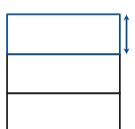
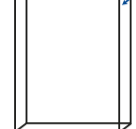
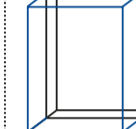
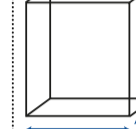
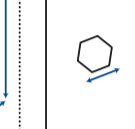
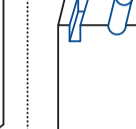
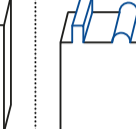
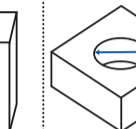
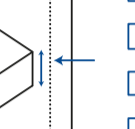
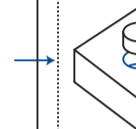
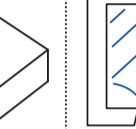


MATERIALS COMPARISON - DESIGN GUIDELINES

Resins

		LAYER THICKNESS	MINIMUM WALL THICKNESS	ACCURACY	MAX SIZE (mm)	MINIMUM VISIBLE DETAIL	ENGRAVING	EMBOSSING	ENLARGEMENT RATIO	INTERLOCKING & ENCLOSED PARTS	ASSEMBLY	HOLLOWING
		Print resolution	Minimum recommended wall size to ensure there are no errors during printing	Expected degree of dimensional accuracy	Maximum dimensions possible to respect an item	Minimum dimension to ensure detail visibility	Graphic elements hollowed out on the surface of the model	Graphic elements raised above the surface of the model	Minimum ratio to be observed between the diameter of a hole and the thickness of the wall of the model	Possibility to print parts that will articulate between each other & Possibility to print a model with volume inclusions	Possibility of assembling parts while leaving a minimum space between them	Optimization of the weight and price of a model by removing internal material
MATERIAL												
Technology DLS	Rigid Polyurethane	100 µm	Unsupported : 2.5mm Supported : 1mm	XY: ± 0.1mm Z: ± 0.4mm	180 x 110 x 290 (z) mm	0.5mm	0.3mm	0.3mm	1/1	No & No	Yes (min space 0.4mm)	No
	Elastomeric Polyurethane	100 µm	Unsupported : 2.5mm Supported : 1mm	-	180 x 110 x 100 mm	0.6mm	0.3mm	0.3mm	1/1	No & No	Yes (min space 0.5mm)	No
Technology SLA	Prototyping Resin	100 µm	0.8mm	±0.2% (with a lower limit of ±0.2 mm)	144 x 144 x 174 mm	-	0.5mm	0.5mm	-	Not recommended	No	Not recommended
Technology Polyjet	VeroWhite	28 µm	2mm	-	203 x 254 x 251 mm	0.2mm	0.5mm	0.5mm	1/1	No & No	Yes (min space 0.4mm)	Yes
	VeroClear	28 µm	2mm	-	203 x 254 x 251 mm	0.2mm	0.5mm	0.5mm	1/1	Yes & Yes	Yes (min space 0.4mm)	Non
Technology DLP / LCD	Ultracur3D® EPD 1086 3D	100 µm	0.6mm	± 100µm	120 x 120 x 120 mm	-	0.3mm	0.3mm	1/1	No & No	No	No
	Ultracur3D® ST 45	100 µm	0.6mm	± 200µm	192 x 108 x 330 mm	-	0.3mm	0.3mm	-	No & No	-	No
	Ultracur3D® RG 3280	100 µm	0.6mm	± 100µm	120 x 120 x 120 mm	-	0.3mm	0.3mm	-	No & No	-	No