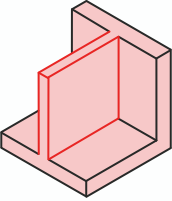
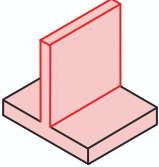
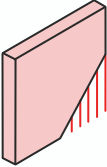
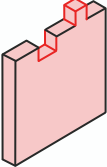
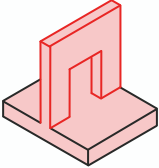
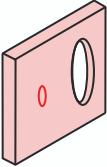
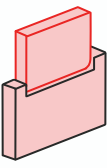
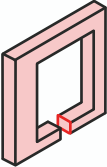
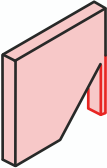
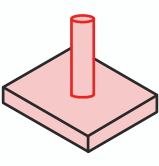


		Laser Sintering	Multi Jet Fusion	Stereo-lithography	Digital Light Processing*	Hybrid PhotoSynthesis	Fused Filament Fabrication	Material Jetting
	Supported Walls Minimum thickness of wall section connected to rest of part on two sides.	0.028 in	0.02 in	0.02 in	Rigid: 0.008 in Flexible: 0.04 in	0.02 in	0.03 in	0.04 in
	Unsupported Walls Minimum thickness of wall section that is connected to part on the base only, or to one other wall.	Supports not required	Supports not required	0.04 in	Rigid: 0.012 in Flexible: 0.098 in	0.04 in	0.03 in	0.04 in
	Supports & Overhangs Minimum angle (measured from print platform) at which a wall can be printed before additional support is necessary.	Supports not required	Supports not required	Base Support Otherwise 45°	Rigid: 25° Flexible: 45°	Base Support Otherwise 45°	45°	Supports always required
	Embossing & Engraving Minimum dimensions of embossed or engraved features upon the object surface.	Width: 0.04 in Height/Depth: 0.04 in	Width: 0.04 in Height/Depth: 0.04 in	Width: 0.016 in Height/Depth: 0.016 in	Rigid: W: 0.008 in H/D: 0.004 in Flexible: W: 0.035 in H/D: 0.02 in	Width: 0.016 in Height/Depth: 0.016 in	Width: 0.024 in Height/Depth: 0.079 in	Width: 0.02 in Height/Depth: 0.02 in
	Horizontal Spans Maximum distance between supporting structures that a surface can traverse without additional support.	Supports not required	Supports not required	0.08 in	Rigid: 0.12 in Flexible: 0.04 in	0.08 in	0.4 in	Supports always required
	Holes & Openings Minimum diameter opening for successful build.	0.02 in	0.02 in	0.02 in	Rigid: 0.008 in Flexible: 0.035 in	0.02 in	0.04 in	0.02 in
	Connecting & Moving Parts Recommended minimum clearance for moving parts or connected assemblies printed in place.	Moving: 0.012 in Connecting: 0.006 in	Moving: 0.012 in Connecting: 0.006 in	0.03 in	Rigid: 0.01 in Flexible: 0.03 in	0.03 in	0.008 in	0.008 in
	Escape Holes Minimum diameter of an opening that can allow material and powder to be removed.	0.04 in	0.04 in	0.04 in	0.04 in	0.04 in	0.04 in	0.04 in
	Minimum Features The smallest size feature on a part for successful build.	0.03 in	0.03 in	0.008 in	Rigid: 0.004 in Flexible: 0.04 in	0.008 in	0.08 in	0.02 in
	Pin Diameter Minimum recommended diameter of small spire features.	0.02 in	0.03 in	0.03 in	Rigid: 0.004 in Flexible: 0.04 in	0.03 in	0.04 in	0.02 in

*Variable depending on material used.
**All tolerances listed are "best case" scenarios.

