



Design guidelines

Multi jet fusion (MJF)

File format

STL, STEP

Wall thickness

Recommended minimum wall thickness of major supported wall is 1 mm. Larger parts require greater thickness or added ribs/web.

Embossed details

Recommended to be at least 1 mm in height with a minimum line thickness of 0.5 mm.

Engraved details

Recommended to be at least 1 mm in depth with a minimum line thickness of 0.5 mm.

Drain hole

Have at least two drain holes with a minimum diameter of 2 mm when the model is hollowed out.

Assembled parts

Assembled parts need a minimum clearance of 0.4 mm (0.2 mm clearance from each part, parts printed separated and mounted afterwards).

Interlocking parts

When you print parts that are interlocked with others in a single build, you need to create a minimum clearance of 0.5 mm.

Lattice structures

When using lattice structures to reduce weight and the quantity of material, you need a minimum gap of 1 mm in the structure.

Accuracy

+/- 0.3% with lower limit of +/- 0.2 mm.

Hollow out your model

Hollow out your model to save agent and material powder and to prevent sink marks. Don't forget the drain holes to make it possible to empty out the unfused powder from inside the model. The shell should ideally be 2-3 mm thick when printing hollowed-out models.

Warping

Bear in mind that large, flat plains are hard to print on an MJF printer. These models usually deform.