DESIGN RULES FOR 3D PRINTING



	Supported Walls	Unsupported Walls	Support & Overhangs	Embossed & Engraved Details	Horizontal Bridges	Holes		Escape Holes	Minimum Features	Tolerance	Pin Diameter
		connected to the		model that are		diameter a technol-	The recommended clearance between 2 moving or connecting parts.	diameter of escape	feature to ensure it	The state of the s	The minimum diameter a pin can be printed at.
Fused Deposition Modeling	1mm	1mm	45°	0.6mm wide & 2mm high	10mm	Ø2mm	0.2mm		2mm	±0.2mm	3mm
Stereo- lithography	1mm	1mm	support always required	0.1mm wide & high		Ø0.5mm	0.5mm for moving parts & 0.2mm for connections	5mm	0.2mm	±0.1mm for 25mm then 0.05mm per 25mm after	0.5mm
Selective Laser Sintering	0.7mm	0.7mm		0.5mm wide & high		Ø1.5mm	0.5mm for moving parts & 0.2mm for connections	3.5mm	0.5mm	±0.3% lower limit ±0.2mm	1mm
Binder Jetting	2mm	3mm		0.4mm wide & high		Ø2mm		10mm	2mm	±0.2mm	3mm
Material Jetting		0.5mm	support always required	0.2mm wide & high		Ø0.5mm	0.5mm for moving parts & 0.2mm for connections		0.2mm	±0.1mm	0.5mm
Direct Metal Laser Sintering	0.4mm		45°	0.1mm wide & high		Ø0.5mm- Ø6mm	0.5mm for moving parts & 0.2mm for connections	2mm	0.25mm	±0.1mm	1mm