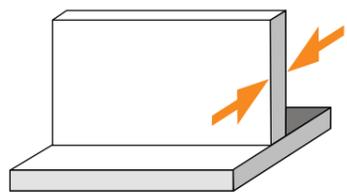
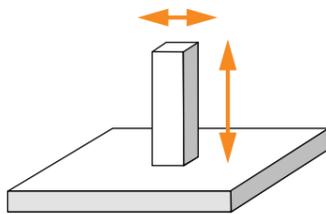


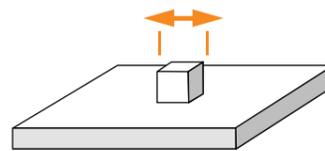
Design rules for metal 3D printing



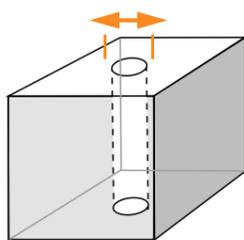
Wall strength
0.3 – 0.5mm



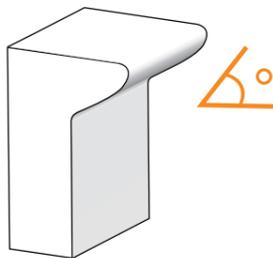
Aspect ratio
8:1



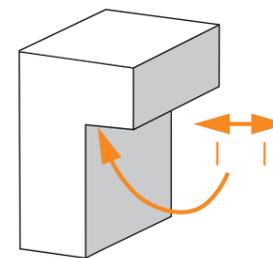
The minimum detail size
0.2 – 0.5mm



Hole size
Ø 1mm

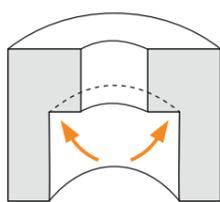


Building angle
40° – 45°

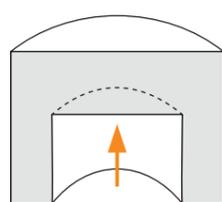


Unsupported structure
0.5mm

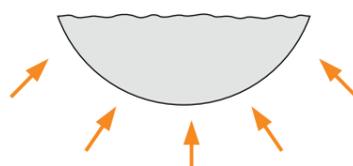
Avoid when possible:



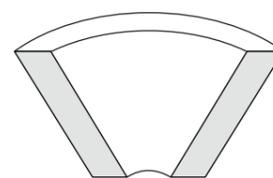
Underneath shoulders
(internal)



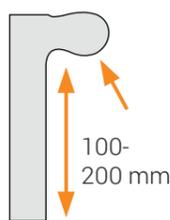
Lids



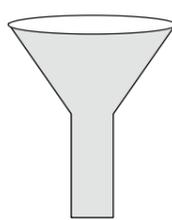
Curved undersides



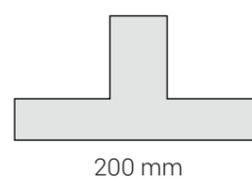
Outward-growing shapes
(in all directions)



Overhangs high up
(long supports)

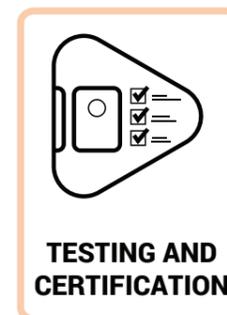
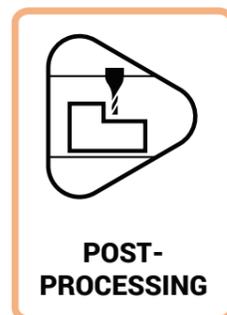
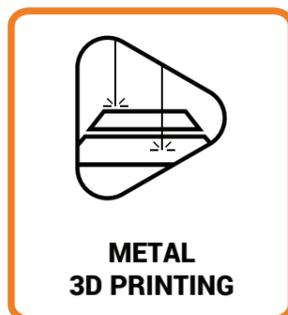
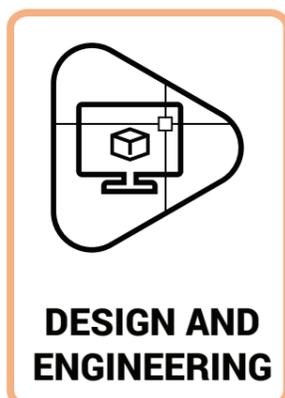


Large masses on top of thin forms



Large flat surfaces
(against the build platform)

Delva as a partner



Delva Oy
Laajamäentie 2
13430 HÄMEENLINNA
FINLAND

+358 50 314 3487
info@delva.fi
www.delva.fi

