



Design guidelines

Polyjet Technology

File format

VRML for model with texture, STL for one material/color. STL assembly for multi-material model.

Wall thickness

The minimum wall thickness for major supported walls is 1 mm, and all other walls should not be thinner than 0.7 mm.

Model with texture, recommended with a wall thickness of 3 mm.

Pin diameter

Minimum 0.5 mm thickness.

Hole size

Minimum hole diameter 0.5 mm.

Embossed details

Minimum height 0.5 mm, minimum line thickness 0.8 mm.

Engraved details

Minimum depth 0.5 mm, minimum line thickness 0.5 mm.

Assembled parts

Assembled parts need a clearance of 0.6 mm around all sides to ensure they will fit together. (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 0.4 mm.

Accuracy

+/- 0.1 - 0.3 mm depending on the size of the model, geometry and the chosen material.

Hollow out your model

Hollow out your model to save on material costs. Make sure the mesh is closed, otherwise there is a risk that the support material will expand and break the model.

If the mesh isn't closed, create escape holes to get rid of the support material and prevent expansion; this will also give you a lighter model.

Matte or glossy?

You can choose between two different finishes on your model when printing with Polyjet technology.

Matte - The whole model is given a uniform, matte surface. Requires support around the whole object.

Glossy - The surface oriented upright in relation to the build platform is given a shiny finish, while the rest of the model is matte.

Multi-material models

To print a model using multiple materials, you need to create a model separated into shells/an assembly (one shell for each type of material). When printing a multi-material model, you need to run a boolean tool before exporting the STLs for printing. The boolean tool subtracts, adds and intersects between the objects to make sure the parts don't overlap. If the parts overlap, there is a great risk that the printed model will fail.