



Component size with ABS and PEI > max. 914 x 609 x 914 [mm] / 36" x 24" x 36" [inch]

Component size with PC > max. 406 x 355 x 406 [mm] / 16" x 14" x 16" [inch]

With large components, the **option of manufacturing single parts** and join them together is possible.

Tolerance according to DIN ISO 2768c

Tolerance Class		Measuring limits for the rated dimensions limits (value in mm)					
Symbol	rough	from 0,5 to 3	over 3 to 6	over 6 to 30	over 30 to 120	over 120 to 400	over 400 to 1000
c	rough	+/- 0,2	+/- 0,3	+/- 0,5	+/- 0,8	+/- 1,2	+/- 2

Following materials are available:

ABS-M30 (P430 ABS), PC (Polycarbonate), PEI (Ultem 9085)

ABS colour: natural, black (optional also white, grey, red and blue)

PC colour: white, black

PEI colour: ivory, black

Properties		
ABS-M30	PC	PEI
<ul style="list-style-type: none"> > good chemical resistance > high impact and notch impact resistance 	<ul style="list-style-type: none"> > good mechanical strength value 	<ul style="list-style-type: none"> > high mechanical property > aviation authorized in accordance to FAR 25.853 and ABD0031 > high thermal stability

Possible layer thickness for each material:

ABS-M30: 0.127 mm, 0.178 mm, 0.254 mm, 0.330 mm

PC: 0.178 mm, 0.254 mm, 0.330 mm

Ultem 9085: 0.254 mm, 0.330 mm

File format for the FDM-Software: STL, iges, vda, step, catiaV4, catiaV5, unigraphics, acis, parasolid.