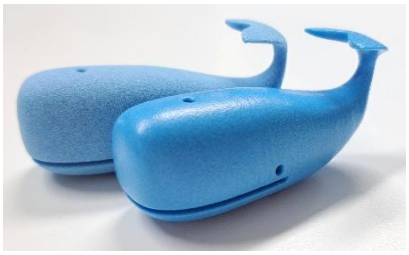
OCEANZ VAPOR POLISH

High quality smoothening of parts produced by Selective Laser Sintering



3D printed parts manufactured by Oceanz can be post-processed to obtain a high quality end product. One of the available options is vapor polish. During this smoothening process the part is hanged in a vacuum process chamber. A solvent is introduced that slightly dissolves the part surface. This smoothens and seals the part surface. After smoothening, the solvent evaporates, leaving the original material properties intact. The technology is therefore skin- and food safe.

Vapor polish is available for Oceanz PA12, PA12 BLUE, PAGF, GREY, FLEXIBLE and PA11 and can be combined with coloring.

Process guidelines	
Process chamber	540 x 340 x 320 mm
Design rules	Wall thickness min. 1,5 mm (2,0 mm for FLEXIBLE) and max. of 10,0 mm
	Details / text need a minimum height or depth of 0,50 mm
	Internal holes / channels need a minimum diameter of 8 mm to be processed
Part quality	Improved air- and watertightness
	Improved surface roughness
Food safe	Oceanz PA12 and Oceanz PA12 Blue
Skin safe	Oceanz PA12, Oceanz PA11 and Oceanz FLEXIBLE

Parts need to be hanged to be processed. This might leave a small mark on the part. In rigid materials this is nearly invisible, but in FLEXIBLE it will be visible.

Please note that a large variation in wall thickness within a part (≥ 4.0 mm) might result in different level of smoothening. Large wall thickness (>10 mm) can result in overprocessing, which will result in a thin film in corners and ridges. Adding a radius to sharp corners and edges will help to prevent this.

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