemistry

	MATERIAL	LAYER THICKNESS	ACCURACY	MINIMUM WALL THICKNESS	MAX SIZE (mm)	MINIMUM VISIBLE DETAIL	MINIMUM CLEARANCE	MIN SIZE OF TEXT	ENGRAVING	EMBOSSING	ENLARGEMENT RATIO	INTERLOCKING PARTS	ASSEMBLY	HOLLOWING	ENCLOSED PARTS
DLS	<a href="#">Rigid Polyurethane</a>	100µm	XY: ±0.1 mm Z: ±0.4 mm	Unsupported: 2.5 mm Supported: 1 mm	180 x 110 x 290 (z) mm	0.5 mm	0.4 mm	3 mm	0.3 mm	0.3 mm	1/1	No	Yes	No	No
	<a href="#">Elastomeric Polyurethane</a>	100 µm	-	Unsupported: 2.5mm Supported: 1mm	180 x 110 x 100mm	0.6 mm	0.5 mm	0.3 mm	0.3 mm	0.3 mm	1/1	No	Yes	No	No
	<a href="#">Flexible Polyurethane</a>	100 µm	min of ± 0.3 mm	2.5mm unsupported 1mm supported	180 x 110 x 100 mm	0.5mm	0.5 mm	-	0.3mm	0.3mm	1/1	No	Yes	No	No
	<a href="#">Cyanate Ester</a>	100 µm	XY: ±0.1 mm Z: ±0.4 mm	0.5 mm	180 x 110 x 290 mm	0.5 mm	0.6 mm	3 mm	-	-	1/1	No	Yes	No	No
	<a href="#">Urethane Methacrylate</a>	100 µm	XY: ±0.1 mm Z: ±0.4 mm	Unsupported: 2.5 mm Supported: 1 mm	180 x 110 x 290 (z) mm	0.5 mm	0.5 mm	3 mm	0.3 mm	0.3 mm	1/1	No	Yes	No	No
SLA	<a href="#">Prototyping Resin</a>	100 µm	-	0.8mm	144 x 144 x 174 mm				0.5 mm	0.5 mm	1:6	Not recommended	No	No	Not recommended
Polyjet	<a href="#">VeroWhite</a>	28µm	-	2mm	203 x 254 x 251 mm	0.2 mm	0.4 mm	0.8mm	0.5 mm	0.5 mm	1/1	Yes	Yes	Yes	Yes
	<a href="#">VeroClear</a>	28µm	-	2mm	203 x 254 x 251 mm	0.2 mm	0.4 mm	0.8mm	0.5 mm	0.5 mm	1/1	Yes	Yes	No	Yes

All materials available at: [sculpteo.com](https://www.sculpteo.com)