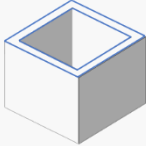
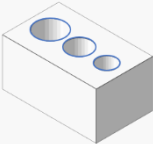


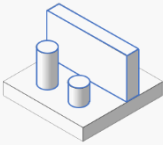
## Design guidelines


For polymer parts produced with Selective Laser Sintering

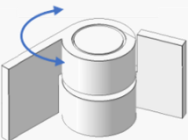
### DESIGN FEATURES

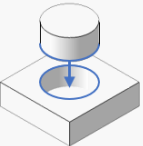
	Maximum part dimensions	Walls <i>Recommended wall thickness</i>		
		Minimum thickness [mm]	Optimum thickness [mm]	Maximum thickness [mm]
	100 x 100 x 100 mm	0.7	1.5-6.0	8.0
	250 x 250 x 250 mm	1.0	2.0-8.0	10.0


	Maximum part dimensions	Holes <i>Recommended hole diameter</i>		
		Minimum diameter [mm]	Optimum diameter [mm]	Maximum diameter [mm]
	100 x 100 x 100 mm	1.5	≥ 2.0	n/a
	250 x 250 x 250 mm	2.0	≥ 3.0	n/a

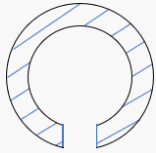
	Maximum part dimensions	Feature size <i>The recommended width of a feature to ensure it will not fail to print<sup>1</sup></i>		
		Minimum width [mm]	Optimum width [mm]	Maximum width [mm]
	100 x 100 x 100 mm	1.5	≥ 2.0	n/a
	250 x 250 x 250 mm	2.0	≥ 3.0	n/a

	Maximum part dimensions	Channels <i>The recommended channel diameter<sup>2</sup></i>		
		Minimum diameter [mm]	Optimum diameter [mm]	Maximum diameter [mm]
	100 x 100 x 100 mm	2.5	≥ 4.0	n/a
	250 x 250 x 250 mm	3.0	≥ 5.0	n/a

	Maximum part dimensions	Connecting parts: Moving <i>The recommended clearance between two moving parts</i>		
		Minimum clearance [mm]	Optimum clearance [mm]	Maximum clearance [mm]
	100 x 100 x 100 mm	0.3	0.5-0.6	n/a
	250 x 250 x 250 mm	0.5	0.6-0.8	n/a

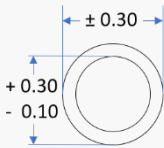
	Maximum part dimensions	Connecting parts: Press fit <i>The recommended clearance between two parts to obtain press fit</i>
		Minimum clearance [mm]
	100 x 100 x 100 mm	0.1
	250 x 250 x 250 mm	0.2

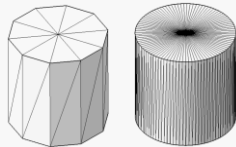
<b>Embossed or engraved details or text</b>				
<i>The recommended dimensions for features raised or recessed below the model surface</i>				
	<b>Maximum part dimensions</b>	<b>Minimum feature width/height [mm]</b>	<b>Optimum feature width/height [mm]</b>	<b>Minimum font height [mm]</b>
	100 x 100 x 100 mm	0.5	1.0	5.0
	250 x 250 x 250 mm	0.5	1.0	5.0

<b>Escape holes</b>			
<i>The recommended hole diameter to ensure powder free hollow parts</i>			
	<b>Maximum part dimensions</b>	<b>Minimum diameter [mm]</b>	<b>Minimum amount of escape holes</b>
	100 x 100 x 100 mm	8.0	2
	250 x 250 x 250 mm	8.0	2

- 1 - Maximum feature height to width ratio of 5:1
- 2 - Maximum channel length = 100 mm

## PART QUALITY

<b>Tolerances</b>			
<i>Valid for nominal sizes above 10 mm</i>			
	<b>Maximum part dimensions</b>	<b>Linear dimensions [mm]</b>	<b>Hole diameter [up to 50mm]</b>
	100 x 100 x 100 mm	IT12 [ISO 286-1]	+ 0.10 - 0.30
	250 x 250 x 250 mm	IT13 [ISO 286-1]	+ 0.10 - 0.30

<b>Required data format</b>			
<i>Oceanz printing technology uses .STL format, all files are converted to this format</i>			
	<b>STL conversion</b>	<b>Surface deviation [mm]</b>	<b>Angle tolerance [°]</b>
	Export settings	0.01	10-20

This guide covers specific details and design rules how to avoid unintended failures when designing for SLS. To avoid print failure, values for each specification must stay within the minimum-maximum range. To guarantee our manufacturing tolerances, your design should meet the optimum values for each specification. Please note that due to the layer by layer production process and the specific design of each individual product values may differ.

If your design contains specific details or features not mentioned in our design rules, or your design exceeds the maximum part dimensions, please contact us, so we can advise you how to obtain required part quality.

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## Tolerance grades

ISO 286-1:2010

Table 1 – Values of standard tolerance grades for nominal sizes up to 800 mm, extracted from ISO standard ISO 286-1:2010.

Nominal size (mm)		IT12 <sup>[1]</sup> Standard tolerance values [mm]	IT13 <sup>[1]</sup> Standard tolerance values [mm]
Above	Up to and including		
-	3	n/a	n/a
3	6	0.12 <sup>[2]</sup>	0.18 <sup>[2]</sup>
6	10	0.15 <sup>[2]</sup>	0.22 <sup>[2]</sup>
10	18	0.18	0.27
18	30	0.21	0.33
30	50	0.25	0.39
50	80	0.30	0.46
80	120	0.35	0.54
120	180	0.40	0.63
180	250	0.46	0.72
250	315	0.52	0.81
315	400	0.57	0.89
400	500	0.63	0.97
500	630	0.70	1.10
630	800	0.80	1.25

[1] To guarantee IT12 or IT13 tolerances values, your design should meet the optimum values of the Oceanz design guidelines (see Design Guidelines.pdf)

[2] For nominal values between 3 and 10 mm, tolerance values of line 10-18 mm are valid

This classification can be compared with ISO 2768-1:1990 for linear dimensions. For parts up to 100x100x100 mm classification 'm' will be valid for linear dimensions of 6 mm and larger. For parts up to 250x250x250 mm tolerance class 'c' will apply.

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