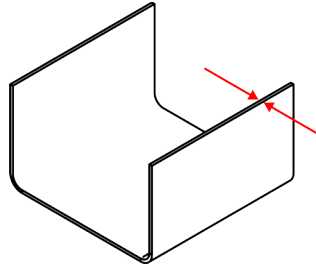
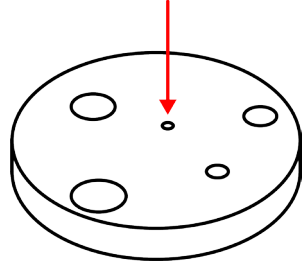


naturalrobotics

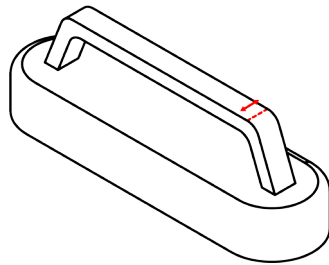
DESIGN TIPS FOR YOUR PRINT JOB.



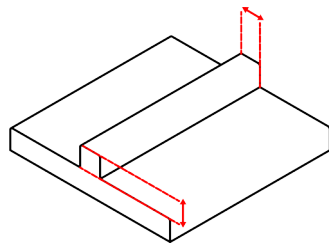
Wall thickness - The minimum wall thickness to ensure a successful 3D print varies between 0.7 mm (for PA12) up to 2.0 mm (for carbon filled polyamide).



Hole size - All holes should be larger than 1.5 mm diameter.

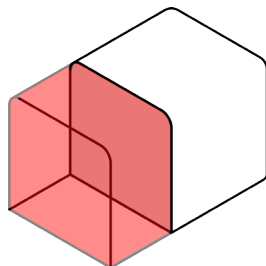


Feature size (pins, protruding features etc.) - A minimum size of 1 mm is recommended.

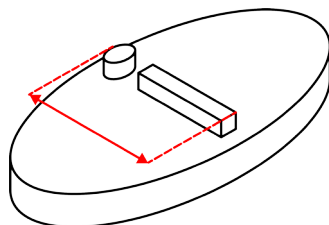


Embossed and engraved details - To ensure small details are visible the following rules apply:

- Minimum depth of engraving 1 mm
- Minimum height of embossing 1 mm

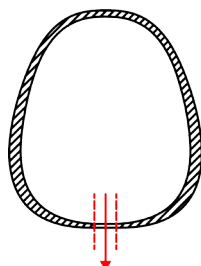


Tolerances - Typical tolerances for SLS parts are ± 0.3 mm.



Text - To ensure readability of text the following rules apply:

- Minimum font height of 2 mm (font size 14) suitable for every direction
- Sans serif font is recommended for readability



Escape holes - To save weight (and sometimes costs) SLS parts are printed hollow. To remove unsintered powder after production escape holes must be included. Escape holes must be a minimum of 3.5 mm diameter. We recommend to include two holes, so it will be easier.