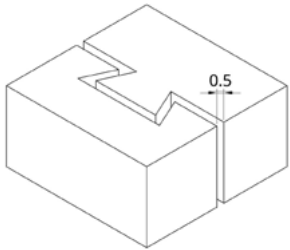
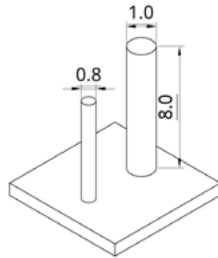


Precious Metal Additive Manufacturing Design Guidelines



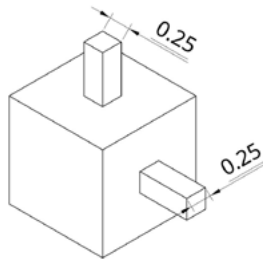
Clearance

Minimum distance between separate parts **0.5mm**



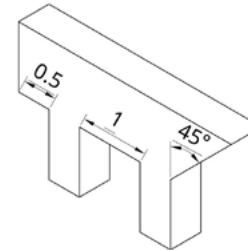
Freestanding Pins

Minimum diameter **0.8mm**
Minimum h:Ø ratio **8:1**



Minimum Feature Size

Smallest printable feature **0.25mm**

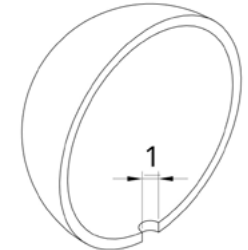


Overhangs

Maximum angle of overhang before a surface needs support **45°**

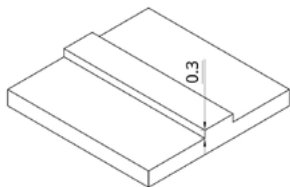
Unsupported Overhangs

Overhangs more than 45° do not need support up to 0.5mm out from a supporting surface. Unsupported bridges between supporting surfaces can be up to 1mm long



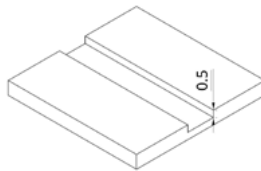
Powder Escape

Minimum diameter of hole for powder to escape from hollow part **1.0mm**



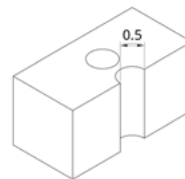
Raised Details

Minimum height of raised details on horizontal surface **0.3mm**



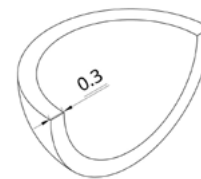
Recessed Details

Minimum depth of recessed details on horizontal surface **0.5mm**



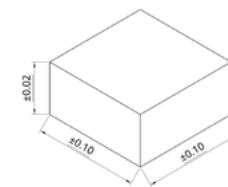
Vertical Holes

Minimum diameter for vertical holes **0.5mm**



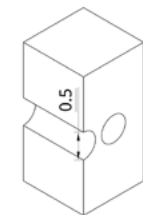
Wall Thickness

Minimum recommended wall thickness **0.3mm**



XYZ Tolerance

X & Y print tolerance **0.1mm**
Z resolution **0.02mm**



Horizontal Holes

Maximum diameter for unsupported tunnel **0.5mm**